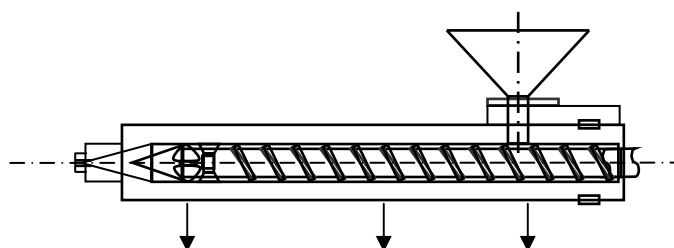


Processing Guides for WONDERLITE® PC-110U

- A Pre-drying 120°C x 4 hrs
depending on
- a) Humidity
 - b) Storage conditions
 - c) Dryer's performance

B. Barrel Setting Profile



Grade / Application		Nozzle	Compression zone	Feeding zone	Mold Temperature *
PC-110U	max.(°C)	310	320	300	70 -120
	min.(°C)	250	250	230	

- * varying with
- a) Thickness of molded articles
 - b) Cooling system design
 - c) Gate and runner system

NOTE :

1. Keep the resin from dust and contamination during handling and production.
2. Do not retain the hot melt at the barrel for a long time between injection cycles.
3. Temperature setting of manifold system should not exceed 330°C to avoid melt from degrading.

■ **Purging :**

Heat decomposing resins are not recommended for purging the residual WONDERLITE® and WONDERLOY® in barrel of injection machine and extruder. Polyethylene and polypropylene are the most commonly used heat stable resins for purging purpose.

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