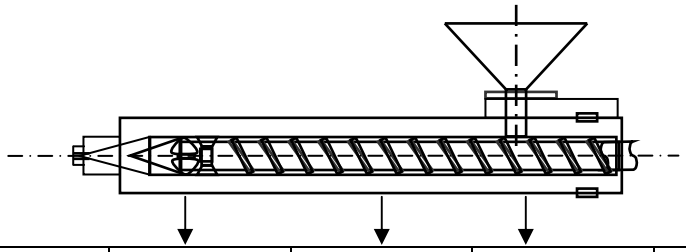
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Processing Guides for WONDERLITE® PC-6600

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-6600	**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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