

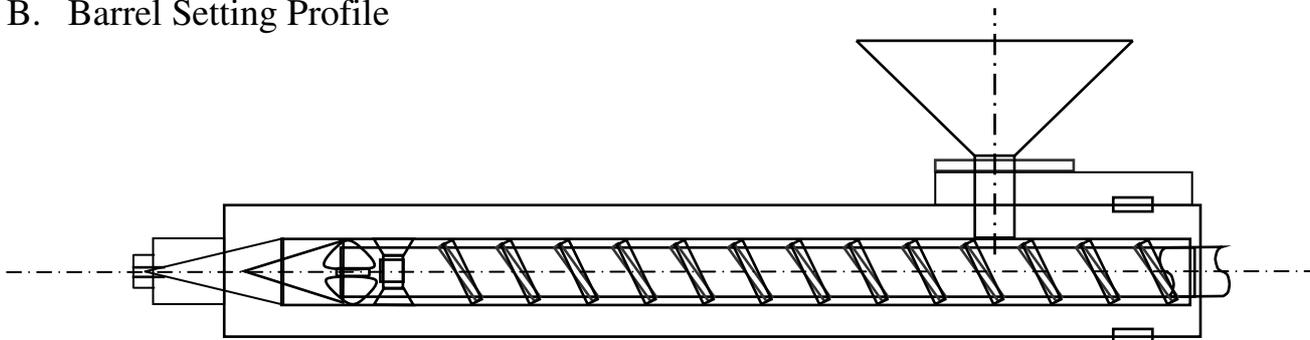
General Purpose SAN, KIBISAN[®] PN-117C

Processing Conditions

A Pre-drying 75~80 °C x 3~4 hrs

- depending on
- a) Humidity
 - b) Ratio of reground resin
 - c) Storage conditions

B. Barrel Setting Profile



MAX(°C)	210	200
MIN(°C)	180	170

C. Mold Temperature 40~60 °C

- depending on
- a) Thickness
 - b) Dimension
 - c) Gate and runner system

D. Injection Pressure 50~70 kg/cm²
 Holding Pressure 40~60 kg/cm²
 Back Pressure 5~15 kg/cm²

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 220 °C to avoid melt from degrading.

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