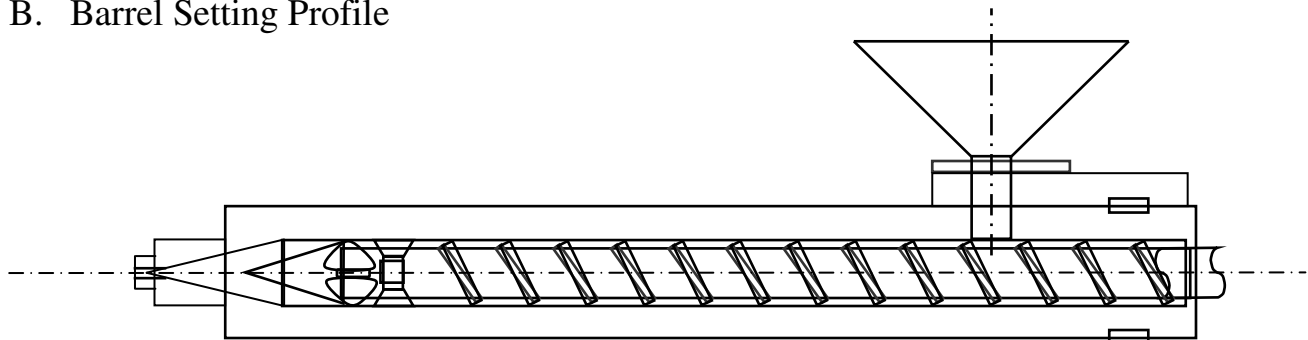


## General Purpose ABS, POLYLAC<sup>®</sup> PA-757G J08(Black)

### Processing Conditions

- A Pre-drying 80 ~ 85 °C x 3 ~ 4 hrs  
depending on   a) Humidity  
                      b) Ratio of reground resin  
                      c) Storage conditions
- B. Barrel Setting Profile



MAX( °C )	230	230	220
MIN( °C )	190	190	180

- C. Mold Temperature 80 ~ 120 °C  
depending on   a) Thickness  
                      b) Dimension  
                      c) Gate and runner system
- D Injection Pressure       50~60 %  
Holding Pressure       40~50 %  
Back Pressure       5~10 kg/cm<sup>2</sup>

#### 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 250 °C to avoid melt from degrading.

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