CHIMEI 奇美實業股份有限公司 CHI MEI CORPORATION ORIGINAL
59-1, San Chia, Jen Te, Tainan City 71702, Taiwan TEL : (06)2663000 FAX : (06)2665555-7

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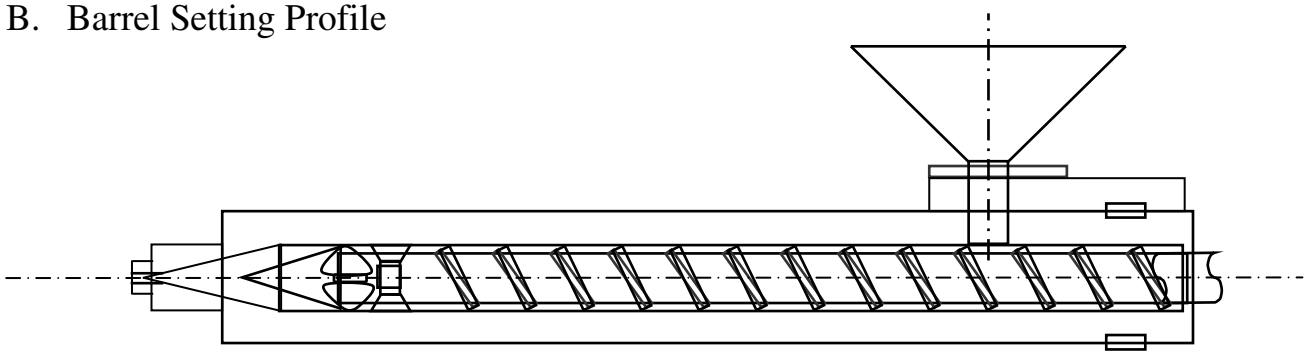
General Purpose MS, ACRYSTEX® PM-600

Processing Conditions :

A Pre-drying 70~80°C x 3~4 hrs

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

B. Barrel Setting Profile



MAX(°C)	240	240	230
MIN(°C)	210	200	180

C. Mold Temperature 40~70 °C

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

D. Injection Pressure 50~70 kg/cm^2
Holding Pressure 40~60 kg/cm^2
Back Pressure 5~15 kg/cm^2

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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