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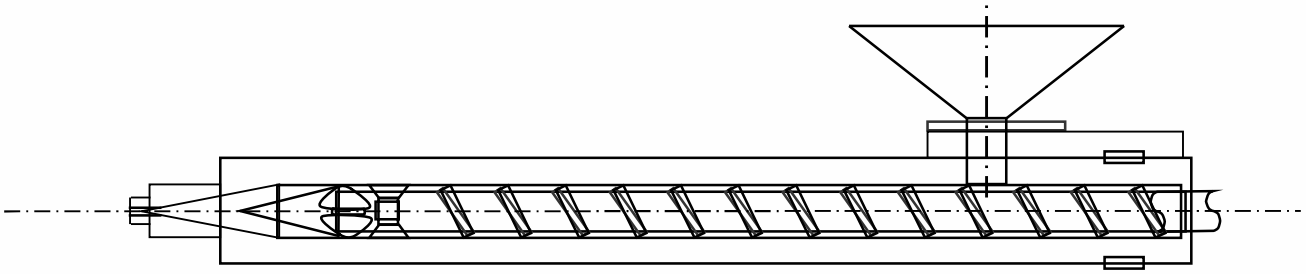
July 22, 2021 V1W

ABS, POLYLAC® PA-746M

Processing Conditions

A Pre-drying 80 ~ 85 ˚C x 2 ~ 3 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 30~60 ˚C
depending on a) Thickness
b) Dimension
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 240°C to avoid melt from degraded.

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