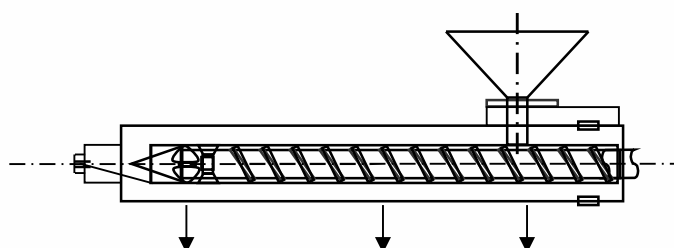


July 22, 2021 VIW

WONDERLITE® PC-145K

- 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-145K | max.(°C) | 300 | 310 | 300 | 70 -120 |
| | min.(°C) | 240 | 240 | 220 | |

- * 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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