CHIMEI
a step up

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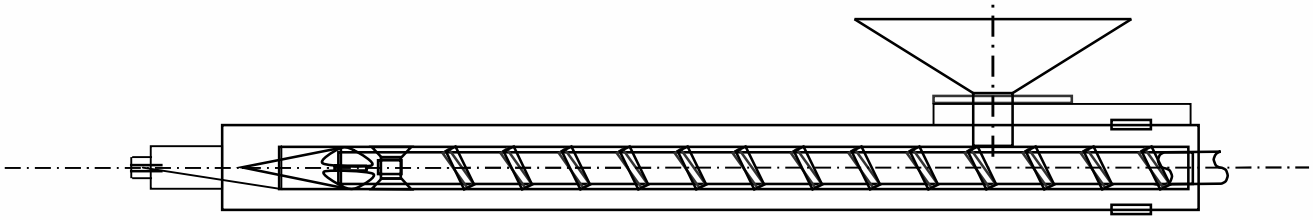
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SAN, KIBISAN® PN-107 L125FG

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	180
MIN(°C)	180	180	160

C. Mold Temperature 40~60 °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 230°C to avoid melt from degrading.
4. To avoid extra chemical residues, please use food contact materials to clean the injection machine while grade changing.

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