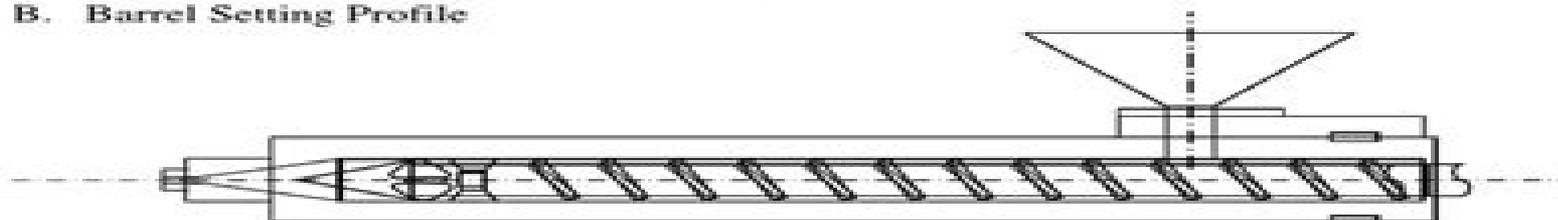


General Purpose ABS, POLYLAC® PA-727

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 30~70 °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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General Purpose Abs Processing Guide

Scott C. Dulebohn



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