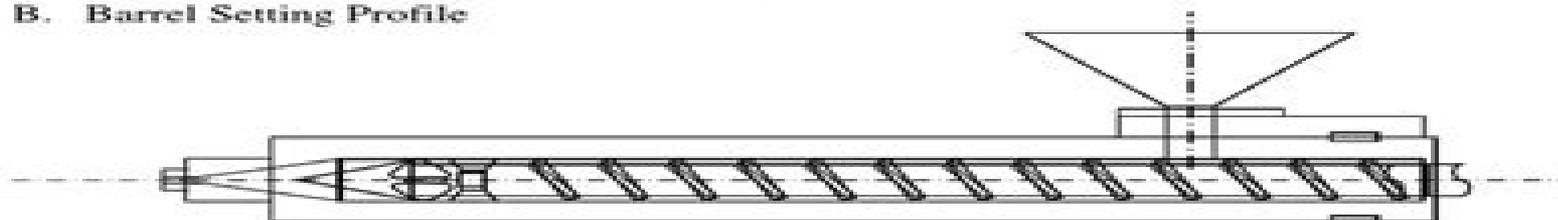


## General Purpose ABS, POLYLAC® PA-727

### 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

**Michael Hoelscher**



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[Engineered Materials Handbook, Desk Edition](#) ASM International. Handbook Committee,1995-11-01 A comprehensive reference on the properties selection processing and applications of the most widely used nonmetallic engineering materials

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