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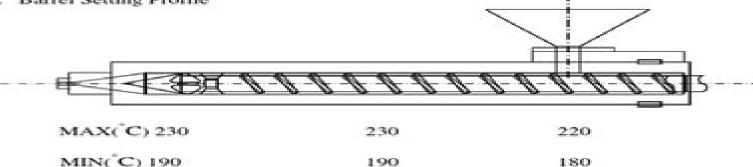
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January 17, 2017 VIW

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



- C. Mold Temperature 30~70 °C
 - depending on
- a) Thickness
- b) Dimension
- c) Gate and runner system

NOTE:

- Keep the resin from dust and contamination during handling and production.
- Do not retain the hot melt at the barrel for a long time between injection cycles.
- Temperature setting of manifold system should not exceed 240°C to avoid melt from degraded.

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