

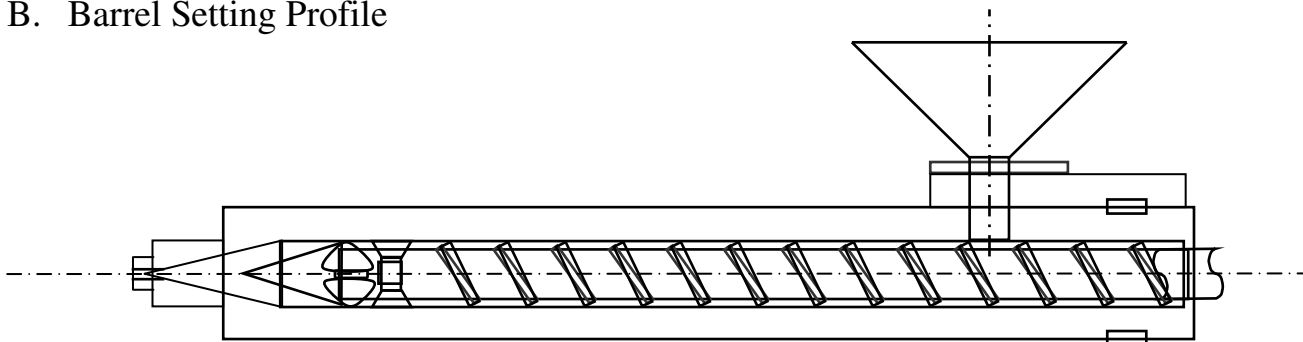
## High Heat ABS, POLYLAC<sup>®</sup> PA-77NB

### Processing Conditions

A Pre-drying 90~95 °C x 3 hrs

- depending on
- a) Humidity
  - b) Ratio of reground resin
  - c) Storage conditions

B. Barrel Setting Profile



MAX( °C)	250	250	240
MIN( °C)	230	230	220

C. Mold Temperature 30~70 °C

- depending on
- a) Thickness
  - b) Dimension
  - c) Gate and runner system

D. Injection Pressure 50~70 kg/cm<sup>2</sup>  
 Holding Pressure 40~60 kg/cm<sup>2</sup>  
 Back Pressure 5~15 kg/cm<sup>2</sup>

#### 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 260 °C to avoid melt from degrading.

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