

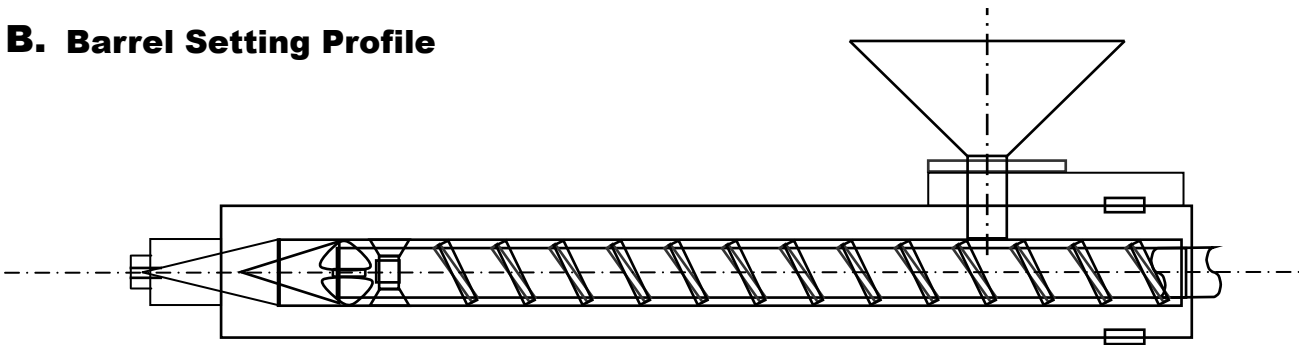
CALSAK CS-42 ABS

Processing Conditions

A Pre-drying 80°C x 2~3 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 50~70 °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 degrading.**