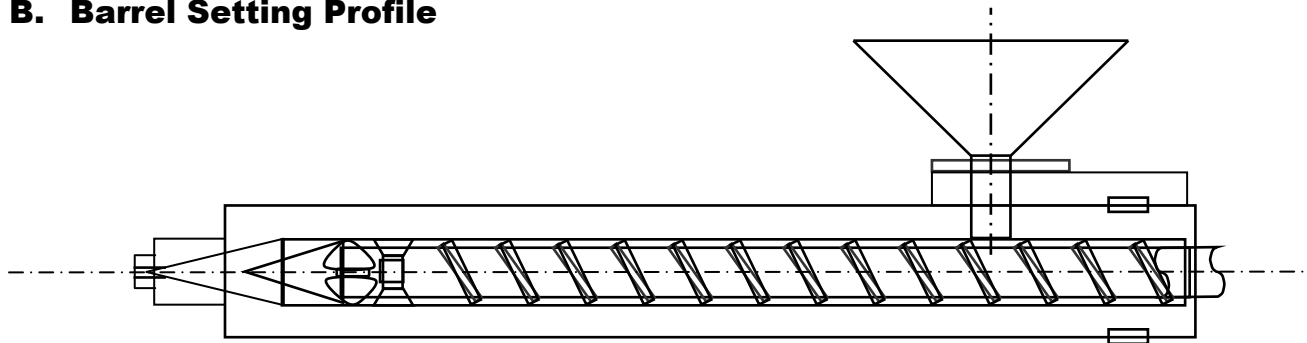


## CALSAK CS-72 ABS

### Processing Conditions

- A. Pre-drying**    **85~90°C x 2~3 hrs**  
depending on    **a) Humidity**  
                         **b) Ratio of reground resin**  
                         **c) Storage conditions**

**B. Barrel Setting Profile**



<b>MAX(°C)</b>	<b>230</b>	<b>230</b>	<b>220</b>
<b>MIN(°C)</b>	<b>190</b>	<b>190</b>	<b>180</b>

- 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 degrading.**