

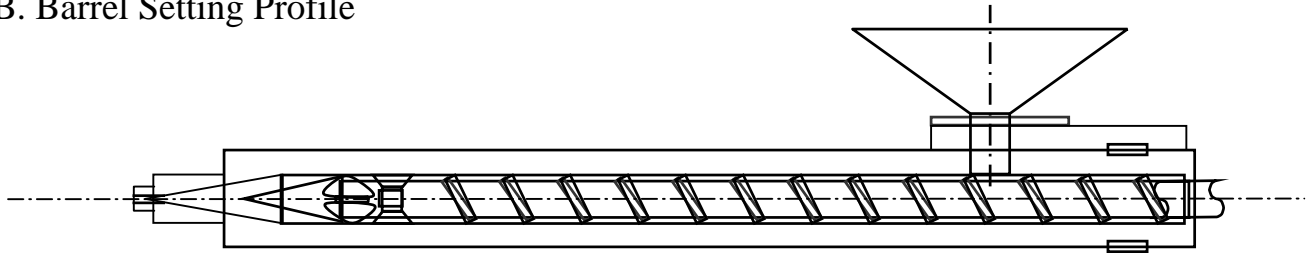


Clear ABS POLYLAC[®] PA-758

Recommended Processing Condition

A Predrying : 85 °C , 3~5 hr
depending on a) Humidity b) Ratio of Regrind c) Storage conditions

B. Barrel Setting Profile



	<u>Metering Zone</u>	<u>Compression Zone</u>	<u>Feeding Zone</u>
Max(°C)	250	250	220
Min(°C)	220	220	200

The suggested processing temperature is 230~240 °C

C. Mold Temperature 50~70 °C

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

D. Injection Pressure 50~80 kg/cm²
 Holding Pressure 20~50 kg/cm²
 Back Pressure 5~10 kg/cm²

E Purging

Purging for shutdown should include complete removal of PA-758 resin with either PA-758 or high flow PMMA(for example, CM-211). The other clear plastics (PS , SAN or the other clear ABS) are not suggested.

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 250 °C to avoid melt from degradation.
4. The manufactured process and the properties may be different among various clear ABS manufactures. Therefore, blending of the different clear ABS is not recommended. The blending of the different clear ABS will influence the properties and light transmission.