



## General Purpose MS, ACRYSTEX<sup>®</sup> PM-600

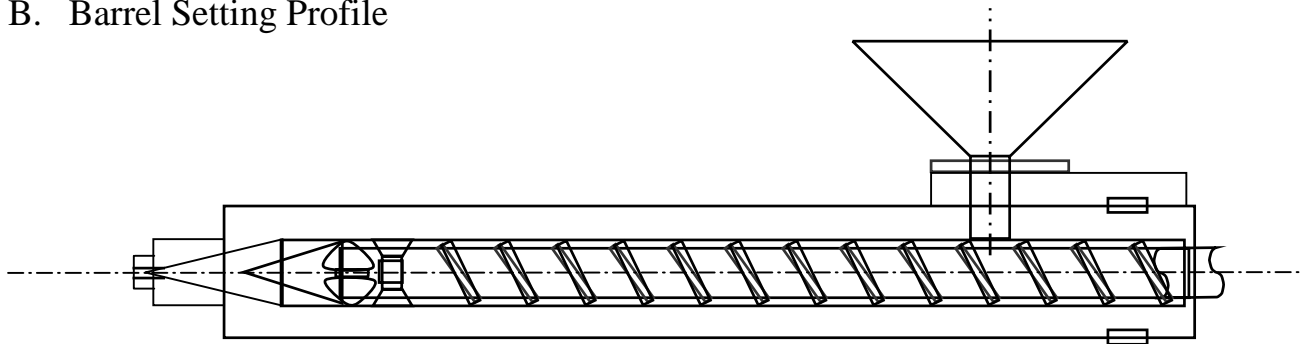
July 2, 2003 VIW

### Processing Conditions :

A Pre-drying 70~80 °C x 3~4 hrs

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

B. Barrel Setting Profile



MAX( °C )	240	240	230
MIN( °C )	210	200	180

C. Mold Temperature 40~70 °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 250 °C to avoid melt from degrading.

For further information, please contact your local agent or fax to Chi Mei Technical Services Dept. at 886-6-2665555