



## General Purpose SAN, KIBISAN<sup>®</sup> PN-117

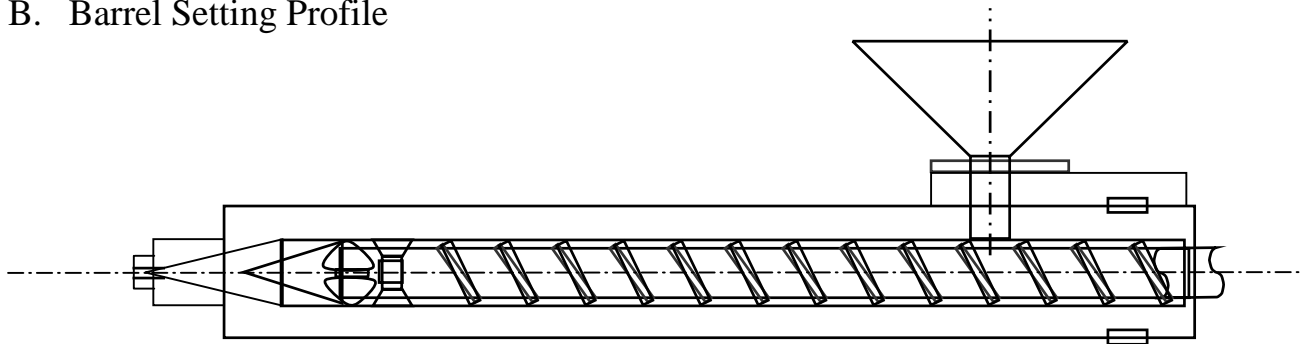
March 30, 2005 V1W

### Processing Conditions : it's for PN-117-L100, L200, and L250

A Pre-drying 75~80 °C x 3~4 hrs

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

B. Barrel Setting Profile



MAX( °C )	220	220	210
MIN( °C )	190	190	180

C. Mold Temperature 40~60 °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 235 °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