



General Purpose SAN, KIBISAN[®] PN-127

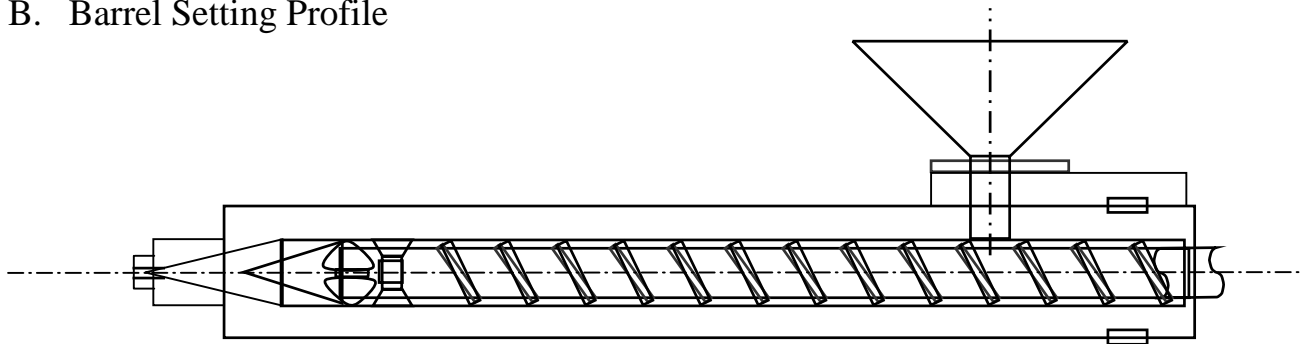
March 30, 2005 VIW

Processing Conditions : it's for PN-127-L100, L150, and L200

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)	200	200	190

C. Mold Temperature 40~60 °C

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

D. Injection Pressure 50~70 kg/cm²
 Holding Pressure 40~60 kg/cm²
 Back Pressure 5~15 kg/cm²

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.

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