

General Purpose ABS, POLYLAC® PA-727

Processing Conditions

- A. Pre-drying 80 – 85°C x 3 – 4 hrs
depending on a) Humidity
b) Ratio of reground resin
c) Storage conditions
- B. Barrel Setting Profile



| | | |
|-------------|-----|-----|
| MAX(°C) 230 | 230 | 220 |
| MIN(°C) 190 | 190 | 180 |

- 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 degraded.

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General Purpose Abs Processing Guide

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[Engineered Materials Handbook, Desk Edition](#) ASM International. Handbook Committee, 1995-11-01 A comprehensive reference on the properties selection processing and applications of the most widely used nonmetallic engineering materials

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Official Gazette of the United States Patent and Trademark Office ,1992

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