



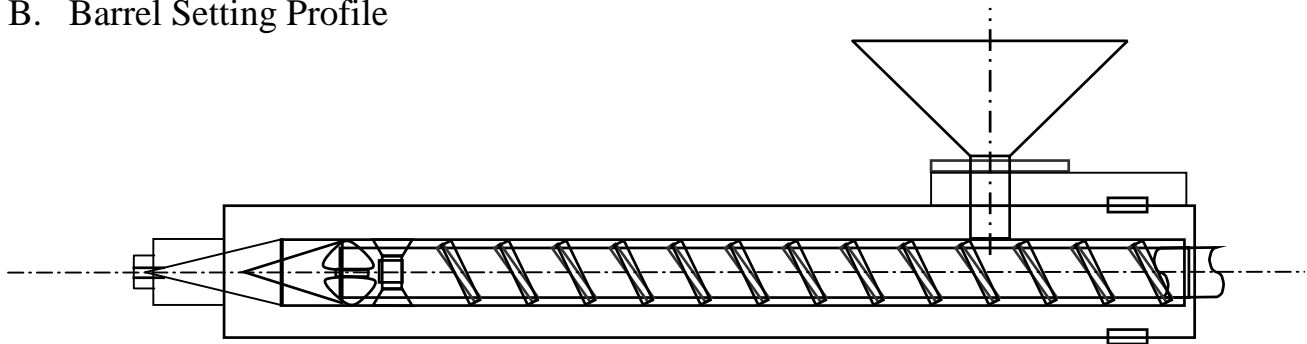
## General Purpose SAN, KIBISAN<sup>®</sup> PN-137H January 22, 2007 VIW

### Processing Conditions

A Pre-drying 80~85 x 3~4 hrs

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

B. Barrel Setting Profile



MAX( )	230	240	230
MIN(°C)	210	220	210

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 250 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