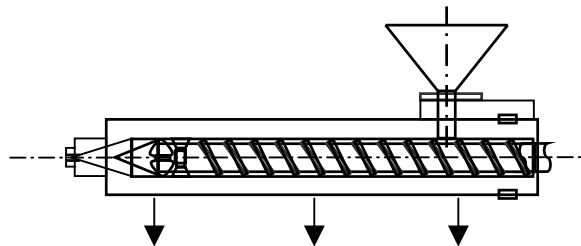




Processing Guides for WONDERLITE® PC-175D

- A Pre-drying 120°C x 4 hrs
 depending on a) Humidity
 b) Storage conditions
 c) Dryer's performance

B. Barrel Setting Profile



Grade / Application		Nozzle	Compression zone	Feeding zone	Mold Temperature *
CD series	max.(°C)	340	345	310	45 - 85
	min.(°C)	270	310	290	
CD-R	max.(°C)	340	355	320	95 - 110
	min.(°C)	270	325	290	
DVD series	max.(°C)	350	385	320	90 - 128
	min.(°C)	270	360	290	

- * varying with a) Thickness between mold surface and cooling channels
 b) Cooling system design
 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. For DVD injection, temperature setting of manifold system should not exceed 385°C to avoid melt from degrading.

For further information, please contact your local agent or fax to CHIMEI-ASAHI Technical Services Dept. at 886-6-2667983/2667984