

Molding of TOYOLAC 900 Series (Toyolac™ 900, Toyolac™ 920, Toyolac™ 930)

The molding results used with general ABS resins can also be applied to transparent ABS resin.

(1) Pre-drying

It is recommended that pre-drying be conducted in ovens for 2-3 hours at 80°C.

(2) Injection molding

As with general ABS resin, the injection molding conditions for Toyolac 900, 920, and 930 resins vary slightly depending on the types of molding machine and the shape of the molded product.

As these grades have good flow properties, they can be molded easily with an ordinary injection molding machine.

Lower molding temperatures are preferred as higher temperatures cause the molding to turn yellow.

Typical molding conditions are as follows:

Cylinder temperature: 200 - 230 ° C

Injection pressure: 500 - 1,500 kg/cm²

Mold temperature: 50 - 70° c

(3) Extrusion molding

The flow properties of Toyolac 900, 920 and 930 are similar to those of Toyolac 600 (standard extrusion grade).

Thus, extrusion molding can be conducted very easily.

No specific problems are associated with the molding of Toyolac 900, 920 and 930 except that the molding temperature must not rise too high and the extrusion molding machine must be completely clean as mixing with other resins affects transparency.