

## 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

**J Elliott**



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