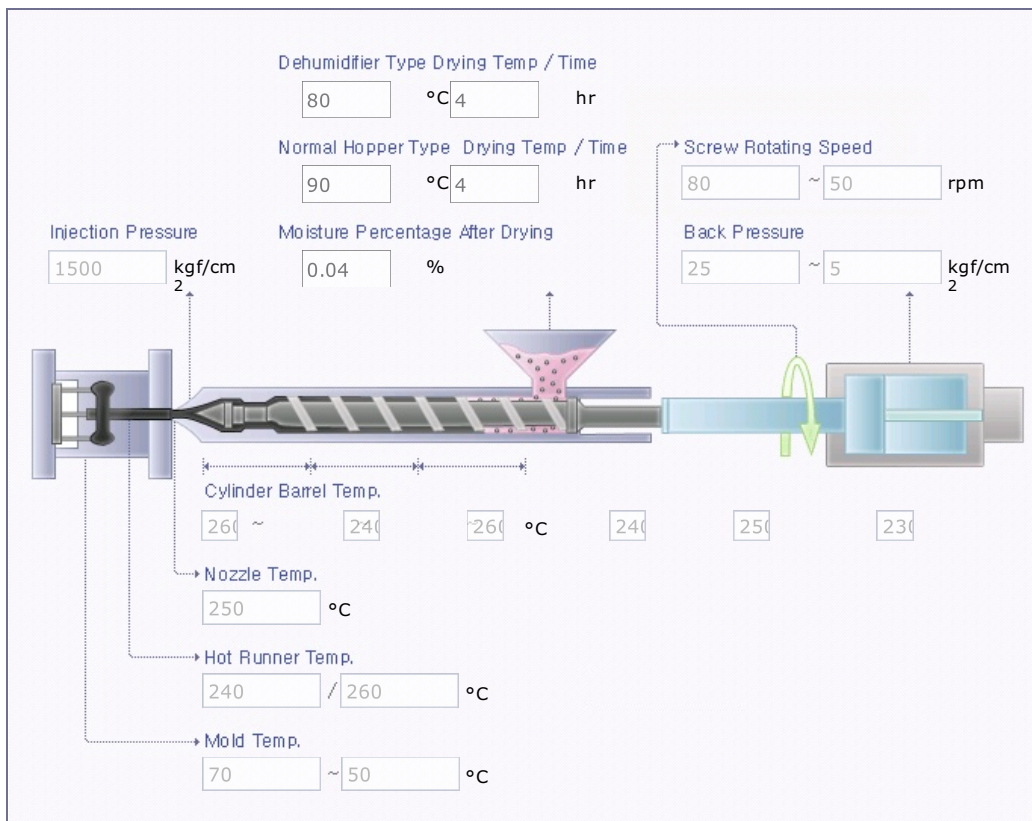


Processing Guide

INFINO.

Grade	WP-1069
Resin Type	PC/ABS

Processing Guide Diagram



Item		Unit	Representative	
Mold Temp.(Standard Molding)	Stationary Platen	°C	70	
	Moving Platen		50	
Hot Runner Temp.	Manifolder	°C	240	
	Valve Nozzl		260	
Nozzle Temp.		°C	250	
Cylinder Barrel Temp.	NH (Nozzle Heater)	°C	260	
	H1		240	
	H2		260	
	H3		240	
	H4		250	
	H5		230	
Injection Pressure		kgf/cm ²	1500	
Drying Condition	Dehumidifier Type	Drying Temp	°C	80
		Drying Time	hr	4
	Normal Hopper Type	Drying Temp	°C	90
		Drying Time	hr	4
Moisture Percentage After Drying		%	0.04	
Screw Rotating Speed		rpm	80	
		rpm	50	
Back Pressure		kgf/cm ²	25	
		kgf/cm ²	5	

1. The value above is the representative value of the NP standard and may have deviation. It can only be used for selecting materials.
2. The value above shall not be regarded as a material specification and cannot be used for molding designs.

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