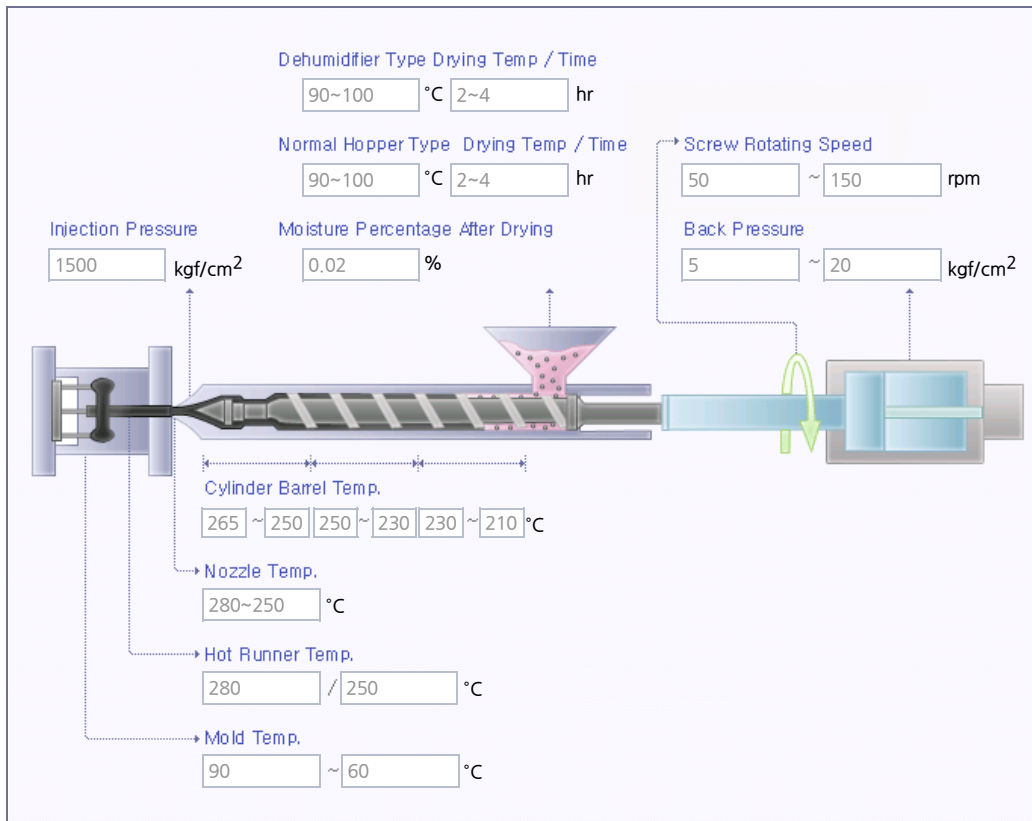


Processing Guide | LOTTE Advanced Materials

<b>INFINO</b>	Grade	WP-1069
	Resin Type	PC/ABS

Processing Guide Diagram



Item		Unit	Representative	
Mold Temp. (Standard Molding)	Stationary Platen	°C	90	
	Moving Platen		60	
Hot Runner Temp.	Manifolder	°C	280	
	Valve Nozzl		250	
Nozzle Temp.		°C	280~250	
Cylinder Barrel Temp.	Beginning part	°C	265 ~ 250	
	Middle part		250 ~ 230	
	End part		230 ~ 210	
Injection Pressure		kgf/cm <sup>2</sup>	1500	
Drying Condition	Dehumidifier Type	Drying Temp	°C	90~100
		Drying Time	hr	2~4
	Normal Hopper Type	Drying Temp	°C	90~100
		Drying Time	hr	2~4
Moisture Percentage After Drying		%	0.02	
Screw Rotating Speed		rpm	50	
		rpm	150	
Back Pressure		kgf/cm <sup>2</sup>	5	
		kgf/cm <sup>2</sup>	20	

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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\* Last update date : 09/02/2016