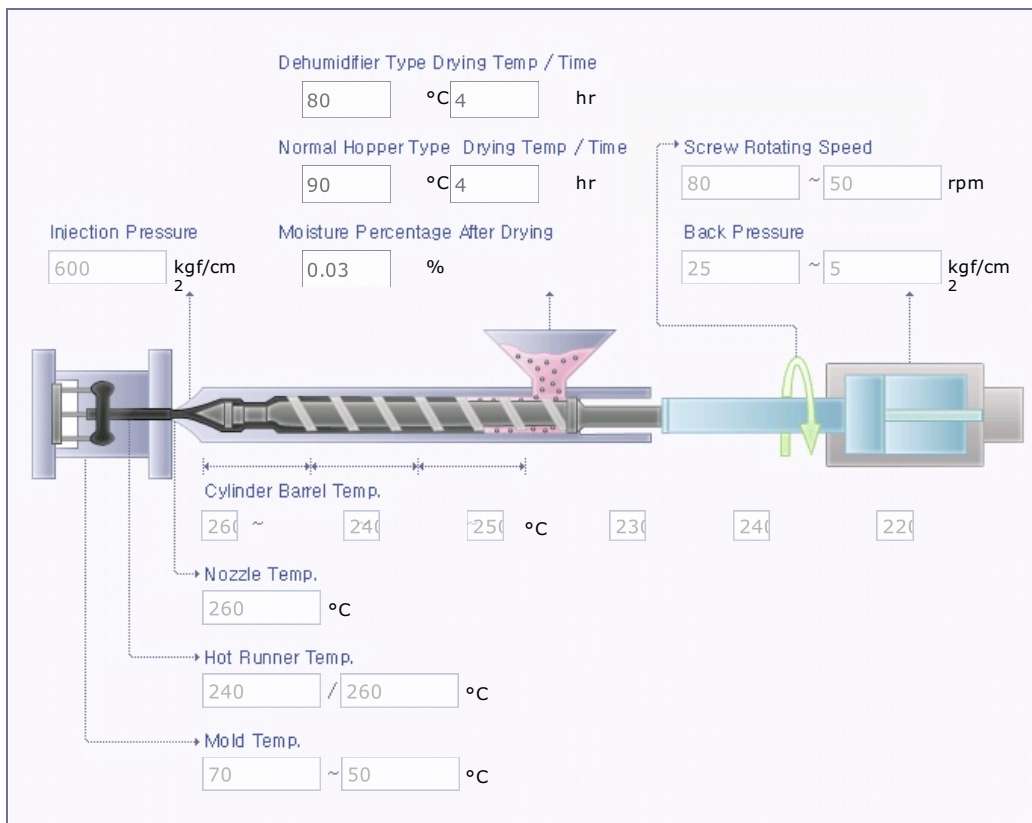


Processing Guide

INFINO.	Grade	WP-1089
	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	260	
Cylinder Barrel Temp.	NH (Nozzle Heater)	°C	260	
	H1		240	
	H2		250	
	H3		230	
	H4		240	
	H5		220	
Injection Pressure		kgf/cm ²	600	
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		%	0.03	
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.

Information inserted in this document such as data, statements, representative values, etc. are provided solely for customer convenience. It does not expressly or impliedly guarantee anything regarding the safety or practicability of the (1) materials, (2) products, and/or (3) design that utilizes recommendations or proposals, of Cheil Industries. Furthermore, nothing in the contents of this document shall have any legal binding effect, and especially, the representative value is simply for reference and is not a minimum value that has legal binding effect. Whether materials and/or products of Cheil Industries and/or a design that uses or utilizes Cheil Industries's recommendations or proposals are (is) compatible with individual uses shall be determined solely by each user and such user shall be solely responsible for any results, including but not limited to, any and all loss and damages incurred due to such uses. Users must implement and verify all testing and analyses for proving the safety and compatibility of final products that have been created or altered by using Cheil Industries's materials or products. The data and values inserted and/or contained in this document may be changed due to quality improvement of the product without any prior notification.

* Last update date : 02/25/2014

© 2010 Cheil Industries Company. All rights reserved.