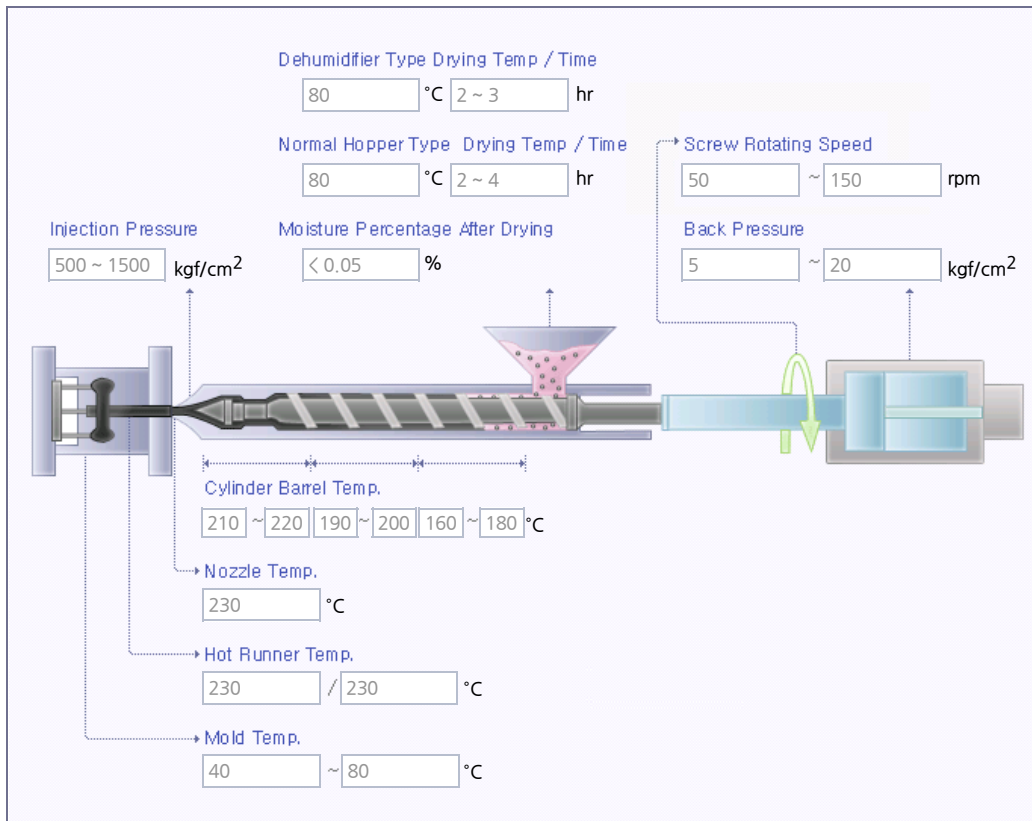


Processing Guide | LOTTE Advanced Materials

starex	Grade	SD-0150 W
	Resin Type	ABS

Processing Guide Diagram



Item		Unit	Representative	
Mold Temp. (Standard Molding)	Stationary Platen	°C	40	
	Moving Platen		80	
Hot Runner Temp.	Manifolder	°C	230	
	Valve Nozzl		230	
Nozzle Temp.		°C	230	
Cylinder Barrel Temp.	Beginning part	°C	210 ~ 220	
	Middle part		190 ~ 200	
	End part		160 ~ 180	
Injection Pressure		kgf/cm ²	500 ~ 1500	
Drying Condition	Dehumidifier Type	Drying Temp	°C	80
		Drying Time	hr	2 ~ 3
	Normal Hopper Type	Drying Temp	°C	80
		Drying Time	hr	2 ~ 4
Moisture Percentage After Drying		%	< 0.05	
Screw Rotating Speed		rpm	50	
		rpm	150	
Back Pressure		kgf/cm ²	5	
		kgf/cm ²	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.

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 LOTTE Advanced Materials. 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 LOTTE Advanced Materials and/or a design that uses or utilizes LOTTE Advanced Materials' 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 LOTTE Advanced Materials' 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 : 09/22/2017