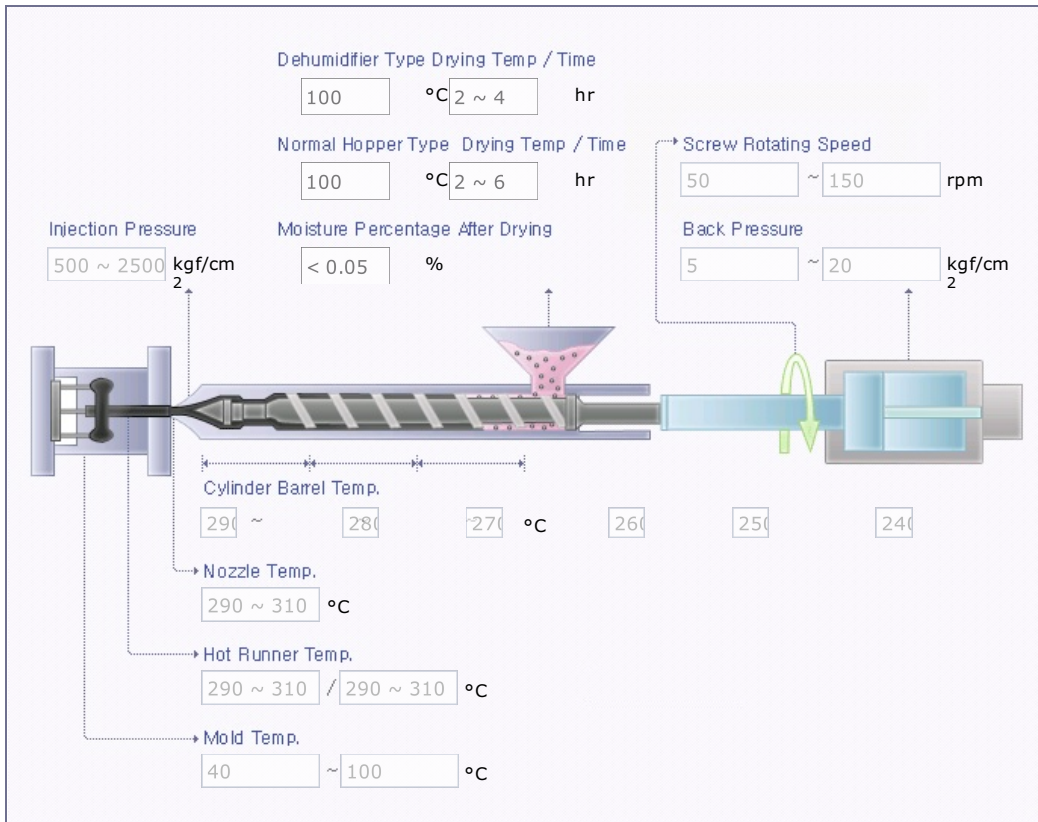


Processing Guide

INFINO.

Grade	FD-1112
Resin Type	PC

Processing Guide Diagram



Item		Unit	Representative	
Mold Temp.(Standard Molding)	Stationary Platen	°C	40	
	Moving Platen		100	
Hot Runner Temp.	Manifolder	°C	290 ~ 310	
	Valve Nozzl		290 ~ 310	
Nozzle Temp.		°C	290 ~ 310	
Cylinder Barrel Temp.	NH (Nozzle Heater)	°C	290 ~ 310	
	H1		280 ~ 300	
	H2		270	
	H3		260	
	H4		250	
	H5		240	
Injection Pressure		kgf/cm ²	500 ~ 2500	
Drying Condition	Dehumidifier Type	Drying Temp	°C	100
		Drying Time	hr	2 ~ 4
	Normal Hopper Type	Drying Temp	°C	100
		Drying Time	hr	2 ~ 6
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.

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