

## PC/ABS RESIN PROCESSING CONDITIONS

Grade	Extrusion Grade	
	AC2190 AC2108 AC25BM	AC3208
Pre-drying Temp.(°C)	100~110	80~90
Pre-drying time(hr)	3~4	3~4
Screw Temp.(°C)	200~260	200~250
Die Temp.(°C)	210~260	210~250

NOTE :

1. Keep the resin from dust and contamination during handling and production.
2. Do not retain the hot melt at the barrel for a long time between injection cycles.
3. Temperature setting of manifold system should not exceed 260°C to avoid melt from degraded.
4. These data only a general information to the best of our knowledge. It can not be guaranteed due to variance of materials, conditions and equipments.



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