1. 烘料條件  
120℃ x 4~8 hrs  
成型前膠粒需充分乾燥，水份的殘留可能會造成產品銀紋或物性的衰退。避免色口變化乾燥時間需控制12小時以內。

2. 射出溫度參數

<table>
<thead>
<tr>
<th>模溫 (℃)</th>
<th>前段 (射嘴)</th>
<th>中段 (壓縮混煉段)</th>
<th>後段 (入料段)</th>
</tr>
</thead>
<tbody>
<tr>
<td>70-100</td>
<td>260-320</td>
<td>260-320</td>
<td>250-290</td>
</tr>
</tbody>
</table>

* 成型變動因素
  a) 產品尺寸厚薄
  b) 成型冷卻(週期)的規劃
  c) 模具澆口、澆道、排氣的規劃設計

注意事項
1. 加工生產前、中、後需避免材料、設備與產品受到汙染
2. 適當的成型週期設定，避免材料於高溫料管中停留太久
3. 避免造成材料劣解，射出溫度建議不可超過330℃。

■ 清車注意事項(螺桿套筒)：
1. 不建議使用熱分解樹脂清除料管中的殘留TAIRILITE® 樹脂
2. 聚乙烯和聚丙烯是用於清洗目的用最常用的熱穩定樹脂

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1. 烘料条件
120℃ x 4~8 hrs
成型前胶粒需充分干燥，水份的残留可能会造成产品银纹或物性的衰退。
避免色口变化干燥时间需控制12小时以内。

2. 射出温度参数

<table>
<thead>
<tr>
<th>模温</th>
<th>前段 (射嘴)</th>
<th>中段 (压缩混炼段)</th>
<th>后段 (入料段)</th>
</tr>
</thead>
<tbody>
<tr>
<td>70-100</td>
<td>260-320</td>
<td>260-320</td>
<td>250-290</td>
</tr>
</tbody>
</table>

*成型变动因素
a) 产品尺寸厚薄
b) 成型冷却(周期)的规划
c) 模具浇口、浇道、排气的规划设计

注意事项
1. 加工生产前、中、后需避免材料、设备与产品受到污染
2. 适当的成型周期设定，避免材料于高温料管中停留太久
3. 避免造成材料劣解，射出温度建议不可超过330℃。

■ 清车注意事项(螺杆套筒)：
1. 不建议使用热分解树脂清除料管中的残留TAIRILITE®树脂
2. 聚乙烯和聚丙烯是用于清洗目的用最常用的热稳定树脂

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Processing Guides for TAIRILITE® AC383(x)

1. Pre-drying  
   **120°C x 4~8 hrs**
   Sufficiently dried. Residual moisture may cause silver streaks or physical property decline. Avoid changing the color tone, the drying time should be controlled within 12 hours.

2. Barrel Setting Pr

<table>
<thead>
<tr>
<th>Mold Temp.</th>
<th>Front-Zone (Nozzle)</th>
<th>Middle-Zone (Compression)</th>
<th>Rear-Zone (Feeding)</th>
</tr>
</thead>
<tbody>
<tr>
<td>70-100</td>
<td>260-320</td>
<td>260-320</td>
<td>250-290</td>
</tr>
</tbody>
</table>

* varying with
  a) Thickness of molded articles
  b) Cooling system design
  c) Gate and runner system

**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. To avoid melt from degrading, Temperature setting of manifold system should not exceed **330°C**.

**Purging:**
Heat decomposing resins are not recommended for purging the residual TAIRILITE® in barrel of injection machine and extruder. Polyethylene and polypropylene are the most commonly used heat stable resins for purging purpose.

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