

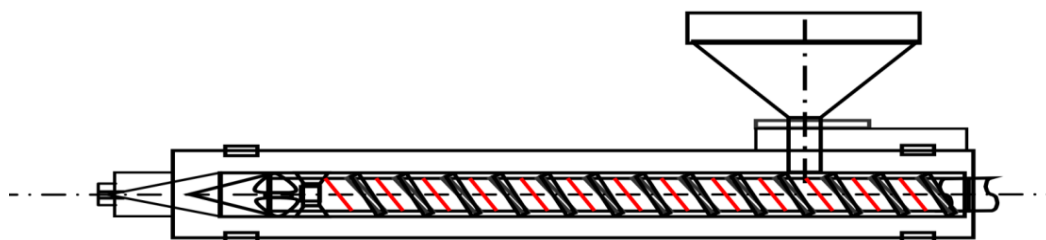


# 加工建議參數 TAIRILITE® AC383(x)

## 1. 烘料條件 120°C 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



單位:(°C)

模溫	前段 (射嘴)	中段 (壓縮混煉段)	後段 (入料段)
70-100	260-320	260-320	250-290

### \* 成型變動因素

- 產品尺寸厚薄
- 成型冷卻(週期)的規劃
- 模具澆口、澆道、排氣的規劃設計

### 注意事項

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

### ■ 清車注意事項(螺桿套筒)：

- 不建議使用熱分解樹脂清除料管中的殘留TAIRILITE® 樹脂
- 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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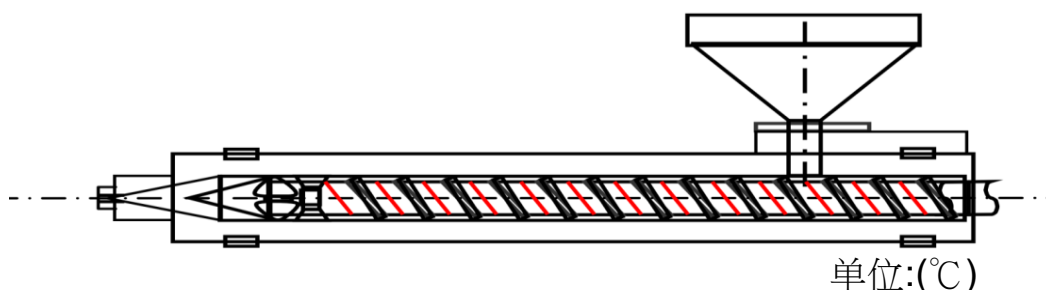


# 加工建议参数 TAIRILITE® AC383(x)

## 1. 烘料条件 120°C 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



模温	前段 (射嘴)	中段 (压缩湿炼段)	后段 (入料段)
70-100	260-320	260-320	250-290

### \* 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°C。

### ■ 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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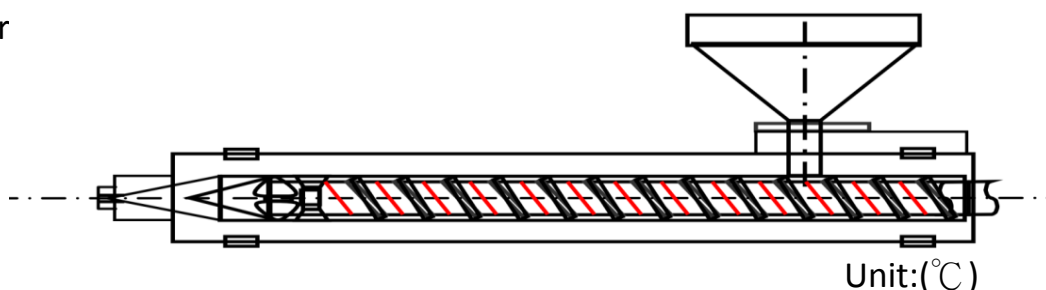


# Processing Guides for TAIRILITE® AC383(x)

## 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



Mold Temp.	Front-Zone (Nozzle)	Middle-Zone (Compression)	Rear-Zone (Feeding)
<b>70-100</b>	<b>260-320</b>	<b>260-320</b>	<b>250-290</b>

- \* 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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