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>250-300</td>
<td>250-300</td>
<td>240-280</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320℃。

■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

The above statement is based on our current level of knowledge and covers the above products directly manufactured and supplied by FCFC CORPORATION at the date of issue. FCFC CORPORATION makes no warranties, whether express or implied, and assumes no liability in connection with any use of above information. Notwithstanding the foregoing, FCFC CORPORATION shall in no event be held obligated or liable for any claims due to or arising from (i) any customer provided, consigned, materials and/or parts, which are incorporated or adopted in the products; (ii) any combination of the products with material not provided or authorized by our company; (iii) any modifications to the products which are made or directed by customer; (iv) our compliance with the specifications, instructions, and/or designs provided by customer; (v) any anti-trust, unfair competition and/or other unlawful actions effected by customer; or (vi) any defects, infringement, breach and/or violation which are arising out of customer’s faults or otherwise not solely and directly attributable to FCFC CORPORATION. In no event will FCFC CORPORATION be liable for any indirect, special, exemplary, punitive, or consequential damages (including lost profits) of any nature whatsoever whether arising out of the purchase, shipment, unloading, handling, or use of any product or otherwise.
加工建议参数 TAIRILITE® AC385(x)

1. 烘料条件  
   120℃ x 4~8 hrs  
   成型前胶粒需充分干燥，水分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>250-300</td>
<td>250-300</td>
<td>240-280</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320℃。

■ 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

The above statement is based on our current level of knowledge and covers the above products directly manufactured and supplied by FCFC CORPORATION at the date of issue. FCFC CORPORATION makes no warranties, whether express or implied, and assumes no liability in connection with any use of above information. Notwithstanding the foregoing, FCFC CORPORATION shall in no event be held obligated or liable for any claims due to or arising from (i) any customer provided, consigned, materials and/or parts, which are incorporated or adopted in the products; (ii) any combination of the products with material not provided or authorized by our company; (iii) any modifications to the products which are made or directed by customer; (iv) our compliance with the specifications, instructions, and/or designs provided by customer; (v) any anti-trust, unfair competition and/or other unlawful actions effected by customer; or (vi) any defects, infringement, breach and/or violation which are arising out of customer’s faults or otherwise not solely and directly attributable to FCFC CORPORATION. In no event will FCFC CORPORATION be liable for any indirect, special, exemplary, punitive, or consequential damages (including lost profits) of any nature whatsoever whether arising out of the purchase, shipment, unloading, handling, or use of any product or otherwise.
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 Profile

<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>250-300</td>
<td>250-300</td>
<td>240-280</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 320°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.