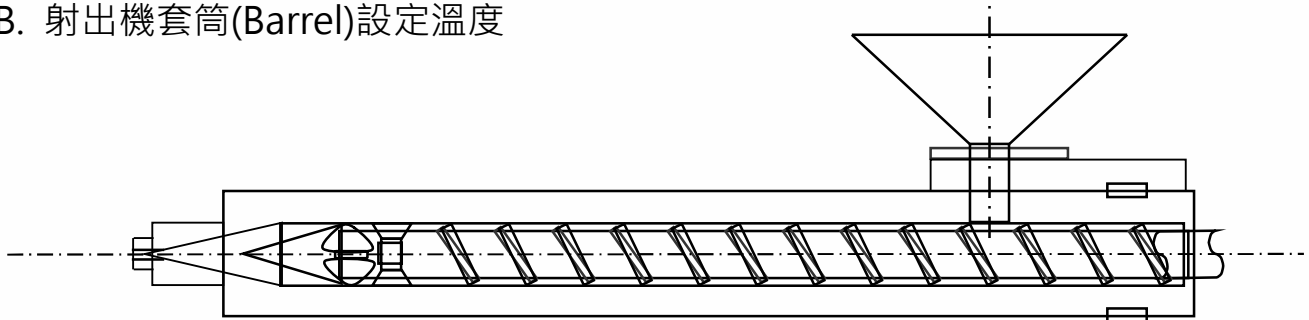


## MABS, POLYLAC<sup>®</sup> PA-758

July 21, 2021 V1W

### 加工建議條件

- A 乾燥：85°C，3~5 小時。  
依以下變數而變 a)濕度 b)回收料比例 c)儲存條件
- B. 射出機套筒(Barrel)設定溫度



	計量區	壓縮區	進料區
最高(°C)	250	250	220
最低(°C)	220	220	200

較佳的射出溫度為230~240°C

- C. 模具溫度 50~70 °C。依以下變數而變  
a)製品厚度 b) 尺寸 c) 澆口(Gate)及流道(Runner)系統
- D. 射壓 50~80 kg/cm<sup>2</sup>  
保壓 20~50 kg/cm<sup>2</sup>  
背壓 5~10 kg/cm<sup>2</sup>
- E. 停、開車的處置：
1. 開機時應溫度調整至設定值，射出料管中的殘餘MABS並確定料溫已達射定值後射出。
  2. 若必須長時間停機，必須將料管中的塑料擠出
  3. 洗車時請使用PA-758或高流動性的壓克力材料(PMMA)，例如CM-211。請勿使用其他透明材料如PS、SAN或ABS來洗車。以減少洗車時間及避免材料透明度受到影響。

#### 注意事項：

1. 生產及操作時避免樹脂接觸到灰塵及雜物。
2. 在射出週期中勿將熱融膠 (Hot Melt)長期停留在加熱管中。
3. 熱澆道(Hot Runner)系統溫度勿超過250°C
4. 各種MABS的製程及特性不同，使用時請勿混用，以免影響產品物性及透明程度。

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