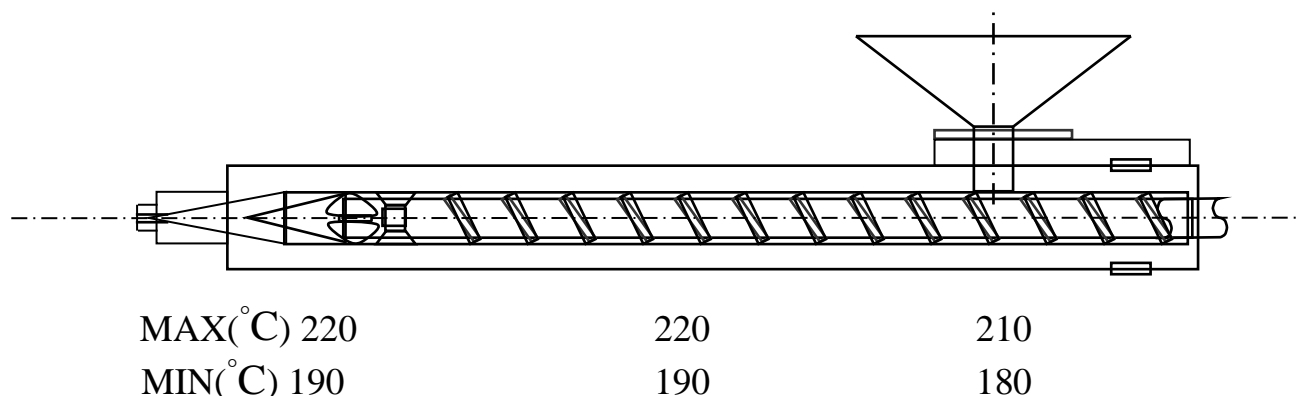


August 29, 2023 VIW

## **SAN, KIBISAN® PN-117 L200**

- A. Pre-drying 75~80°C x 3~4 hrs  
depending on a) Humidity  
b) Ratio of reground resin  
c) Storage conditions
- B. Barrel Setting Profile



- C. Mold Temperature 40~60 °C  
depending on a) Thickness  
b) Dimension  
c) Gate and runner system
- D. Injection Pressure 50~70 kg/cm<sup>2</sup>  
Holding Pressure 40~60 kg/cm<sup>2</sup>  
Back Pressure 5~15 kg/cm<sup>2</sup>

### 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 235°C to avoid melt from degradation.

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