

FR-PC RESIN PROCESSING CONDITIONS

Items	Self extinguishing Grade
Grade No.	AC3600
Pre-drying (°C x hr)	120~130°C 4~6hr
Mold Shrinkage (%)	0.5~0.7
Screw Temp. (°C)	260~295
Injection Pressure (Kg/cm ²)	50~130
Mold Temp. (°C)	80~100

Notes : Products quality from injection process depends on the following factors:

1. Wall thickness of Products
2. Mold cooling loop design
3. Mold gate and runner design



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