

## PC RESIN PROCESSING CONDITIONS

Items	Self extinguishing Grade		Transparent Self -extinguishing Grade	Transparent Self -extinguishing Grade
Grade No.	<b>AC3700</b>	<b>AC3710</b>	<b>AC3800</b>	<b>AC3900</b>
Pre-drying (°C×hr)	120~130°C 4~8hr	90~100°C 4~8hr	120~130°C 4~8hr	120~130°C 4~8hr
Mold Shrinkage (%)	0.5~0.7		0.5~0.7	0.5~0.7
Screw Temp. (°C)	260~290		260~290	260~290
Injection Pressure (Kg/cm <sup>2</sup> )	50~80		50~80	50~80
Mold Temp. (°C)	80~100		80~100	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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