

PC RESIN PROCESSING CONDITIONS

Items	Self extinguishing Grade			Transparent Self -extinguishing Grade	White color Self -extinguishing Grade
Grade No.	AC3630-AF	AC3700	AC3710	AC3800	AC3900 AC3910-AF
Pre-drying (°C×hr)	90~100°C 4~8hr	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	0.5~0.7	0.5~0.7
Screw Temp. (°C)	260~300	260~290	260~300	260~290	260~290
Injection Pressure (Kg/cm ²)	50~80	50~80	50~80	50~80	50~80
Mold Temp. (°C)	80~95	80~100	80~95	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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