

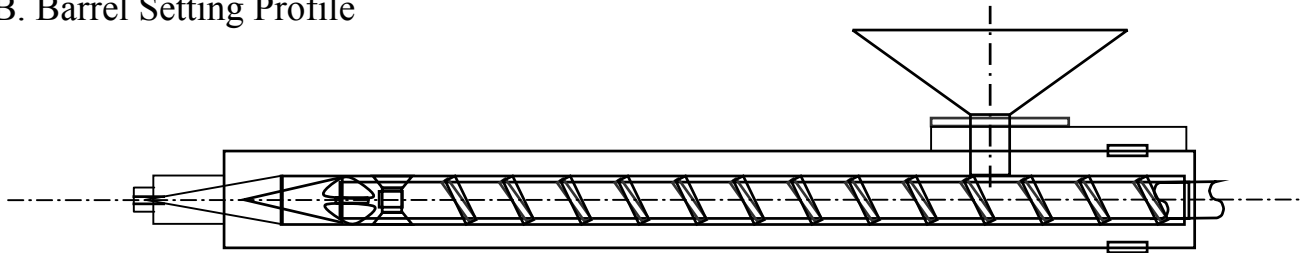


Clear KIBITON[®] PB-5903

Recommended Processing Condition

A Predrying is not necessary.

B. Barrel Setting Profile



	<u>Metering Zone</u>	<u>Compression Zone</u>	<u>Feeding Zone</u>
Max(°C)	200	200	180
Min(°C)	180	180	160

The suggested processing temperature is 180~190°C

C. Mold Temperature 30~50 °C

depending on a) Thickness b) Dimension c) Gate and runner system

D. Injection Pressure	40~70 kg/cm ²
Holding Pressure	10~40 kg/cm ²
Back Pressure	5~10 kg/cm ²

E Purging

Purging for shutdown should include complete removal of PB-5903 resin with either PB-5903 or PG-33/PG383 . The other clear plastics (ex. Clear ABS/Clear HIPS) are not suggested.

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 210°C to avoid melt from degradation.
4. PB-5903 can any ratio blend with other K-RESIN grade will not influence the properties and light transmission.