



USI Group

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**TAITALAC**

ABS Resin

## Processing Guide - Molding condition for injection

Character		General purpose		High impact & Metal Plating		Superior impact		Extrusion		High Flow		Flame retardant	
Grade		5000 5000M 5000W 5000S		1000 1250 6000 1000T 1000D		3000P 3100R 3100M		3000D		1003 5002 5000F 6000P		8540T	
Processing parameters	unit	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Drying Temperature	°C (°F)	80(176)	85(185)	80(176)	85(185)	80(176)	85(185)	80(176)	85(185)	80(176)	85(185)	70(158)	75(167)
Drying Time	hr	2	4	2	4	2	4	2	4	2	4	2	4
Melt Zone	°C (°F)	170(338)	180(356)	180(356)	190(374)	185(365)	195(383)	190(374)	200(392)	170(338)	180(356)	165(329)	175(347)
Rear Zone	°C (°F)	185(356)	215(419)	190(374)	220(428)	200(392)	230(446)	205(401)	235(455)	180(356)	210(410)	170(338)	200(392)
Middle Zone	°C (°F)	195(383)	225(437)	200(392)	230(446)	210(410)	240(464)	215(419)	245(473)	190(383)	220(428)	180(356)	210(410)
Front Zone	°C (°F)	185(365)	215(419)	190(374)	220(428)	200(392)	230(446)	205(401)	235(455)	180(356)	210(410)	170(338)	200(392)
Nozzle	°C (°F)	205(401)	235(455)	210(410)	240(464)	220(428)	240(464)	225(437)	245(473)	200(392)	230(446)	190(383)	220(428)
Mold Temperature	°C (°F)	40(104)	70(158)	40(104)	70(158)	40(104)	70(158)	40(104)	70(158)	40(104)	70(158)	40(104)	70(158)
Back Pressure	psi(Mpa)	50	70	50	70	50	70	50	70	50	70	50	70
Screw Speed	rpm	30	100	30	100	30	100	30	100	30	100	30	100
Injection Pressure	-	Moderate to Moderately High		Moderate to Moderately High		Moderately High to high		Low to Moderate		Low to Moderate		Moderate to Moderately High	
Injection Speed	-	Moderate to Fast		Moderate to Fast		Moderate to Fast		Low to Moderate		Low to Moderate		Moderate to Fast	

Notice 1 – All data listed above are just reference information. It would need to take some adjustment according to different equipment and molding.

Notice 2 – Processing condition of dye products are same as natural products.