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TAITALAC
SAN Resin**Processing Guide - Molding condition for injection**

Character		General purpose	
Grade		1200(Z) 1400(N/Z)	
Processing parameters	unit	Min.	Max.
Drying Temperature	°C (°F)	80(176)	85(185)
Drying Time	hr	2	4
Melt Zone	°C (°F)	170(338)	180(356)
Rear Zone	°C (°F)	185(356)	215(419)
Middle Zone	°C (°F)	195(383)	225(437)
Front Zone	°C (°F)	185(365)	215(419)
Nozzle	°C (°F)	205(401)	235(455)
Mold Temperature	°C (°F)	40(104)	70(158)
Back Pressure	psi(Mpa)	50	70
Screw Speed	rpm	30	100
Injection Pressure	-	Moderate to Moderately High	
Injection Speed	-	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.