



USI Group

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

Character		General purpose		High heat resistant Chemical resistant	
Grade		1200(Z) 1400(N/Z)		1600 (Z) 1600H (Z)	
Processing parameters	unit	Min.	Max.	Min.	Max.
Drying Temperature	°C (°F)	80(176)	85(185)	80(176)	85(185)
Drying Time	hr	2	4	2	4
Melt Zone	°C (°F)	170(338)	180(356)	180(356)	220(428)
Rear Zone	°C (°F)	185(356)	215(419)	190(374)	230(446)
Middle Zone	°C (°F)	195(383)	225(437)	200(392)	240(464)
Front Zone	°C (°F)	185(365)	215(419)	190(374)	230(446)
Nozzle	°C (°F)	205(401)	235(455)	210(410)	240(464)
Mold Temperature	°C (°F)	40(104)	70(158)	40(104)	70(158)
Back Pressure	psi(Mpa)	50	70	50	70
Screw Speed	rpm	30	100	30	100
Injection Pressure	-	Moderate to Moderately High		Moderate to Moderately High	
Injection Speed	-	Moderate to Fast		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.