

Standard Conditions

■ Predrying conditions

| Grade | VH, VHS, VH4, VH5 | MD, TF8, TF9 | MF, SV | IRH, IRG, IRK, IRL, VRL | IRD, IRS |
|-----------------|----------------------|--------------|---------|----------------------------|----------|
| Temperature | 80~90°C | 75~85°C | 70~80°C | 75~85°C | 70~80°C |
| Drying Time (1) | 4~6hr | 4~6 h r | 4~6 h r | 4~6hr | 4~6hr |

(1)When using a dehumidification dryer

■ Injection Molding Conditions

| Grade | VH,VHS, VH4,VH5 | MD, TF8, TF9 | MF,SV | IRH,IRG,IRK, IRL,VRL | IRD,IRS |
|----------------------|--------------------|--------------|-------------|-------------------------|-----------|
| Cylinder Temperature | 210~260°C | 190~260°C | 170~260°C | 210~260°C | 200~260°C |
| Mold Temperature | 50~90°C | 50~70°C | 50~60°C | 50~80°C | 50~80°C |
| Injection Pressure | 80~140MPa | 80~140M P a | 80~140M P a | 70~150MPa | 70~150MPa |

■ Annealing Conditions of Molded Products

| Grade | VH,VHS, VH4,VH5 | MD, TF8, TF9 | MF,SV | IRH,IRG,IRK, IRL,VRL | IRD,IRS |
|----------------------|--------------------|--------------|---------|-------------------------|---------|
| Air bath Temperature | 85~90°C | 70~75°C | 65~70°C | 75~85°C | 65~75°C |
| Time | 1~3Hr | 1~3Hr | 1~3Hr | 1~3Hr | 1~3Hr |