Clear KIBITON® PB-5903

Recommended Processing Condition

A. Predrying is not necessary.

B. Barrel Setting Profile

<table>
<thead>
<tr>
<th></th>
<th>Metering Zone</th>
<th>Compression Zone</th>
<th>Feeding Zone</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max(°C)</td>
<td>200</td>
<td>200</td>
<td>180</td>
</tr>
<tr>
<td>Min(°C)</td>
<td>180</td>
<td>180</td>
<td>160</td>
</tr>
</tbody>
</table>

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/cm²
   Holding Pressure  10~40 kg/cm²
   Back Pressure  5~10 kg/cm²

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.