

## DANE TECHNICZNE / PLASTICKÉ MATERIÁLY

| amorficzne / amorfni<br>kryształiczne / kryšťalické | OZNACZENIE KODOWE<br>OZNAČENÍ MATERIÁLŮ | NAZVY HANDLOWE<br>OBCHODNÍ NÁZEV                |  |
|---|---|---|--|
| A   | ABS                                     | Terluran - Cicolac - Novodur - Lustran - Magnum |  |
| A   | ASA                                     | Luran S - Rovel - Gelay - Centrex               |  |
| A   | CAB                                     | Cellidor B - Tenite                             |  |
|   | C                                       | FEP   | Teflon - Fluron - Hostaflow                                |
|   | C                                       | LCP   | Vectra - Xydar   |
|   | C                                       | PA 11   | Ultramid - Rilsan B  |
|   | C                                       | PA 12   | Rilsan A   |
|   | C                                       | PA 610  | Maranil B - Zytel  |
|   | C                                       | PA 6  | Grilon - Ultramid C - Capron                               |
|   | C                                       | PA 6.6  | Sniamid - Minlon - Ultramid A - Zytel                      |
|   | C                                       | PBTP  | Pocan - Valox - Celanex                                    |
| A   | PC                                      | Macrolon - Lexan - Calibre                      |  |
|   | C                                       | PE  | Moplen - Lupolen - Dowlex - Tenite                         |
|   | C                                       | PEEK  | Victrex  |
| A   | PEI                                     | Ultem   |  |
| A   | PES                                     | Ultrason  |  |
|   | C                                       | PETP  | Arnite - Rynite - Crastin - Petra                          |
| A   | PMMA                                    | Acrylglas - Vedril - Oroglas - Plexiglas        |  |
|   | C                                       | POM   | Delrin - Ultraform - Hostaform - Celcon                    |
|   | C                                       | PP  | Hostalen - Novolen - Moplen - Fortilene - Pro-Fax - Tenite |
| A   | PPO                                     | Noryl   |  |
|   | C                                       | PPS   | Ryton - Fortron  |
| A   | PS                                      | Polystyron - Edistir - Styron                   |  |
| A   | PSU                                     | Polysulfon - Mindel - Radel                     |  |
| A   | PVC                                     | Hostalit - Colorite                             |  |
| A   | SAN                                     | Luran - Kostil - Tyril                          |  |
| A   | SB                                      | Styrolux - "K" Resin                            |  |
| A   | TPU                                     | Desmopan - Texin - Santoprene                   |  |
|   |   |   |  |

## TWORZYWA SZTUCZNE / PLASTICKÉ MATERIÁLY

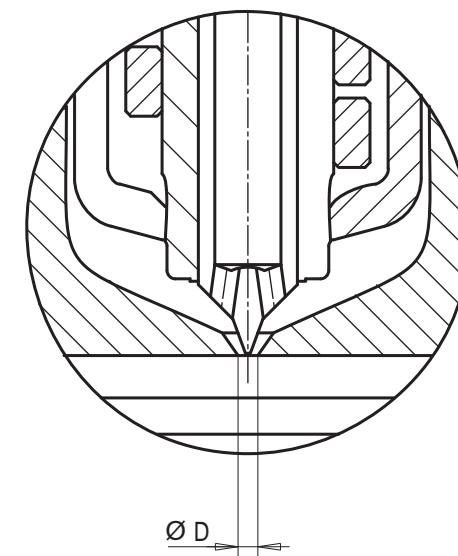
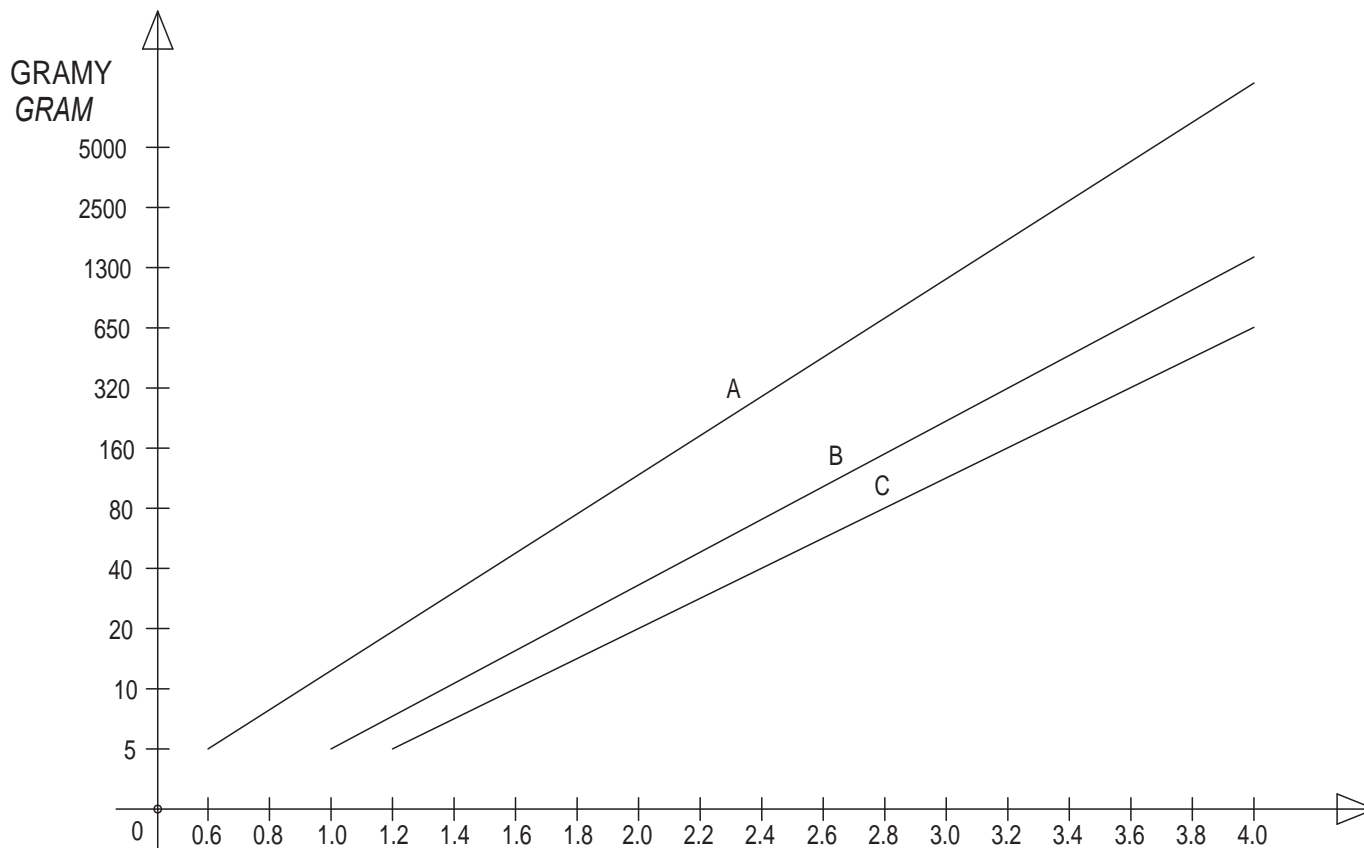
| Oznaczenie kodowe<br><i>Kód</i> | Nazwa<br><i>Název</i>                              | Temperatura suszenia<br><i>Teplota sušení</i><br>C | Czas suszenia<br><i>Doba sušení</i><br>(h) | Temperatura cylindra<br><i>Teplota vstřikovacího válce</i><br>C | Temperatura formy<br><i>Teplota formy</i><br>C | Ciśnienie wtrysku<br><i>Vstřikovací tlak</i><br>Kg/cm <sup>2</sup> | Skurcz<br><i>Směšnění</i><br>% | Gęstość właściwa<br><i>Měrná váha</i> | Odporność termiczna<br><i>Tepelná odolnost (stálá)</i> |
|---------------------------------|--|--|--|---|--|--|--------------------------------|---------------------------------------|--|
| PA 11                           | POLIAMID<br>POLYAMID                               | 70/80  | 8/15                                       | 190/270   | 20/100   | 700<br>1200  | 0.3/1.5                        | 1.03<br>1.08                          | 80/150   |
| PA 12                           |  | 70/80  | 8/15                                       | 190/270   | 20/100   | 700<br>1200  | 0.3/1.5                        | 1.03<br>1.08                          | 80/150   |
| PA 6                            |  | 80   | 8/15                                       | 240/290   | 40/120   | 700<br>1200  | 0.5/1.5                        | 1.12<br>1.14                          | 80/120   |
| PA 66                           |  | 80   | 8/15                                       | 260/300   | 40/120   | 700<br>1200  | 0.8/1.5                        | 1.38                                  | 80/120   |
| PBTP                            | POLITEREFTALAN BUTYLENOWY<br>POLYBUTYLENTEREFTALAT | 120  | 4  | 230/280   | 40/80  | 560<br>1800  | 1.5/2.0                        | 1.31<br>1.38                          | 49/120   |
| PC                              | POLIWEGLAN<br>POLYCARBONAT                         | 120  | 4/6  | 270/380   | 80/120   | 800<br>1400  | 0.5/0.7                        | 1.19<br>1.20                          | 120  |
| PMMA                            | POLIMETAKRYLAN METYLU<br>POLYMETHYLMETACRYLAT      | 70/100   | 2/6  | 190/290   | 40/90  | 400<br>1400  | 0.1/0.4                        | 1.17<br>1.20                          | 59/93  |
| POM                             | POLIACETAL (POLIFORMALDECHYD)<br>POLYACETALHARTZ   | 10   | 2  | 180/230   | 50/120   | 800<br>1700  | 1/3.5                          | 1.41<br>1.42                          | 90   |
| POM+25FV                        |  | 110  | 2  | 180/230   | 50/120   | 800<br>1700  | 0.4                            | 1.61                                  | 104  |
| PP                              | POLIPROPYLEN<br>POLYPROPYLEN                       | -  | -  | 200/300   | 20/90  | 700<br>1400  | 1/2.5                          | 0.9<br>0.91                           | 46/60  |
| PP+40FV                         |  | -  | -  | 200/300   | 20/90  | 700<br>1400  | 0.2/0.8                        | 1.22<br>1.23                          | 60/90  |
| PPO                             | POLITLENEK FENYLENU<br>POLYPHENYLENOXID            | 80/120   | 2  | 260/300   | 80/110   | 1000<br>1400   | 0.5/0.7                        | 1.06<br>1.10                          | -40/+120   |
| PPS                             | POLISIARCZEK FENYLENU<br>POLYPHENYLENSULFAT        | 150/170  | 4  | 300/360   | 40/200   | 750<br>1500  | 0.7                            | 1.34                                  | 230  |
| PS                              | POLISTYREN<br>POLYSTYROL                           | -  | -  | 170/280   | 20/60  | 700<br>2100  | 0.4/0.7                        | 1.05                                  | 65/76  |
| SB                              |  | -  | -  | 190/280   | 10/80  | 700<br>2100  | 0.4/0.7                        | 1.03<br>1.06                          | 60/79  |
| PS                              |  | -  | -  | 190/280   | 220/80   | 700<br>2100  | 0.2/0.6                        | 1.05<br>1.09                          | 60/80  |
| PSU                             | POLISULFON<br>POLYSULFON                           | 135/150  | 3/4  | 310/390   | 95/115   | 1000<br>1500   | 0.7/0.8                        | 1.24                                  | -100/+180  |
|                                 |  |  |  |   |  |  |                                |                                       |  |

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|---------------------------------|---|--|--|---|--|--|--------------------------------|---------------------------------------|--|
| SVP                             | POLICHLOREK WINYLU<br><i>POLYVENYLCHORID</i>                                | -  | -  | 160/190   | 10/20  | 560 / 1750   | 1/5                            | 1.16 / 1.35                           | -  |
| HPVC                            |   | -  | -  | 170/210   | 10/60  | 700 / 2800   | 0.1/0.5                        | 1.30 / 1.58                           | 50/80  |
| SAN                             | KOPOLIMER STYREN-AKRYLONITRYL<br><i>STYROL ACRYLNITRID</i>                  | 85   | 2/4  | 200/260   | 50/80  | 700 / 2300   | 0.2/0.7                        | 1.07 / 1.10                           | 60/95  |
| SAN <sup>+20 FV</sup><br>+30 FV |   | 85   | 2/4  | 200/260   | 50/80  | 1050 / 2800  | 0.1/0.2                        | 1.20 / 1.46                           | 90/103   |
| ABS                             | KOPOLIMER AKRYLONITRYL-BUTADIEN-STYREN<br><i>BUTADIENSTYROL ACRYLNITRID</i> | 70/80  | 2  | 200/250   | 50/80  | 550 / 1750   | 0.4/0.9                        | 1.03 / 1.06                           | 71/93  |
| ABS                             |   | 70/80  | 2  | 250/300   | 50/80  | 550 / 1750   | 0.4/0.9                        | 1.05 / 1.08                           | 85/165   |
| ABS <sup>+20 FV</sup><br>+40 FV |   | 70/80  | 2  | 200/250   | 50/80  | 1000 / 2800  | 0.1/0.2                        | 1.22 / 1.36                           | 90/110   |
| ASA                             | KOPOLIMER STYREN-AKRYLOESTER<br><i>STYROL ACRYLNITRID + ACRYLESTER</i>      | 80/90  | 2  | 200/250   | 40/85  | 800 / 1800   | 0.4/0.7                        | 1.07                                  | 80/90  |
| CAB                             | OCTANOMAŚLAN CELULOZY<br><i>CELLULOSEACETOBUTYRAT</i>                       | 80   | 3  | 180/230   | 40/70  | 800 / 1200   | 0.4/0.7                        | 1.16 / 1.22                           | 60/110   |
| FEP                             | POLIFLUOROETYLENOPROPYLEN<br><i>TETRAFLUORPROPYLEN HEXA FLUORPROPYLEN</i>   | -  | -  | 330/420   | -  | - / -  | 3/6                            | 2.10 / 2.20                           | 260/280  |
| LCP                             | POLIMERY CIEKŁOKRYSTALICZNE<br><i>FLUSSIGCRISTAL POLYMER</i>                | 150/160  | 4  | 285/330   | 100/150  | 140 / 400  | 0.1/1                          | 1.4 / 1.9                             | 220/240  |
| LDPE                            | POLIETYLEN MAŁEJ GĘSTOŚCI<br><i>HOCHDRUCK POLYETHYLEN</i>                   | -  | -  | 160/240   | 20/70  | 500  | 1.5/3.5                        | 0.92 / 0.94                           | 80/95  |
| HDPE                            | POLIETYLEN DUŻEJ GĘSTOŚCI<br><i>NIEDERDRUCK POLYETHYLEN</i>                 | -  | -  | 180/300   | 10/90  | 1200   | 2/4                            | 0.94 / 0.96                           | 80/105   |
| PEEK                            | POLIETEROETEROKETON<br><i>POLYETHERETHER KETON</i>                          | 150  | 3  | 370/390   | 160/170  | 700 / 1400   | 0.7/1.2                        | 1.30                                  | 250  |
| PEI                             | POLIETEROIMID<br><i>POLYETHERIMID</i>                                       | 150  | 4  | 340/425   | 100/150  | 800 / 2000   | 0.5/0.7                        | 1.27 / 1.42                           | -200/+260  |
| PES                             | POLIETEOSULFON<br><i>POLYETHERSULFON</i>                                    | 135/150  | 3/4  | 340/390   | 120/160  | 1000 / 1500  | 0.6                            | 1.37                                  | 200  |
| PETP                            | POLITEREFTALAN ETYLENOWY<br><i>POLYETHYLENTEREPHTALAT</i>                   | 75/90  | 3/4  | 260/290   | 30/140   | 1000 / 1700  | 1/2                            | 1.37                                  | -40/+110   |
| TPU                             | POLIURETAN TERMOPLASTYCZNY<br><i>THERMOPLASTISCHES POLYURETHAN</i>          | 100/110  | 2  | 190/230   | 20/30  | 400 / 1000   | 0.2/2                          | 1.14 / 1.26                           | -40/+80  |

TWORZYWA SZTUCZNE / PLASTICKE MATERIÁLY

DANE TECHNICZNE / TABULKY MATERIÁLU

WYKRES DOBORU ŚREDNICY PRZEWEŹKI  
 GRAF PRO STANOVENÍ PRŮMĚRU VSTŘIKOVACÍHO OTVORU



- A ————— Materiał o dużej płynności : PE - PP  
 B ————— Materiał o średniej płynności : ABS - POM - PA  
 C ————— Materiał o małej płynności : PC - PMMA

- A ————— *Materiál s nízkou viskozitou* : PE - PP  
 B ————— *Materiál se střední viskozitou* : ABS - POM - PA  
 C ————— *Materiál s vysokou viskozitou* : PC - PMMA

ŚREDNICA PRZEWEŹKI W mm D  
 PRŮMĚR VSTŘIKOVACÍHO OTVORU