PLASTIC MATERIALS / *KUNSTSTOFFE*

Amorphous / *Amorph*	Crystalline / *Kristallin*	CODE ABBREV. *CHEMISCHE BEZEICHNUNG*	COMMERCIAL NAMES *HANDELSNAME*
A		ABS	Terluran - Cycolac - Novodur - Lustran - Magnum
A		ASA	Luran S - Rovel - Geloy - 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

Code *Chemische Bezeichnung*	Name *Bezeichnung*	Drying temperature *Trocknungs--temperatur* C	Drying time *Trocknungs--zeit* (h)	Injection barrel temperature *Zylinder--temperatur* C	Mold temperature *Werzeug--temperatur* C	Injection pressure *Einspritz--druck* Kg/cm 2	Shrinkage *Schrumpfung* %	Specific density *Spezifische Dichte*	Temperature resistance (continuous) *Temperatur--widerstand*
PA 11	POLYAMID	70/80	8/15	190/270	20/100	700 / 1200	0.3/1.5	1.03 / 1.08	80/150
PA 12		70/80	8/15	190/270	20/100	700 / 1200	0.3/1.5	1.03 / 1.08	80/150
PA 6		80	8/15	240/290	40/120	700 / 1200	0.5/1.5	1.12 / 1.14	80/120
PA 66		80	8/15	260/300	40/120	700 / 1200	0.8/1.5	1.38	80/120
PBTP	POLYBUTYLENTEREPHTALAT	120	4	230/280	40/80	560 / 1800	1.5/2.0	1.31 / 1.38	49/120
PC	POLYCARBONAT	120	4/6	270/380	80/120	800 / 1400	0.5/0.7	1.19 / 1.20	120
PMMA	POLYMETHYLMETACRYLAT	70/100	2/6	190/290	40/90	400 / 1400	0.1/0.4	1.17 / 1.20	59/93
POM	POLYACETALHARZ	10	2	180/230	50/120	800 / 1700	1/3.5	1.41 / 1.42	90
POM+25FV		110	2	180/230	50/120	800 / 1700	0.4	1.61	104
PP	POLYPROPYLEN	-	-	200/300	20/90	700 / 1400	1/2.5	0.9 / 0.91	46/60
PP+40FV		-	-	200/300	20/90	700 / 1400	0.2/0.8	1.22 / 1.23	60/90
PPO	POLYPHENYLENOXID	80/120	2	260/300	80/110	1000 / 1400	0.5/0.7	1.06 / 1.10	-40/+120
PPS	POLYPHENYLENSULFAT	150/170	4	300/360	40/200	750 / 1500	0.7	1.34	230
PS	POLYSTYROL	-	-	170/280	20/60	700 / 2100	0.4/0.7	1.05	65/76
SB		-	-	190/280	10/80	700 / 2100	0.4/0.7	1.03 / 1.06	60/79
PS		-	-	190/280	220/80	700 / 2100	0.2/0.6	1.05 / 1.09	60/80
PSU	POLYSULFON	135/150	3/4	310/390	95/115	1000 / 1500	0.7/0.8	1.24	-100/+180

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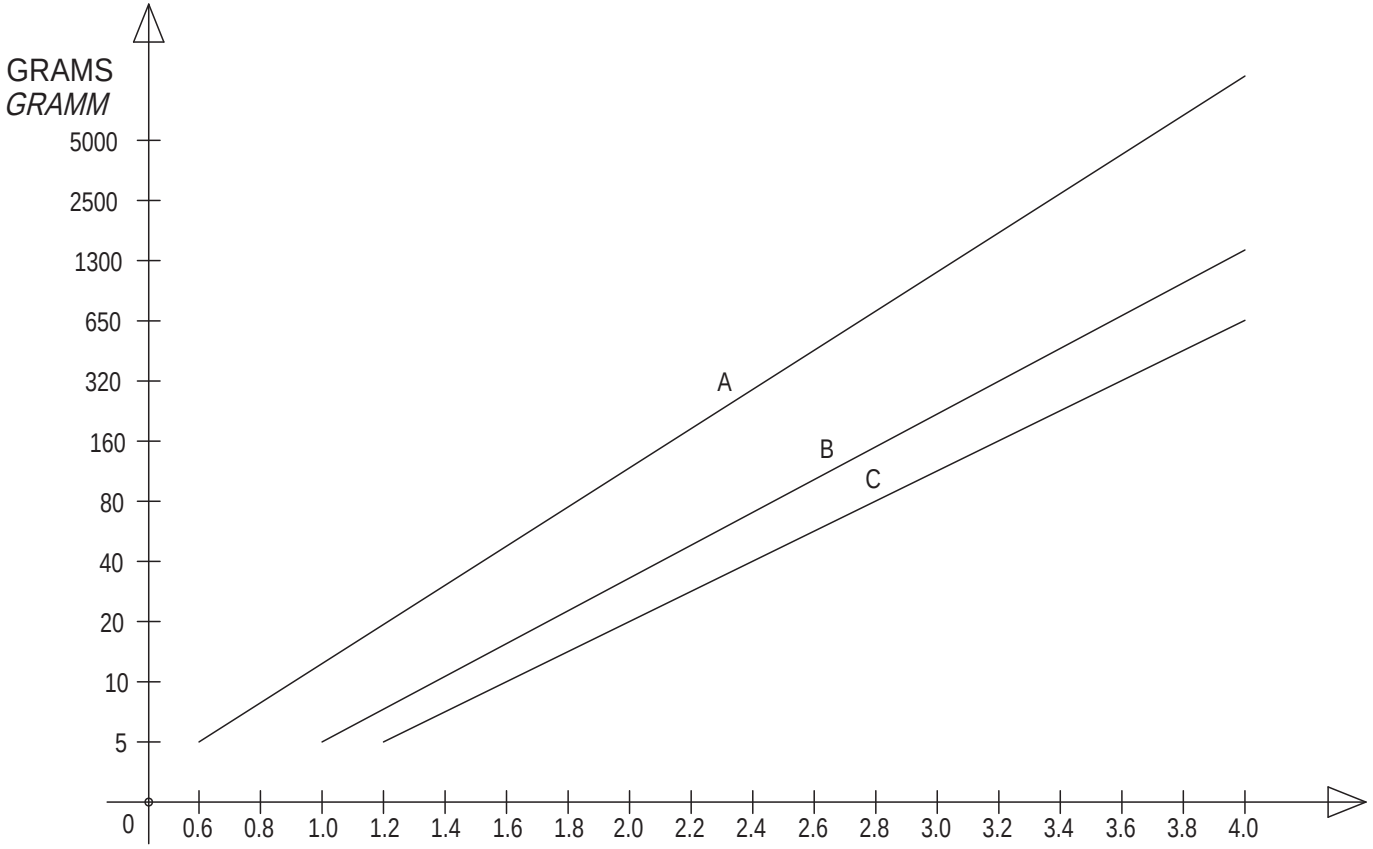
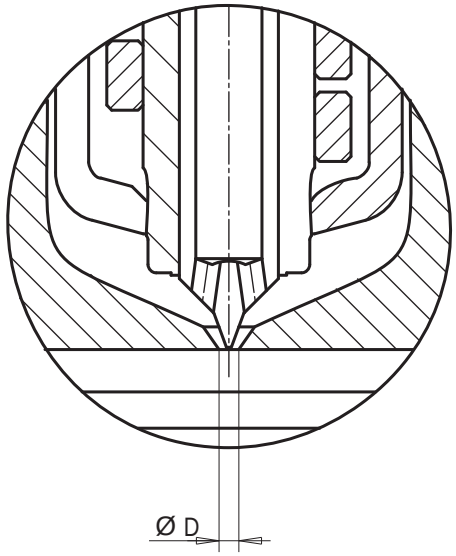
SVP	POLYVENYLCHORID	-	-	160/190	10/20	560 / 1750	1/5	1.16 / 1.35	-
HPVC		-	-	170/210	10/60	700 / 2800	0.1/0.5	1.30 / 1.58	50/80
SAN	STYROL ACRYLNITRID	85	2/4	200/260	50/80	700 / 2300	0.2/0.7	1.07 / 1.10	60/95
SAN +20 FV +30 FV		85	2/4	200/260	50/80	1050 / 2800	0.1/0.2	1.20 / 1.46	90/103
ABS	BUTADIENSTYROL ACRYLNITRID	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 +20 FV +40 FV		70/80	2	200/250	50/80	1000 / 2800	0.1/0.2	1.22 / 1.36	90/110
ASA	STYROL ACRYLNITRID + ACRYLESTER	80/90	2	200/250	40/85	800 / 1800	0.4/0.7	1.07	80/90
CAB	CELLULOSEACETOBUTYRAT	80	3	180/230	40/70	800 / 1200	0.4/0.7	1.16 / 1.22	60/110
FEP	TETRAFLUORPROPYLEN HEXA FLUORPROPYLEN	-	-	330/420	-	- / -	3/6	2.10 / 2.20	260/280
LCP	FLUSSIGCRISTAL POLYMER	150/160	4	285/330	100/150	140 / 400	0.1/1	1.4 / 1.9	220/240
LDPE	HOCHDRUCK POLYETHYLEN	-	-	160/240	20/70	500	1.5/3.5	0.92 / 0.94	80/95
HDPE	NIEDERDRUCK POLYETHYLEN	-	-	180/300	10/90	1200	2/4	0.94 / 0.96	80/105
PEEK	POLYETHERETHER KETON	150	3	370/390	160/170	700 / 1400	0.7/1.2	1.30	250
PEI	POLYTHERIMID	150	4	340/425	100/150	800 / 2000	0.5/0.7	1.27 / 1.42	-200/+260
PES	POLYETHERSULFON	135/150	3/4	340/390	120/160	1000 / 1500	0.6	1.37	200
PETP	POLYETHYLENTHEREPHTALAT	75/90	3/4	260/290	30/140	1000 / 1700	1/2	1.37	-40/+110
TPU	THERMOPLASTISCHES POLYURETHAN	100/110	2	190/230	20/30	400 / 1000	0.2/2	1.14 / 1.26	-40/+80

GRAPH TO CALCULATE GATE DIAMETER

TABELLE ZUR BESTIMMUNG DES ANSCHNITTDURCHMESSERES





A _____ Material of low viscosity : PE - PP
B _____ Material of medium viscosity : ABS - POM - PA
C _____ Material of higt viscosity : PC - PMMA

GATE DIAMETER IN mm D

ANSCHNITTDURCHMESSER D

A _____ *Niedrigviskose Kunststoffe* *: PE - PP*
B _____ *Mittelviskose Kunststoffe* *: ABS - POM - PA*
C _____ *Hochviskose Kunststoffe* *: PC - PMMA*