



CONDITION STATO	MATERIAL / MATERIALE	
	Family name <i>Sigla</i>	Commercial name <i>Nome commerciale</i>
Amorphous / Amorfo	ABS	Cycolac
	ASA	Luran S, Rovel, Geloy, Centrex
	EVA	Greenflex
	PC	Macrolon, Lexan, Calibre
	PC+ASA	Xenoy
	PC+ABS	Bayblend, Cycloy
	PCT	Termx
	PCTA	Eastar, Durastar
	PCTG	Tritan
	PEI	Ultem
	PES	Ultrason E
	PET	Amite, Rynite
	PMMA	Plexiglas, Altuglas, Vedril
	PPO/PPE	Noryl, Prenex
	PSU	Ultrason S
	PVC	Geon, Benuic
	SAN	Luran, Lustan
SEBS	Multiflex, Tefabloc	
Semicrystalline / Semicristallino	HDPE	Marlex, Hostalen, Rigidex
	HIPS (PS)	Plystirene, Stynon, Emera
	LCP	Vectr, Xydar
	LDPE	Escorene, Alkathene, Lopolen, Polyethylene L
	PA11	Rilsan B
	PA12	Rilsan A
	PA46	Stanyl
	PA6	Radylon, Akulon, Technyl, Ultramid B, Zytel
	PA66	Zytel, Fryanil A, Radylon A
	PBT	Valox, Celanex, Duranex
	PEEK	Victrax
	POM	Ultraform, Hostaform, Delrin, Celcon
	PP	Moplen, Noryl, Hostalen, Celstran
	PPS	Rytlon, Fortron
	TPE\TPU	Arnitel, Arnilex, Multiflex, Hytrel, Riteflex

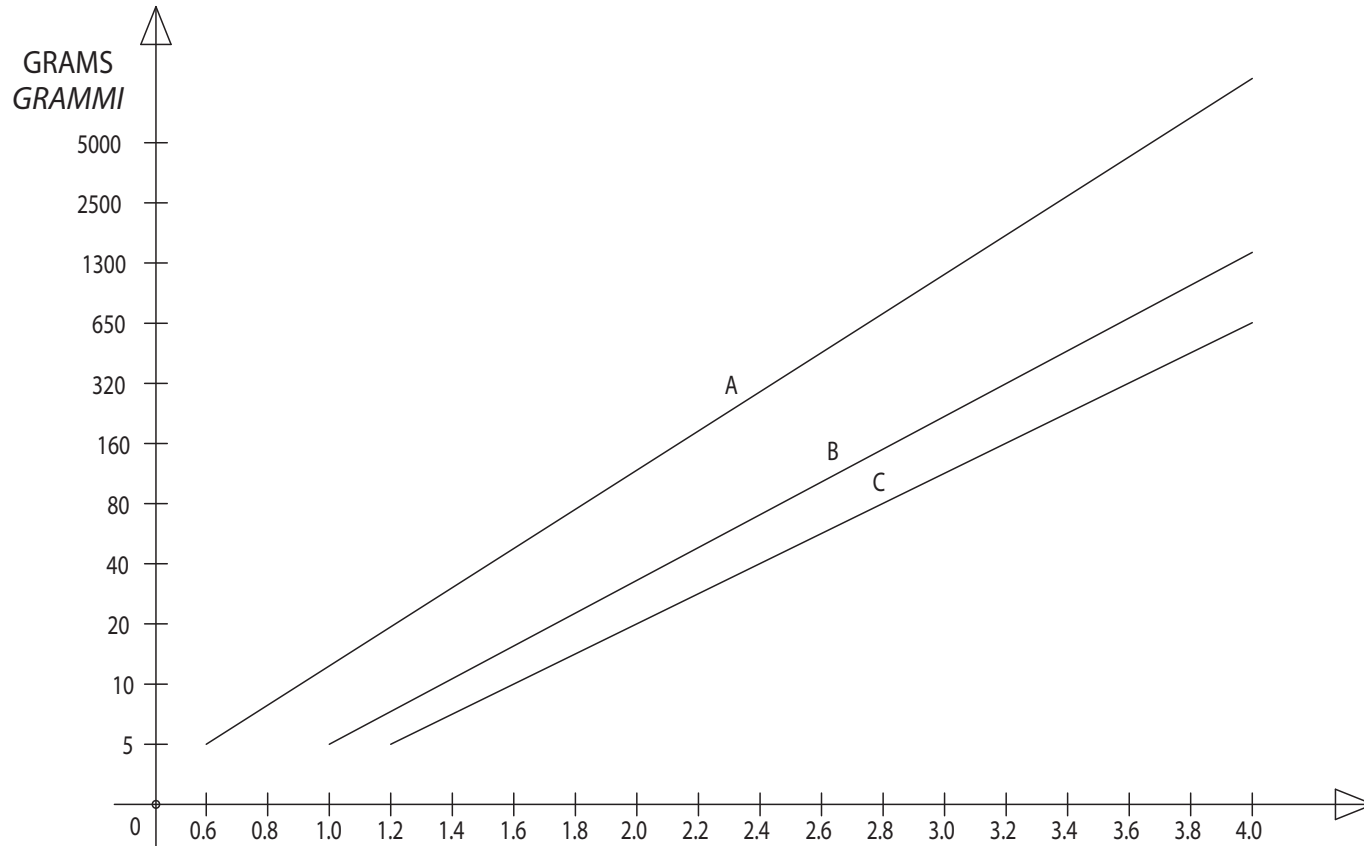
Code Sigla	Name Nome	Drying temperature <i>Temperatura di essiccazione</i> C	Drying time <i>Tempo di essiccazione</i> (h)	Injection barrel temperature <i>Temp. cilindro d'iniezione</i> C	Mold temperature <i>Temperatura stampo</i> C	Injection pressure <i>Pressione d'iniezione</i> Kg/cm ²	Shrinkage <i>Ritiri</i> %	Specific density <i>Peso specifico (densità)</i>
PA 11	POLYAMID / POLYAMMIDE	70/80	8/15	190/270	20/100	700 1200	0.3/1.5	1.03 1.08
PA 12		70/80	8/15	190/270	20/100	700 1200	0.3/1.5	1.03 1.08
PA 6		80	8/15	240/290	40/120	700 1200	0.5/1.5	1.12 1.14
PA 66		80	8/15	260/300	40/120	700 1200	0.8/1.5	1.38
PBTP	POLYBUTYLENTEREPHTALAT / POLIBUTILENTEREFTALATO	120	4	230/280	40/80	560 1800	1.5/2.0	1.31 1.38
PC	POLYCARBONAT / POLICARBONATO	120	4/6	270/380	80/120	800 1400	0.5/0.7	1.19 1.20
PMMA	POLYMETHYLMETACRYLAT / POLIMETILMETACRILATO	70/100	2/6	190/290	40/90	400 1400	0.1/0.4	1.17 1.20
POM	POLYACETALHARZ / POLIACETALICHE	10	2	180/230	50/120	800 1700	1/3.5	1.41 1.42
POM+25FV		110	2	180/230	50/120	800 1700	0.4	1.61
PP	POLYPROPYLEN / POLIPROPILENE	-	-	200/300	20/90	700 1400	1/2.5	0.9 0.91
PP+40FV		-	-	200/300	20/90	700 1400	0.2/0.8	1.22 1.23
PPO	POLYPHENYLENOXID / POLIFENILEOSSIDO	80/120	2	260/300	80/110	1000 1400	0.5/0.7	1.06 1.10
PPS	POLYPHENYLENSULFAT / POLIFENILENSOLFURO	150/170	4	300/360	40/200	750 1500	0.7	1.34
PS	POLYSTYROL / POLISTIRENE	-	-	170/280	20/60	700 2100	0.4/0.7	1.05
SB		-	-	190/280	10/80	700 2100	0.4/0.7	1.03 1.06
PS		-	-	190/280	220/80	700 2100	0.2/0.6	1.05 1.09
PSU	POLYSULFON / POLISULFONE	135/150	3/4	310/390	95/115	1000 1500	0.7/0.8	1.24
PETG	POLYETHYLENE TEREPHTHALATE GLYCOL COMONOMER POLIETILENE TEREFTALATO GLICOLE COMONOMERO	71	6	250/270	15/40	800 1400	0.2/0.5	1.27
PET	POLYETHYLENE TEREPHTHALATE/ POLIETILENE TEREFTALATO	120/140	4/6	250/280	20/80	800 1400	1.8/2.1	1.3



Code Sigla	Name Nome	Drying temperature <i>Temperatura di essiccazione</i> °C	Drying time <i>Tempo di essiccazione</i> (h)	Injection barrel temperature <i>Temp. cilindro d'iniezione</i> °C	Mold temperature <i>Temperatura stampo</i> °C	Injection pressure <i>Pressione d'iniezione</i> Kg/cm ²	Shrinkage <i>Ritiri</i> %	Specific density <i>Peso specifico (densità)</i>
PCTA	COPOLYESTER / COPOLIESTERE	70	4	230/280	15/30	800 / 1400	0.3	1.19
SVP	POLYVENYLCHORID / CLORURO DI POLIVINILE	-	-	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
SAN	STYROL ACRYLNITRID / STIRENE ACRILONITRILE	85	2/4	200/260	50/80	700 / 2300	0.2/0.7	1.07 / 1.10
SAN ^{+20 FV} +30 FV		85	2/4	200/260	50/80	1050 / 2800	0.1/0.2	1.20 / 1.46
ABS	BUTADIENSTYROL ACRYLNITRID ACRIL BUTADIENE STIRENE	70/80	2	200/250	50/80	550 / 1750	0.4/0.9	1.03 / 1.06
ABS		70/80	2	250/300	50/80	550 / 1750	0.4/0.9	1.05 / 1.08
ABS ^{+20 FV} +40 FV		70/80	2	200/250	50/80	1000 / 2800	0.1/0.2	1.22 / 1.36
ASA	STYROL ACRYLNITRID + ACRYLESTER STIRENE ACRILONITRILE + ESTERE ACRILICO	80/90	2	200/250	40/85	800 / 1800	0.4/0.7	1.07
CAB	CELLULOSEACETOBUTYRAT ACETO BUTIRRATO DI CELLULOSA	80	3	180/230	40/70	800 / 1200	0.4/0.7	1.16 / 1.22
FEP	TETRAFLUORPROPYLEN HEXA FLUORPROPYLEN TETRAFLUOROETILENE ESAFLUOROPROPILENE	-	-	330/420	-	- / -	3/6	2.10 / 2.20
LCP	FLUSSIGCRISTAL POLYMER / LIQUIDO CRISTAL POLIMERO	150/160	4	285/330	100/150	140 / 400	0.1/1	1.4 / 1.9
LDPE	HOCHDRUCK POLYETHYLEN / POLIETILENE	-	-	160/240	20/70	500	1.5/3.5	0.92 / 0.94
HDPE	NIEDERDRUCK POLYETHYLEN / POLIETILENE	-	-	180/300	10/90	1200	2/4	0.94 / 0.96
PEEK	POLYETHERETHER KETON / POLIETEREETERECHETONE	150	3	370/390	160/170	700 / 1400	0.7/1.2	1.30
PEI	POLYETHERIMID / POLIETEREIMMIDI	150	4	340/425	100/150	800 / 2000	0.5/0.7	1.27 / 1.42
PES	POLYETHERSULFON / POLIETERESULFONE	135/150	3/4	340/390	120/160	1000 / 1500	0.6	1.37
PETP	POLYETHYLENTEREPHTALAT / POLIETILENTEREFTALATO	75/90	3/4	260/290	30/140	1000 / 1700	1/2	1.37
TPU	THERMOPLASTISCHES POLYURETHAN / URETANI TERMOPLASTICI	100/110	2	190/230	20/30	400 / 1000	0.2/2	1.14 / 1.26



GRAPH TO CALCULATE GATE DIAMETER
 GRAFICO PER IL CALCOLO DEI FORI DI INIEZIONE



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

A ——— Materiali a bassa viscosità : PE - PP
 B ——— Materiali a media viscosità : ABS - POM - PA
 C ——— Materiali ad alta viscosità : PC - PMMA

GATE DIAMETER IN mm D
 DIAMETRO FORO DI INIEZIONE (D)

