



CONDITION ZUSTAND	MATERIAL	
	Family name <i>Chemische Bezeichnung</i>	Commercial name <i>Handelsname</i>
Amorphous / Amorph	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 / Teilkristalline	HDPE	Marlex, Hostalen, Rigidex
	HIPS (PS)	Polystirene, 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	Victrix
	POM	Ultraform, Hostaform, Delrin, Celcon
	PP	Moplen, Noryl, Hostalen, Celstran
	PPS	Rytlon, Fortron
	TPE\TPU	Arnitel, Arnilex, Multiflex, Hytrel, Riteflex

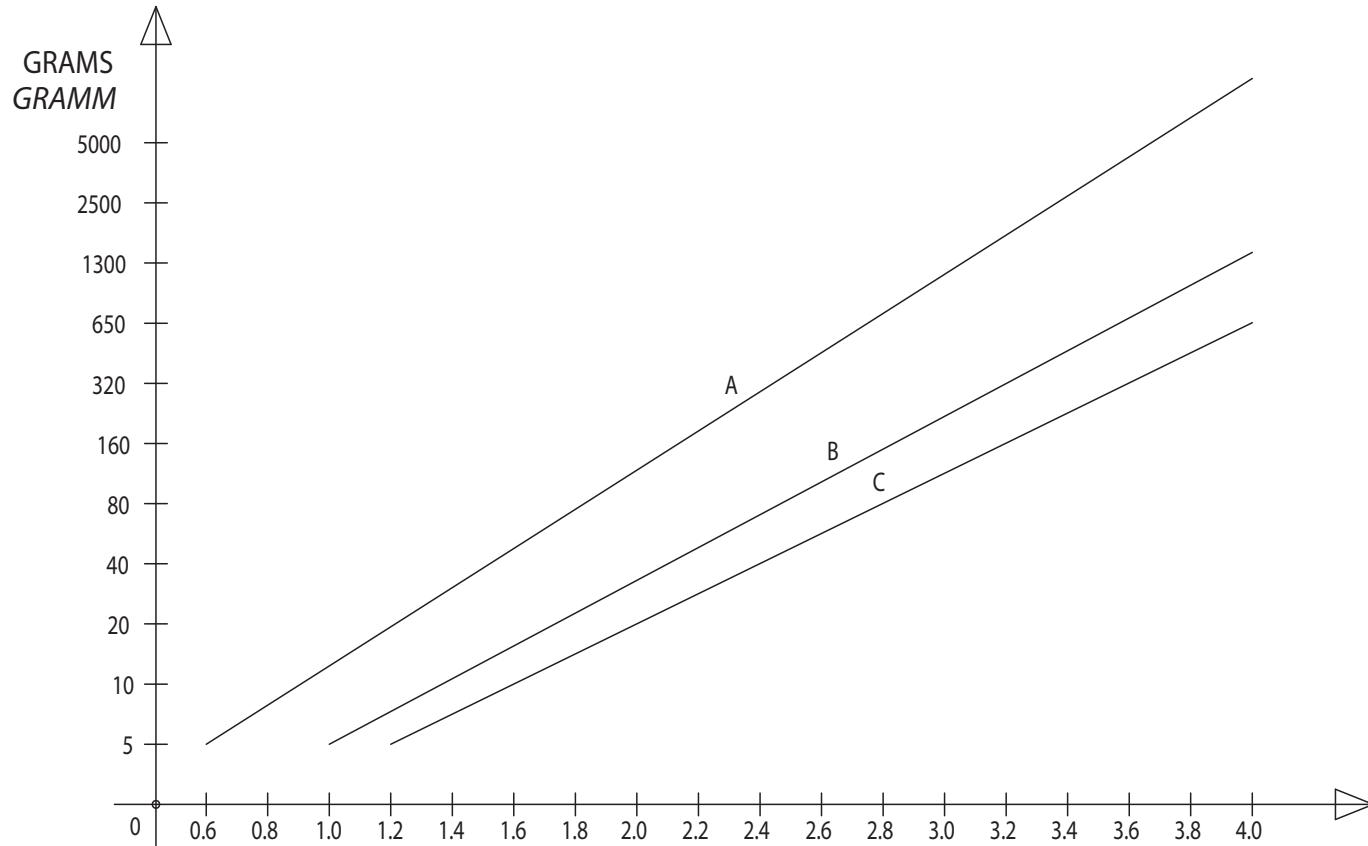
Code <i>Chemische Bezeichnung</i>	Name <i>Bezeichnung</i>	Drying temperature <i>Trocknungs- temperatur</i> C	Drying time <i>Trocknungs-zeit</i> (h)	Injection barrel temperature <i>Zylinder- temperatur</i> C	Mold temperature <i>Werkzeug- temperatur</i> C	Injection pressure <i>Einspritz- druck</i> Kg/cm ²	Shrinkage <i>Schwindung</i> %	Specific density <i>Spezifische Dichte</i>
PA 11	POLYAMID	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	120	4	230/280	40/80	560 1800	1.5/2.0	1.31 1.38
PC	POLYCARBONAT	120	4/6	270/380	80/120	800 1400	0.5/0.7	1.19 1.20
PMMA	POLYMETHYLMETACRYLAT	70/100	2/6	190/290	40/90	400 1400	0.1/0.4	1.17 1.20
POM	POLYACETALHARZ	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	-	-	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	80/120	2	260/300	80/110	1000 1400	0.5/0.7	1.06 1.10
PPS	POLYPHENYLENSULFAT	150/170	4	300/360	40/200	750 1500	0.7	1.34
PS	POLYSTYROL	-	-	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	135/150	3/4	310/390	95/115	1000 1500	0.7/0.8	1.24
PETG	POLYETHYLENE TEREPHTHALATE GLYCOL COMONOMER	71	6	250/270	15/40	800 1400	0.2/0.5	1.27
PET	POLYETHYLENE TEREPHTHALATE	120/140	4/6	250/280	20/80	800 1400	1.8/2.1	1.3



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PCTA	COPOLYESTER	70	4	230/280	15/30	800 / 1400	0.3	1.19
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
SAN	STYROL ACRYLNITRID	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	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	80/90	2	200/250	40/85	800 / 1800	0.4/0.7	1.07
CAB	CELLULOSEACETOBUTYRAT	80	3	180/230	40/70	800 / 1200	0.4/0.7	1.16 / 1.22
FEP	TETRAFLUORPROPYLEN HEXA FLUORPROPYLEN	-	-	330/420	-	- / -	3/6	2.10 / 2.20
LCP	FLUSSIGCRISTAL POLYMER	150/160	4	285/330	100/150	140 / 400	0.1/1	1.4 / 1.9
LDPE	HOCHDRUCK POLYETHYLEN	-	-	160/240	20/70	500	1.5/3.5	0.92 / 0.94
HDPE	NIEDERDRUCK POLYETHYLEN	-	-	180/300	10/90	1200	2/4	0.94 / 0.96
PEEK	POLYETHERETHER KETON	150	3	370/390	160/170	700 / 1400	0.7/1.2	1.30
PEI	POLYETHERIMID	150	4	340/425	100/150	800 / 2000	0.5/0.7	1.27 / 1.42
PES	POLYETHERSULFON	135/150	3/4	340/390	120/160	1000 / 1500	0.6	1.37
PETP	POLYETHYLENTEREPHTALAT	75/90	3/4	260/290	30/140	1000 / 1700	1/2	1.37
TPU	THERMOPLASTISCHES POLYURETHAN	100/110	2	190/230	20/30	400 / 1000	0.2/2	1.14 / 1.26



GRAPH TO CALCULATE GATE DIAMETER TABELLE ZUR BESTIMMUNG DES ANSCHNITTDURCHMESSERS



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

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

GATE DIAMETER IN mm D
 ANSCHNITTDURCHMESSER D

