

MALZEME BİLGİSİ

		Code (Kısaltma)	Name (sim)	Drying Temperature (Kurutma Sıcaklığı) (C)	Drying Time (Kurutma Süresi) (h)	Injection Barrel Temperature (Enjeksiyonlama Sıcaklığı) (C)	Mold Temperature (Kalıp Sıcaklığı) (C)	Injection pressure (Enjeksiyon Basıncı) (kg/cm ²)	Shrinkage (Çekme Payı) (%)	Specific Density (Özkütle) (g/cm ³)	Temperature Resistance (Sıcaklık Direnci) (C)
AMORPHOUS PLASTICS	COMMODITY THERMOPLASTICS	PMMA	<i>Poly Methyl Methacrylate</i>	70/100	2/6	190/290	40/90	400/1400	0.1/0.4	1.17/1.20	59/93
		PS	<i>Polystyrene</i>	-	-	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
		SAN	<i>Styrene Acrylonitrile</i>	85	2/4	200/260	50/80	700/2300	0.2/0.7	1.07/1.10	60/95
		SAN +20/30 FR		85	2/4	200/260	50/80	1050/2800	0.1/0.2	1.20/1.46	90/103
		ABS	<i>Acrylonitrile butadiene styrene</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 +20/40 FR		70/80	2	200/250	50/80	1000/2800	0.1/0.2	1.22/1.36	90/110
	CAB	<i>Cellulose Acetate Butyrate</i>	80	3	180/230	40/70	800/1200	0.4/0.7	1.16/1.22	60/110	
	ENGINEERING THERMOPLASTICS	PC	<i>Polycarbonate</i>	120	4/6	270/380	80/120	800/1400	0.5/0.7	1.19/1.20	120
		PPO	<i>Polyphenylene Oxide</i>	80/120	2	260/300	80/110	1000/1400	0.5/0.7	1.06/1.10	-40/+120
		TPU	<i>Thermoplastic Urethane</i>	100/110	2	190/230	20/30	400/1000	0.2/2	1.14/1.26	-40/+80
HIGH PERFORMANCE THERMOPLASTICS	PSU	<i>Polysulfone</i>	135/150	3/4	310/390	95/115	1000/1500	0.7/0.8	1.24	-100/+180	
	PEI	<i>Polyetherimide</i>	150	4	340/425	100/150	800/2000	0.5/0.7	1.27/1.42	-200/+260	
	PES	<i>Polyethersulfone</i>	135/150	3/4	340/390	120/160	1000/1500	0.6	1.37	200	

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SEMI-CRYSTALLINE PLASTICS	COMMODITY THERMOPLASTICS	PP	Polypropylene	-	-	200/300	20/90	700/1400	1/2.5	0.9/0.91	46/60
		PP +40FR		-	-	200/300	20/90	700/1400	0.2/0.8	1.22/1.23	60/90
		LDPE	Low Density Polyethylene	-	-	160/240	20/70	500	1.5/3.5	0.92/0.94	80/95
		HDPE	High Density Polyethylene	-	-	180/300	10/90	1200	2/4	0.94/0.96	80/105
	ENGINEERING THERMOPLASTICS	PA 11	Polyamide	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	Polybutylene Terephthalate	120	4	230/280	40/80	560/1800	1.5/2.0	1.31/1.38	49/120
		POM	Polyoxymethylene	10	2	180/230	50/120	800/1700	1/3.5	1.41/1.42	90
		POM +25FR		110	2	180/230	50/120	800/1700	0.4	1.61	104
		PET	Polyethylene Terephthalate	75/90	3/4	260/290	30/140	1000 /1700	1/2	1.37	-40/+110
	HIGH PERFORMANCE THERMOPLASTICS	PPS	Polyphenylene Sulfide	150/170	4	300/360	40/200	750/1500	0.7	1.34	230
		FEP	Fluorinated Ethylene Propylene	-	-	330/420	-	-	3/6	2.10/2.20	260/280
		LCP	Liquid crystal polymer	150/160	4	285/330	100/150	140/400	0.1/1	1.4/1.9	220/240
		PEEK	Polyether Ether Ketone	150	3	370/390	160/170	700/1400	0.7/1.2	1.30	250