Kunststoffgranulate
• Compoundieren
• Regranulieren
• Lohnverarbeitung

MKV® Kunststoffgranulate

Processing Recommendations for Injection Moulding

The recommendations given are for the following engineering thermoplastics:

• Polyamide 6	Ziamid B
• Polyamide 6.6	Ziamid A
• ABS	Zialan
• POM	Ziaform
• PBT	Ziadur
• PC	Ziabre
• PC/ABS	Ziablend
• PPO	Zianyl

Tool Temperatures

Herebelow find a general overview:

Material	Tool Temperature
ABS	50-80 °C
PC/ABS	70-100 °C
Polycarbonate	80-100 °C
Polycarbonate GF-reinforced	80-130 °C
Polyamide 6	50-80 °C
Polyamide 6 GF-reinforced	80-120 °C
Polyamide 6.6	70-90 °C
Polyamide 6.6 GF-reinforced	80-120 °C
PBT	60-80 °C
PBT GF-reinforced	80-100 °C
POM	60-90 °C
PPO	80-120 °C

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Melt Temperatures

Here below find a general overview:

Material	Melt Temperature
ABS	220 – 260 °C
Polycarbonate	280 – 320 °C
Polycarbonate GF-reinforced	310 – 330 °C
Polyamide 6	240 – 270 °C
Polyamide 6 GF-reinforced	260 – 290 °C
Polyamide 6.6	280 – 300 °C
Polyamide 6.6 GF-reinforced	285 – 310 °C
PBT	245 – 270 °C
PBT GF-reinforced	250 – 270 °C
POM	180 – 220 °C
POM GF-reinforced	190 – 220 °C
PPOm	280 - 300 °C

Pre Drying

Herebelow please find a general overview of drying temperatures and times:

Material	Temperature (°C)	Hot-Air Dryer (h)
ABS	80	2-3
PC	120	4-6
PC/ABS	100-120	3-4
PA *	80	4-6
PBT	120	3-4
POM	110	3-4
PPO	80-100	2-3

* Drying time is very dependent on material moisture content

The data presented are given earnestly and in good faith. The values reported are influenced by processing conditions, modifications, additives and environmental influences. The customer is advised to carry out his own tests to ensure that any particular material is suitable for the application in mind. No legal liability can be accepted for the guarantee of any data reported.