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Plastics processing, mold making

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Plastics Properties

Material	ABS	PA6	PA6/Gf30	PA6.6	PA6.6/Gf30	PC	LDPE
Density g/cm ³	1,05	1,13	1,35	1,14	1,36	1,20	0,92
Operating temperature Without load							
Short-term approx.	100 °C	160 °C	200 °C	200 °C	230 °C	140 °C	90 °C
Long-term approx.	80 °C	90 °C	120 °C	100 °C	120 °C	125 °C	70 °C
Thermostability							
HDT/A 1.8 Mpa approx.	98 °C	65 °C	210 °C	75 °C	240 °C	130 °C	/
Flammability UL 94							
Resistant to							
Greases/oils	+	+	+	+	+	+	+
Esters/alcohol	-/+	+	+	+	+	-/+	-/+
Acids	+	+	+	+	+	+	+
Bases	+	-	-	-	-	0	+
Free from							
Silicon	+	+	+	+	+	+	+
CFC's	+	+	+	+	+	+	+
Heavy metal	+	+	+	+	+	+	+
Dioxins and Furanes	+	+	+	+	+	+	+
PCB's and PCT's	+	+	+	+	+	+	+
Halogens	+	+	+	+	+	+	+
Asbestos	+	+	+	+	+	+	+
Further processing							
Painting	++	+	+	+	+	0	-
Printing	++	+	+	+	+	+	0
Gluing	++	+	+	+	+	0	-

Material	HDPE	POM	PP	PSN	PSI	PVC/Weich	TPU
Density g/cm ³	0,96	1,41	0,90	1,05	1,05	1,2-1,4	1,25
Operating temperature							
Without load							
Short-term approx.	100 °C	100 °C	100 °C	80 °C	85 °C	70 °C	120 °C
Long-term approx.	90 °C	80 °C	90 °C	70 °C	70 °C	60 °C	86 °C
Thermostability							
HDT/A 1.8 Mpa approx.	49 °C	100 °C	55 °C	86 °C	85 °C	/	47 °C
Flammability UL 94							
Resistant to							
Greases/oils	+	+	-/+	-/+	-/+	0	+
Esters/alcohol	+	+	-/+	-/+	-/+	0	+
Acids	+	-	+	+	+	0	+
Bases	+	0	+	+	+	0	+
Free from							
Silicon	+	+	+	+	+	+	+
CFC's	+	+	+	+	+	+	+
Heavy metal	+	+	+	+	+	0	+
Dioxins and Furanes	+	+	+	+	+	+	+
PCB's and PCT's	+	+	+	+	+	+	+
Halogens	+	+	+	+	+	0	+
Asbestos	+	+	+	+	+	+	+
Further processing							
Painting	-	0	-	++	++	-	0
Printing	0	0	0	++	++	-	0
Gluing	-	0	-	++	++	0	0

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