Isoter®

Dafnelac®

Document	Process Data for Injection Moulding
Description	**ABS – ASA - SAN**
Application	Injection Moulding

Structure	Amorphous	
General Properties	Hard, tenacious down to – 40°C. Resistant to temperature variations. Low hygroscopicity. Low chemical resistance.	
Barrel Temperature	(decrease 20°C for Flame Retardant grades, V0/V2/FXC/FXB)	
	Feed Zone	40 – 60 °C
	Zone 1	160 – 180 °C
	Zone 2	180 – 230 °C
	Zone 3	210 – 250 °C
	Zone 4	210 – 250 °C
	Zone 5	210 – 250 °C
	Nozzle	210 – 240 °C
Melt temperature	210 – 240 °C	
Mould temperature	40 –80 °C	
Injection pressure	1000 – 1500 bar	
Post-pressure	Between 30 and 60% of injection pressure, low post-pressure time	
Counterpressure	50 – 150 bar	
Injection speed	Suggested profile: medium-high	
Screw speed	Equal to peripheric speed of 0.6 m/s	
Metering	0.5 –4.0 diameters	
Cushion	2 – 8 mm, depends on metering and screw diameter	
Drying	0.5 - 2 hours at 80°C	
Recycle	30% of regrinded material. This percentage decreases for technical and aesthetic parts. Not recommended for Flame Retardant grade	
Shrinkage	0.4 – 0.7% (for unfilled product)	
Barrel equipment	Standard screw, non-return valve, free-flow nozzle	
Quenching	Not necessary to purge with other materials. Purge with natural ABS product suggested after Flame Retardant processing.	

Attention: in Flame Retardant grade, off-gas products produced during processing can be irritants to the mucous membranes, therefore adequate ventilation and aspiration is recommended

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