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- plastic wear parts
- machine parts made of plastic
- customers advice
- material development
- design of component parts
- prototype production
- large scale production

Gleitlager aus Kunststoff

Injection molding instruction for polyblend ZX-410

predrying with dry air:

Step1: 80°C-100°C: 6-8 hours

Step2: 150°C: 4-6 hours

(continiously drying during processing)

temperatures:

material temperature

possible values:

360-400°C

mold temperature 140°C

90-170°C

feed header 100°C

90-120°C

barrel temperature:

zone 1 (feed zone):

350-390°C:

zone 2:

360-400°C

zone 3:

370-410°C

zone 4:

370-410°C

zone 5:

360-400°C

zone 6:

350-400°C

zone 7:

350-400°C

injection pressure:

1500-2000 bar

back pressure:

60-100 bar

holding pressure:

1000-1500 bar

screw configuration:

compression rating

1,5-3,0:1,0

relation length/diameter:

16-24:1 L/D

injection rate:

medium to quick

locking pressure:

600-800 bar

screw speed:50-200 rotations/
min**purging compound:**

glass fiber reinforced polycarbonate (PC)

Start cleaning process at processing temperature
and reduce barrel temperatures gradually during
cleaning.

The mass temperature should be kept in the lower part of the temperature range and should not reach the 400°C.