

THERMOLAST K in Injection Moulding: Shrinkage

Shrinkage

Due to the anisotropic behaviour of THERMOLAST K compounds, shrinkage normally differs in relation to the flow direction in moulding. Our engineering staff can assist you in design of your moulds and will provide shrinkage data for injection-moulded plaques fabricated under various conditions.

Please note that shrinkage values from laboratory samples will not correlate on a 1:1 basis with values obtained in practice as shrinkage can be influenced by a large number of factors:

- ▶ processing parameters
- ▶ runner system (hot runner / cold runner)
- ▶ mould temperature
- ▶ mould design
- ▶ part geometry
- ▶ melt temperature
- ▶ flow direction
- ▶ material processed

Effects on shrinkage when injection moulding conditions are changed:

	Changes in injection moulding conditions	Effect on shrinkage
ΔT melt - mould	▲	▲
cooling time in mould	▲	▼
mould temperature	▲	▲
injection rate	▲	▼
hold pressure	▲	▼

Our applications engineering department will be happy to provide further information on the shrinkage values of individual compounds upon request.