

PROCESSING GUIDE

Injection Moulding

THERMOLAST® K compound series generally used in the fields of:
Consumer, Care, Medical, Toys, Sports

THERMOLAST K®	Description	Barrel Temperatures						Max.		Mould Temp.		Hot Runner Temp.		Injection Rate	Pre drying °C/°F
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C	°F		
FD/n Series	Conforming to BfR, FDA, 2002/72/EC, natural	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	medium	not necessary
FD/tl Series	Conforming to BfR, FDA, 2002/72/EC, translucent	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	medium	not necessary
FD/ht Series	Conforming to BfR, FDA, 2002/72/EC, high transparency	180	355	200	390	220	425	250	480	15 - 60	60 - 140	180 - 220	355 - 425	medium	not necessary
FD/HM/tl Series	Conforming to BfR, FDA, 2002/72/EC, high mechanical performance, translucent	200	390	220	425	240	465	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
FD/HM/t Series	Conforming to BfR, FDA, 2002/72/EC, high mechanical performance, transparent	180	355	200	390	220	425	250	480	25 - 40	75 - 105	180 - 220	355 - 425	medium	not necessary
FD/M Series	Conforming to BfR, FDA, 2002/72/EC, medical applications	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
FD/UV/t Series	Conforming to BfR, FDA, 2002/72/EC, outdoor sports/games applications, transparent	180	355	200	390	220	425	250	480	25 - 40	75 - 105	180 - 220	355 - 425	medium	not necessary
FD/S Series	Conforming to BfR, FDA, 2002/72/EC, super soft	140	280	160	320	180	355	220	425	25 - 40	75 - 105	160 - 180	320 - 355	medium to low	not necessary
EF Series	Conforming to BfR, FDA, 2002/72/EC, elastic film	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary

PROCESSING GUIDE

Injection Moulding

THERMOLAST® compound series generally used in the fields of:

Automotive, Appliances, Electronics, Construction, Design, Industries

THERMOLAST® K	Description	Barrel Temperatures						Max.		Mould Temp.		Hot Runner Temp.		Injection Rate	Pre drying °C
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C	°F		
GP/HM Series	General purpose, high mechanical performance	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
GP/LD/b Series	Automotive interior applications, low density, black	180	355	200	390	220	425	250	480	25 - 40	75- 105	200 - 250	390 - 480	high	not necessary
UV/LD/b Series	Automotive exterior applications, low density, black	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
CS Series	Optimized compression set	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
FR Series	Flame retardant	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	2h at 80/175*
MR Series	Microbe resistant and fungicide	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary

*recommended

THERMOLAST® V	Description	Barrel Temperatures						Max.		Mould Temp.		Hot Runner Temp.		Injection Rate	Pre drying °C
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C	°F		
GP/LP Series	General purpose, long-term performance	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary

PROCESSING GUIDE

Extrusion

THERMOLAST K®	Description	Barrel Temperatures						Extruder Connector		Die Temp.		Maximum		Pre drying
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C/°F		
UV/LD/b Series	Automotive exterior applications, low density, black	160	320	170	340	180	355	180	355	180	355	220	425	generally not necessary
GP/HM Series	General purpose, high mechanical performance													
	25 - 55 Shore A	140	285	150	300	160	320	170	340	180	355	210	410	generally not necessary
	60 - 95 Shore A	160	320	170	340	180	355	180	355	180	355	220	425	generally not necessary
EX Series	Extrusion													
	30 - 55 Shore A	140	285	150	300	160	320	170	340	180	355	210	410	generally not necessary
	60 - 90 Shore A	160	320	170	340	180	355	180	355	180	355	220	425	generally not necessary
EX/UV Series	Extrusion, outdoor applications	160	320	170	340	180	355	180	355	180	355	220	425	generally not necessary
FR Series	Flame retardant	160	320	170	340	180	355	180	355	180	355	220	425	2h at 80/175*
Film Series	Conforming to Bfr, FDA, 2002/72/EC, elastic film	150	300	160	320	170	340	180	355	180	355	230	445	generally not necessary
FD/M Series	Conforming to Bfr, FDA, 2002/72/EC, medical applications	160	320	170	340	180	355	180	355	180	355	220	425	generally not necessary

* recommended

THERMOLAST® V	Description	Barrel Temperatures						Extruder Connector		Die Temp.		Maximum		Pre drying
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C/°F		
GP/LP Series	General purpose, long-term performance	160	320	170	340	180	355	180	355	180	355	220	425	generally not necessary

PROCESSING GUIDE

Coextrusion

THERMOLAST® K		Description	Barrel Temperatures				Extruder Connector		Die Temp.		Maximum		Pre drying		
			°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C/°F		
UV/LD/b	Series	Automotive exterior applications, low density, black Adhesion to PP	160	320	170	340	180	355	180	355	180	355	220	425	2h at 80/175*
GP/HM	Series	General purpose, high mechanical performance	140	285	150	300	160	320	170	340	180	355	210	410	2h at 80/175*
		Adhesion to PP 25 - 55 Shore A 60 - 95 Shore A	160	320	170	340	180	355	180	355	180	355	220	425	2h at 80/175*
EX	Series	Extrusion													
		Adhesion to PP and PE 30 - 55 Shore A 60 - 90 Shore A	140	285	150	300	160	320	170	340	180	355	210	410	2h at 80/175*
EX/UV	Series	Extrusion, outdoor applications Adhesion to PP	160	320	170	340	180	355	180	355	180	355	220	425	2h at 80/175*
CO/1VT/CS	Series	Adhesion to PC, ABS, PETG, optimized compression set	160	320	170	340	180	355	180	355	180	355	250	480	2h at 80/175
FD/M	Series	Conforming to Bfr, FDA, 2002/72/EC, medical applications Adhesion to PP	160	320	170	340	180	355	180	355	180	355	220	425	2h at 80/175*

* recommended

THERMOLAST® V		Description	Barrel Temperatures				Extruder Connector		Die Temp.		Maximum		Pre drying		
			°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C/°F		
GP/LP	Series	General purpose, long-term performance Adhesion to PP	160	320	170	340	180	355	180	355	180	355	220	425	generally not necessary

* recommended

PROCESSING GUIDE

Coinjection Moulding (with Coinjection Machine)

THERMOLAST® K compound series generally used in the fields of:

Consumer, Care, Medical, Toys, Sports

THERMOLAST K®	Description	Barrel Temperatures						Max.		Mould Temp.		Hot Runner Temp.		Injection Rate	Pre drying °C/°F						
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C	°F								
FD/n	Series	Conforming to BfR, FDA, 2002/72/EC natural						180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	medium	not necessary
FD/tl	Series	Conforming to BfR, FDA, 2002/72/EC translucent																			
		Adhesion to PP						180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	medium	not necessary
FD/ht	Series	Conforming to BfR, FDA, 2002/72/EC high transparency																			
		Adhesion to PP						180	355	200	390	220	425	250	480	15 - 60	60 - 140	180 - 220	355 - 425	medium	not necessary
FD/HM/tl	Series	Conforming to BfR, FDA, 2002/72/EC, high mechanical performance, translucent																			
		Adhesion to PP						200	390	220	425	240	465	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
FD/HM/t		Conforming to BfR, FDA, 2002/72/EC, high mechanical performance, transparent																			
		Adhesion to PP						180	355	200	390	220	425	250	480	25 - 40	75 - 105	180 - 220	355 - 425	medium	not necessary
FD/CO/1VT	Series	Conforming to BfR, FDA, 2002/72/EC, adhesion to PC, ABS, PETG						200	390	220	425	240	465	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	2h at 80/175
FD/CO/2VT	Series	Conforming to BfR, FDA, 2002/72/EC, adhesion to SAN, ASA, PMMA						160	320	180	355	200	390	220	425	25 - 40	75 - 105	180 - 220	355 - 425	high	2h at 80/175
FD/M	Series	Conforming to BfR, FDA, 2002/72/EC, medical applications																			
		Adhesion to PP						180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
FD/UV/t	Series	Conforming to BfR, FDA, 2002/72/EC, outdoor sports/games applications, transparent																			
		Adhesion to PP						180	355	200	390	220	425	250	480	25 - 40	75 - 105	180 - 220	355 - 425	medium	not necessary
FD/S	Series	Conforming to BfR, FDA, 2002/72/EC, supersoft																			
		Adhesion to PP						140	280	160	320	180	355	220	425	25 - 40	75 - 105	160 - 180	320 - 355	medium to low	not necessary

PROCESSING GUIDE

Coinjection Moulding (with Coinjection Machine)

THERMOLAST® compound series generally used in the fields of:
Automotive, Appliances, Electronics, Construction, Design, Industries

THERMOLAST® K	Description	Barrel Temperatures						Max.		Mould Temp.		Hot Runner Temp.		Injection Rate	Pre drying °C/F
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C	°F		
GP/HM Series	General purpose, high mechanical performance Adhesion to PP	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
GP/LD/b Series	Automotive interior applications, low density, black Adhesion to PP	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
UV/LD/b Series	Automotive exterior applications, low density, black Adhesion to PP	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
CS Series	Optimized compression set Adhesion to PP	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
CO/1VT Series	Adhesion to PC, ABS, PETG	180	355	210	410	240	465	250	480	40 - 60	105 - 140	220 - 250	425 - 480	high	2-4h at 60-80/140-175
CO/2VT Series	Adhesion to SAN, ASA, PMMA	160	320	180	355	200	390	220	425	40 - 60	105 - 140	180 - 220	355 - 425	high	2-4h at 60-80/140-175
CO/3VT Series	Adhesion to SAN, ASA, PMMA	200	390	220	425	230	450	240	465	40 - 60	105 - 140	180 - 220	355 - 425	high	2-4h at 60-80/140-175
CO/1VT/CS Series	Adhesion to PC, ABS, PETG, optimized compression set	180	355	210	410	240	465	250	480	40 - 60	105 - 140	220 - 250	425 - 480	high	2-4h at 60-80/140-175
CO/PA Series	Adhesion to PA														
	to PA 6	240	465	260	500	270	520	280	535	40 - 60	105 - 140	max. 280	max. 535	high	2-4h at 60-80/140-175
CO/PA/CS Series	Adhesion to PA														
	to PA 6.6 and Polyarylamide	255	490	270	520	280	535	290	555	40 - 60	105 - 140	max. 290	max. 555	high	2-4h at 60-80/140-175
CO/PA/CS Series	Adhesion to PA														
	optimized compression set to PA 6	240	465	260	500	270	520	280	535	40 - 60	105 - 140	max. 280	max. 535	high	2-4h at 60-80/140-175
CO/PA/CS Series	Adhesion to PA														
	to PA 6.6 and Polyarylamide	255	490	270	520	280	535	290	555	40 - 60	105 - 140	max. 290	max. 555	high	2-4h at 60-80/140-175
CO/POM Series	Adhesion to POM (Hostaform®, Celcon, Duracon)	215	420	240	465	265	510	270	520	80 - 110	175 - 230	250 - 265	480 - 510	high	2-4h at 60-80/140-175
FR Series	Flame retardant Adhesion to PP	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	hoch	2h at 80/175*
MR Series	Microbe resistant and fungizide														
	Adhesion to PP	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary
MR Series	Adhesion to PA	240	465	260	500	270	520	280	535	40 - 60	105 - 140	200 - 250	390 - 480	high	2-4h at 60-80/140-175

*recommended

THERMOLAST® V	Description	Barrel Temperatures						Max.		Mould Temp.		Hot Runner Temp.		Injection Rate	Pre drying °C/F
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C	°F		
GP/LP Series	General purpose, long-term performance Adhesion to PP	180	355	200	390	220	425	250	480	25 - 40	75 - 105	200 - 250	390 - 480	high	not necessary

THERMOLAST® A	Description	Barrel Temperatures						Max.		Mould Temp.		Hot Runner Temp.		Injection Rate	Pre drying °C/F
		°C	°F	°C	°F	°C	°F	°C	°F	°C	°F	°C	°F		
UV/CO/1VT Series	Outdoor applications with adhesion to PC, PC/ABS and better scratch resistance Adhesion to PC, PC/ABS	180	355	210	410	240	465	250	480	40 - 60	105 - 140	220 - 250	425 - 480	high	2-4h at 60-80/140-175