

Material:	Diametro (in)
ABS, SAN	0.187-0.375
Acetal	0.125-0.375
Acrylic	0.312-0.375
Impact acrylic	0.312-0.500
Cellulose acetate	0.187-0.437
Cellulose acetate butyrate	0.187-0.375
Cellulose propionate	0.187-0.375
Ionomer	0.090-0.375
Nylon	0.062-0.375
Polyallomers	0.187-0.375
Polycarbonate	0.187-0.375
Polyethylene	0.062-0.375
Polypropylene	0.187-0.375
Polyphenylene oxide	0.250-0.375
Polysulfone	0.250-0.375
Polystyrene	0.125-0.375
Polyvinylidene Fluoride	0.125-0.312
Polyvinyl chloride (plasticized)	0.125-0.375

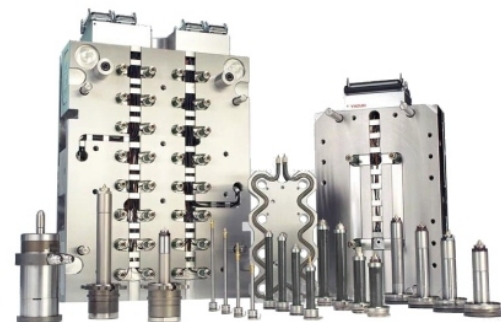
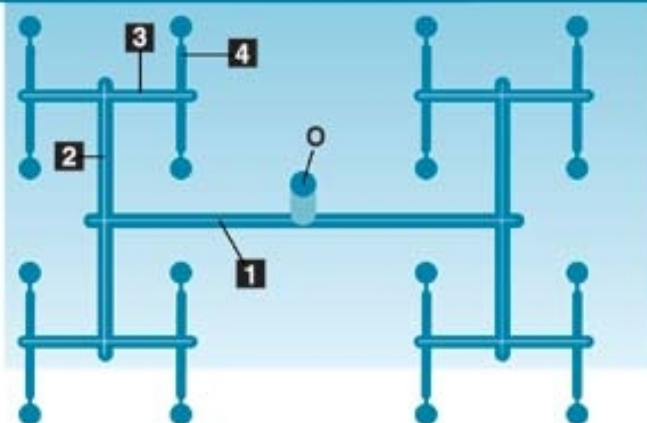


Table 1. Runner diameters in a balanced mold

	Amorphous materials (styrene, SAN, acrylic, ABS, PC, PES)	Semicrystalline materials (PE, PP, nylon, acetal, PBT)
Sprue O-diameter	.350 inch	.275 inch
Nozzle orifice	.325 inch	.250 inch
1) Main runner	.300 inch	.225 inch
2) Second-level runner	.275 inch	.200 inch
3) Third-level runner	.250 inch	.175 inch
4) Fourth-level runner	.225 inch	.150 inch

(measurements based on a part thickness of .100 inch)



¡Tú futuro empieza hoy!