

## Special Information on Coinjection Moulding: Bounds options

### Coinjected Composite Systems

Evaluation of adhesion quality is normally highly subjective. As a uniform test procedure for adhesion evaluation has not yet been established, comparison of different materials by test data alone is often unreliable. On request we will be happy to provide coinjected sample plaques made with materials you wish to evaluate.

A number of factors can significantly influence THERMOLAST K adhesion results including the manufacturing process and process parameters used, part geometry and composition of the hard material. We therefore strongly recommend tests under the actual conditions prevailing in the application.

Please also note that the final adhesion quality is only achieved after a storage period of approximately 24 h.

Our application engineering department can provide advice on design, material selection and tests.

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THERMOLAST K adhesion compounds are available for the following thermoplastics:

THERMOPLASTIC	Adhesion Bond Quality In Coinjection Moulding with THERMOLAST K	Transfer Processes Providing Good Adhesion Results	
ABS	> 35 Sh A		•
ABS transparent	> 45 Sh A		•
ABS/PC	> 35 Sh A		
CAB	> 45 Sh A		
CAP	> 45 Sh A		
HIPS	> 40 Sh A		•
PA 12	> 25 Sh A		•
PA 6	> 25 Sh A		•
PA 6.6	> 25 Sh A		
PBT	> 45 Sh A		•
PC	> 35 Sh A		
PC/PBT	> 45 Sh A		
PC/PET	> 45 Sh A		
PE	> 30 Sh A		
PET	> 45 Sh A		
PETG	> 45 Sh A		
PMMA	> 45 Sh A		
PMP	> 25 Sh A		
POM (Hostaform, Duracon, Celcon; Ticona)	> 45 Sh A		
PP	> 5 Sh A		
PPO/PS	> 50 Sh A		•
PS	> 45 Sh A		•
SAN	> 35 Sh A		
ASA	> 45 Sh A		

Description of quality

Adhesion quality

Very good adhesion, separation in cohesive mode	
Good adhesion, separation in adhesive mode, TPE is difficult to pull off	

Good results possible in robotic or manual transfer processes (insert moulding) **without** intermediate storage.

Good results possible in transfer processes (insert moulding) **with** intermediate storage

Preheating of semi-finished part recommended.

Table Composite Systems