Offer of free capacities for injection moulding of plastics in clean rooms GAMA GROUP

We offer free capacities for injection moulding in clean room, Class 8 ISO.

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Injection moulding technology

INJECTION MOULDING MACHINES

Type	QTY	Screw diameter	Max. clamping force
ENGEL VC 200/50	5	30 or 35 mm	500 kN
ENGEL VC 330/80	3	35 mm	800 kN
KrausMaffei ClassiX CX 80-380	1	35 mm	800 kN
KrausMaffei ClassiX CX 160-380	1	35 mm	1600 kN

USED MATERIALS

Material	Type of plasticizer	Hardness Shore A
soft polyvinylchloride (soft PVC)	DEHP Bis (2-Ethylhexyl) Phthalate	61 87 93
	DEHT Bis (2-Ethylhexyl) Terephthalate	61 87 93
	TOTM (TEHTM) Tris (2-Ethylhexyl) Trimellitate	87 93
rigid polyvinylchloride (rigid PVC)		
polypropylene (PP)		
low density polyethylene (LDPE)		
high density polyethylene (HDPE)		
polystyrene (PS)		
acrylonitrile butadiene styrene (ABS)		
methyl methacrylate-acrylonitrile-butadiene-styrene (MABS)		
polycarbonate (PC)		
polyoxymethylene (POM)		
thermoplastic elastomer (TPE)		

Drying of material	QTY
vacuum drying machine	3
hot air drying machine	1

Peripheral equipment	QTY
heating unit	6
hot runner controller	4
colouring unit for dosing of masterbatch	8

Extrusion technology

EXTRUSION LINES

Type	QTY	Screw diameter
Bausano TM 60/25	1	60 mm
Betol BC 50	1	50 mm

USED MATERIALS

Material	Plasticizer	Hardness Shore A
soft polyvinylchloride (soft PVC)	DEHP Bis (2-Ethylhexyl) Phthalate	61 75 85
	DEHT Bis (2-Ethylhexyl) Terephthalate	61 70 75 85
	TOTM (TEHTM) Tris (2-Ethylhexyl) Trimellitate	61 75 85 92

MEDICAL TUBES

Concurrently 52 produced tube dimensions

Standard tolerance of inner and outer diameter of tubes: ± 0,1 mm

Material	Tube dimensions			
	Inner diameter (mm)		Outer diameter (mm)	
	min.	max.	min.	max.
soft polyvinylchloride	0,9	8,0	1,6	12,0

Winding of tubes to coils	Length of coil (m)	
	min.	max.
	20	1000

Cutting of tubes	Tube length (mm)	
	min.	max.
	10	3000

Standard length tolerances of cut tubes	
Tube length (mm)	Tube length tolerance (mm)
10 – 100	+/- 1
101 – 200	+/- 3
201 - 400	+/- 5
401 – 600	+/- 7
601 – 900	+/- 10
901 – 1200	+/- 12
1201 – 1500	+/- 15
1501 – 2000	+/- 20
2001 - 3000	+/- 30

Assembly technology

Technology	Specification
Gluing	Cyclohexanon (resolvent) Dichlormethan (resolvent) Cyanoacrylic UV glue
Welding	High frequency welding (VF)
Assembly	Manual Semi-automatic (Ergoline, Stroza) Automatic (Tecnofar, Tecnocut, Tecnoideal, Aunotec)

Packaging technology

Machine MULTIVAC

Packaging dimensions	Form multiplicity
300 x 200 mm	2
130 x 300 mm	3
225 x 100 mm	4
150 x 100 mm	8
57 x 75 mm	21

Packaging materials	Specification
paper	60 g/m^2
foil	60 µm (material PP/PA/PE)
foil	80 µm (material PP/PA/PE)
foil	100 µm (material PP/PA/PE)

MARKING

- ❒ With label
- ❒ Printing (AMACO) – colour according to requirement of customer (black, blue, green, ...)

Manual packaging

- ❒ Material, marking and dimensions according to requirement of customer

Sterilization

- ❒ Gas EtO (Ethylenoxide)