

# Distrupol

A Univar company

[www.distrupol.com](http://www.distrupol.com)

## Types of 2K Machines

## Types of 2K Technology

2K machine and  
One mould



### Insert/Over moulding

- **Two machines and Two moulds:**

Mould on one machine (one tool), transfer part to a second machine (second tool) and overmould.

- **2K machine and One mould with two gates:**

Two step process. Injection of second material after (rotation of the mould/platen).

- **2K machine and One mould with two gates:**

Two step process. Injection of second material after removal of sliding core.

2K machines and one  
mould (sliding core)



Simultaneous  
Multi Shot Moulding



### Simultaneous Multi Shot Moulding

- **2K machine and One mould with Two gates.**

One step process. Injection of both materials takes place at the same time

Sandwich  
Multi Shot Moulding



### Sandwich Multi Shot Moulding

2K machine and One mould with One gate.

Injection of both materials take place nearly at the same time.

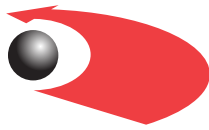
Interval  
Multi Shot Moulding



### Interval Multi Shot Moulding

2K machine and One mould with One gate.

Injection of both materials takes place alternately.



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## A Rough Guide to material compatibility

- + Good combination
- o Poor combination
- No combination

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	ABS	ASA	CA	EVA	PA 6	PA 6.6	PC	PE-HD	PE-LD	PMMA	POM	PP	PPE+PS	PS-GP	PS-HI	PBTP	TPU	PVC-W	SAN	TPR	PETP	PVAC	PPSU	PC-PBTP	PC-ABS
ABS	+	+	+				+	o	o	+		o	o	o	o	+	+	+	+		+	-		+	+
ASA	+	+	+	+			+	o	o	+		o	o	o	o	+	+	+	+			-		+	+
CA	+	+	+	-				o	o			o	o	o	o	+	+	+	+						
EVA		+	-	+				+	+			+	+				o	o							
PA 6					+	+	-	+	+	+		-		o	o		+								
PA 6.6					+	+		+	+	+		-		o	o		+								
PC	+	+				-	+	o	o	-	+	o	o	o	o	+	+	+	+		+		+	+	+
PE-HD	o	o	o	+	-	-	o	+	+	+	-	o	o	o	o	o	o	o	-	o				o	o
PE-LD	o	o	o	+	-	-	o	+	+	+	-	+	o	o	o	o	o	o	o	o				o	o
PMMA	+	+					-	+	+	+	+	-	o	o	o			+	+						
POM								+	+	+	+	-	o	o	o				+						
PP	o	o	o	+	-	-	o	+	+	-	+	+	-	o	o	o	o	o	-	o	+			o	o
PPE+PS	o	o	o									+	+	+	+	o	o	o	o	o				o	o
PS-GP	o	o	o	+	o	o	o	o	o	o	o	o	+	+	+	+	o	o	-	o				o	o
PS-HI	o	o	o		o	o	o	o	o	o	o	o	+	+	+	+	o	o	-	o				o	o
PBTP	+	+	+				+	o	o			o	o	o	o	o	+	+	+	+		+			
TPU	+	+	+	o	+	+	+	o	o			o	o	o	o	o	+	+	+	+		+			
PVC-W	+	+	+	o			+	-		+		-	o	o	o	o	+	+	+	+					+
SAN	+	+	+				+	o	o	+		o	o	o	o	o	+	+	+	+		+	-	+	+
TPR												+									+				
PETP	+						+										+	+		+	+			+	+
PVAC	-	-																	-			+			
PPSU							+																+		
PC-PBTP	+	+					+	o	o			o	o	o	o				+	+		+		+	+
PC-ABS	+	+					+	o	o			o	o	o	o				+	+	+	+			+

Contact Distrupol for more details