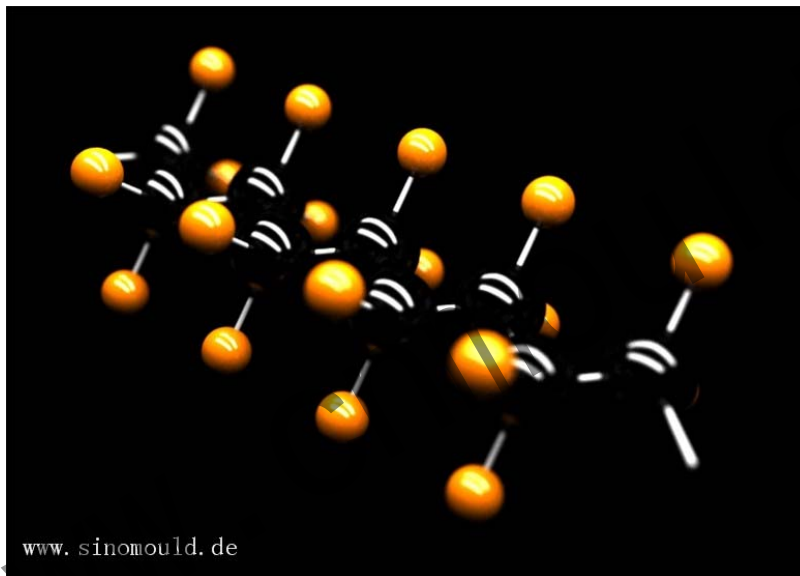


PVC plastic and pipe fitting mould

PCV (Vinyl Chloride), especially **rigid PVC**, is the most widely used plastic materials. It is mostly used in pipe fittings. Accordingly, there are many **pipe fitting** and **pipe fitting mould** suppliers. But producing pipe fittings or pipe fitting mould is not easy, content below will tell you the reasons.

- Structure

PVC has an amorphous structure with polar chlorine atoms in the molecular structure. Having chlorine atoms and the amorphous molecular



structure are inseparably related. Although plastics seem very similar in the context of daily use, PVC has completely different features in terms of performance and functions

compared with olefin plastics which have only carbon and hydrogen atoms in their molecular structures. And PVC materials are often added stabilizers, lubricants, auxiliary processing agents, pigments, anti-impact agents and other additives.

- Properties

PVC materials have Chemical stability because of its chlorine atoms. Furthermore, it own fire retarding properties, high strength, resistance to climate variability and excellent geometric stability.PVC has superior fire retarding properties due to its chlorine content, even in the absence of fire

retardants. And the heat released in burning is much lower than PE, and PP. Therefore, in the terms of safety, PVC is very suitable for people's daily lives. PVC have a nice resistance to climate variability .Under normal conditions of use, resistance to oxidation by atmospheric oxygen is the primary factor to judge whether it's durable or not. PVC is highly resistance to oxidative reactions because of the chlorine atom. In addition, PVC have a strong resistance on the reductant and acid.

- PVC process

The melting temperature of PVC is a very important process parameter in the processing time.

Incorrect parameter set will result in material decomposition. PVC have very poor flow characteristics and a very narrow scope of its technology. In particular, high molecular weight PVC material more difficult to process (this material is usually added to improve the

flow characteristics of lubricants), so commonly used are small molecular weight PVC material. PVC's shrinkage rate is very low, generally 0.2 to 0.6%.

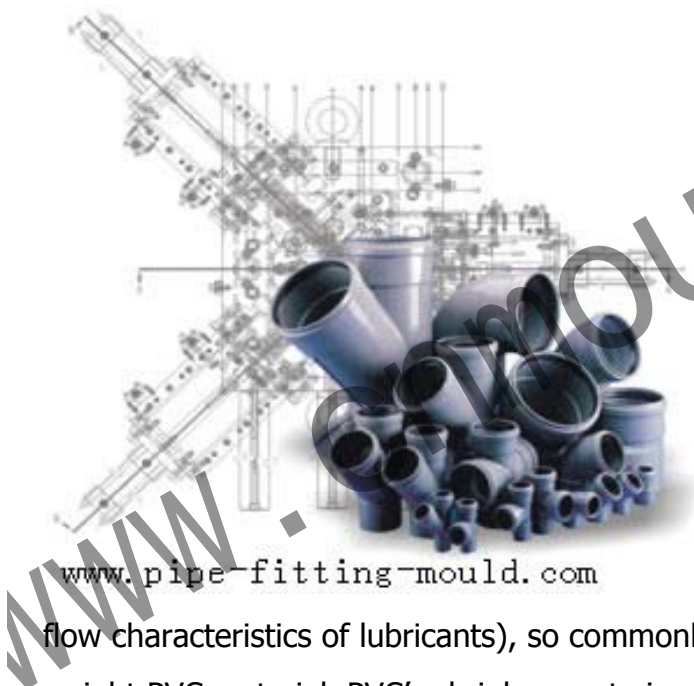
- Injection Moulding process conditions:

Drying: Drying is usually not required.

Melting temperature: 185 ~ 205C

Die temperature: 20 ~ 50C

Injection pressure: can be as large as 1500bar



Holding pressure: can be as large as 1000bar

Injection speed: in order to avoid material degradation, the general use of the injection speed must be considerable

Runner and the gate: all of the conventional gate can be used. When processing of smaller components, it's better to use pin-point gate or submarine gate; for thicker parts, it is best to use fan-shaped gate. The minimum diameter of the pin-point gate or submarine gate should be 1 mm; fan-shaped gate thickness can't less than 1mm.

- Typical uses

water supply pipes, home pipes, housing wall panels, business machine housing, [electronics packaging](#), [medical devices](#), [food packaging](#).



www.cnmould.com

[Sino Mould Co., Ltd](#), a professional [pipe fitting mould](#) manufacture, is good at producing PVC pipe fitting mould. And SINO MOULD keened on moulds

structures developing and innovating. They produce pipe fitting mould with collapsible cores, pipe fitting mould with curve sliding cores, pipe fitting mould with unscrewing cores, pipe fitting mould with normal mechanical or hydraulic direct sliding cores and so on.