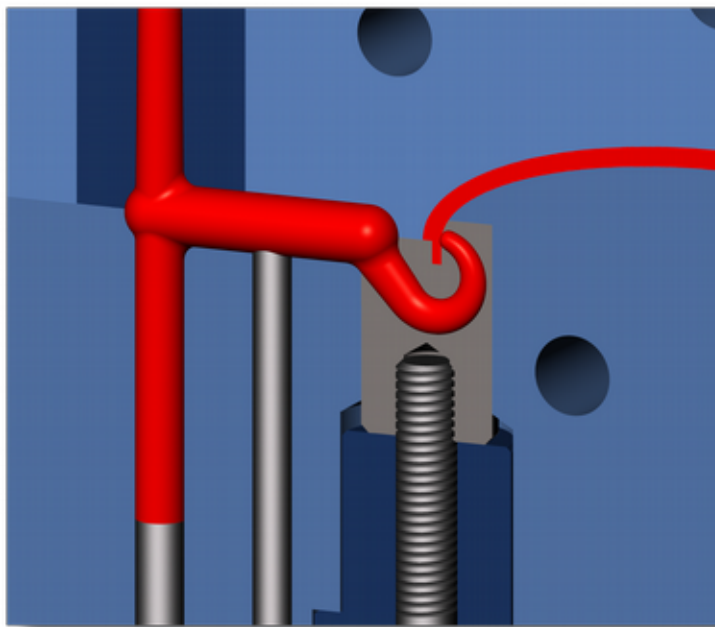




COMPONENT GUYS INC.

EXAflow®

Tunnel Gate Inserts



Midiflow



Maxiflow



Ringeflow



About us

1998 Development of the EXAflow® tunnel gate insert for injection moulding applications.

1998 EXAflow® inserts (Standardflow) are produced by mechanical machining and erosion processes.

2000 Market interest in EXAflow® gate inserts becomes so keen that an alternative production method is required. MIM tooling is built for the manufacture of EXAflow® inserts.

2001 The new EXAflow® inserts are produced by the metal injection moulding (MIM) process. Concurrently, a new product (Miniflow®) is being developed.

2003 An additional insert variant (Konturflow®) is introduced to supplement the product portfolio.

2004 Slide locks are included in the product range.

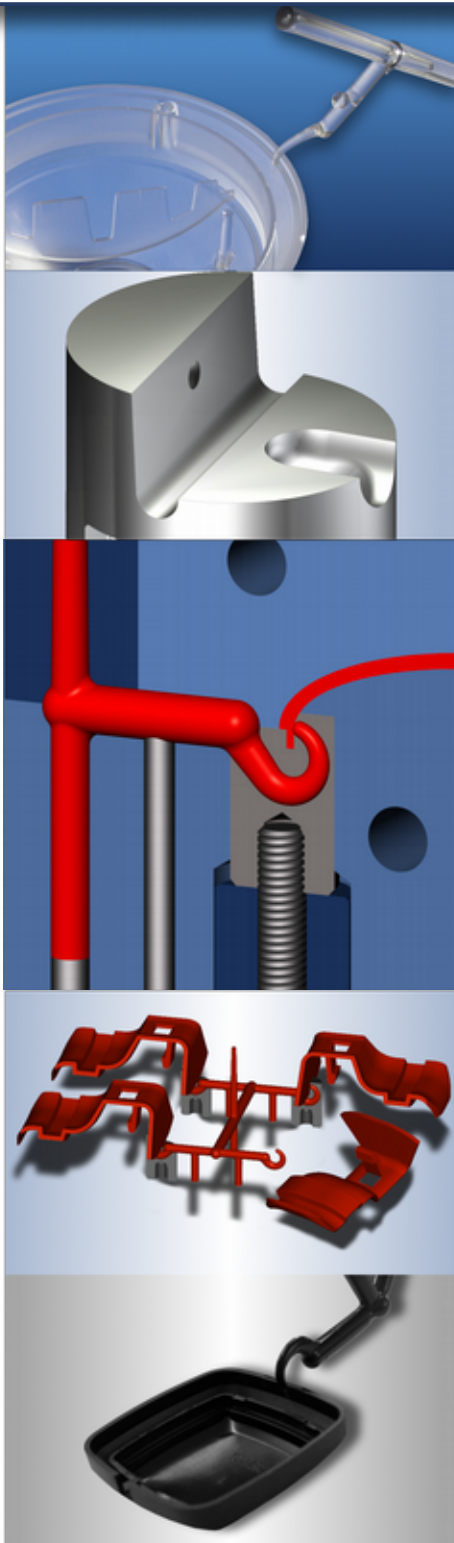
2005 To permit the design of new insert geometries, EXAflow® develops a special production method. Two new insert types, Ringelflow® and Maxiflow®, are launched.

2013 New insert types, Midiflow: GMK-1, GMK-2, GMK-3 are launched.



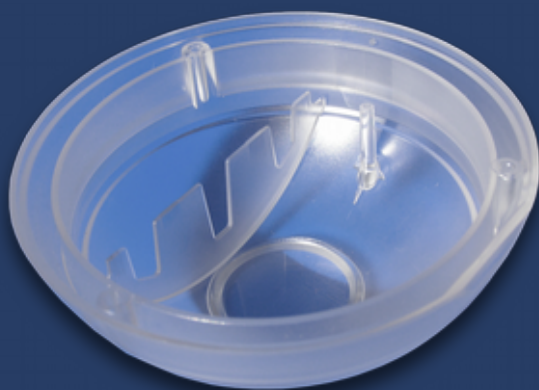
<i>About us</i>	2
<i>Table of contents</i>	3
<i>The benefits</i>	4
EXAflow[®] The original	5
<i>List of tunnel gate inserts</i>	6
Standardflow GTR	8
Standardflow GTE	10
Miniflow[®] - GTM und GTM	11
<i>Installation examples</i>	13
Konturflow[®] - GTK	19
<i>Calotte design</i>	20
Ringelflow[®] - GRF-1	23
Midiflow GMK	27
Maxiflow[®] - GXK	31
<i>Supporting ejector</i>	35
<i>Installation dimensions</i>	36
<i>Tables of viscosity</i>	39

The benefits



Benefit from our product advantages:

- Perfect surface quality and concealed gate marks through tunnel gating, even on rear molding wall thanks to innovative Ringelflow® technology
- Variable gate diameters from 0,5 to 3,5 mm
- Clearly defined separating edge for precise degating
- Save time and cost through fast & easy interchangeability
- High wear resistance
- Compact dimensions due to single-part design
- Enhances molding process reliability
- Unsurpassed balance in multiple gating applications



Injected by:

Ringelflow® - GRF-1

Material / Material: PC

Weight: 45 g Firma /

Company:

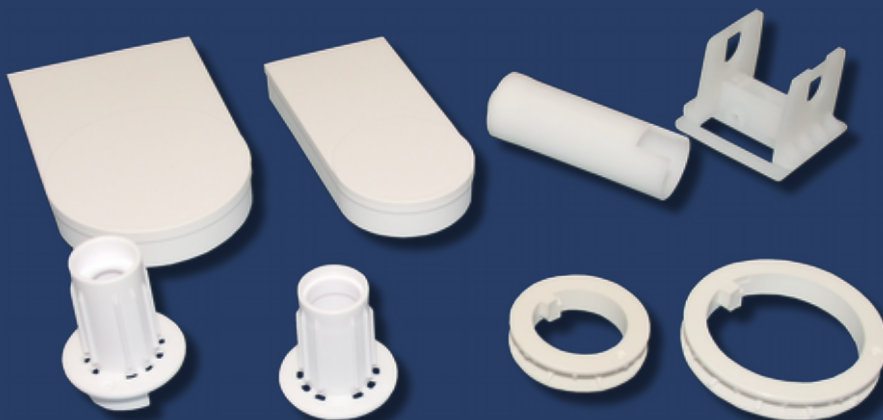
Rapp Kunststofftechnik GmbH
Pfinztal-Söllingen
Deutschland / Germany

EXAflow® - Das Original
EXAflow® - The Original

Innovation is a key success driver at EXAflow®. Our ambition is to create innovative products and solutions for the injection moulding industry, and to provide our customers with a decisive head start in a highly competitive environment, now and in the future.

- *EXAflow® products are designed to help you build moulds reliably and at favourable cost.*
- *We are determined to provide you with just the right gate insert for your application.*
- *Our aim is to amaze you, both with innovative products and with our extensive after-sales support.*

As a specialist for gate insert technology, we develop and produce sophisticated solutions for plastic injection moulders and support them with a maximum of service.



Injected by:

Konturflow® - GTK

Material: ABS

Weight: 10 g

Firma / Company:

Benthin Technology GmbH
Bremerhaven
Deutschland / Germany

List of standard inserts



**Standardflow
GTR 10**



**Standardflow
GTE 10**



**Standardflow
GTR 12**



**Standardflow
GTE 12**



**Standardflow
GTR 14**



**Standardflow
GTE 14**



**Miniflow®
GTM**



**Miniflow®
Geschlossener Anschnitt**



Injected by:

Standardflow GTE

Material: ABS

Weight: 200 g Firma /

Company:

Maschinen & Formenbau Leinetal GmbH
Neustadt
Deutschland / Germany

List of contourable inserts



**Maxiflow[®]
GSK**



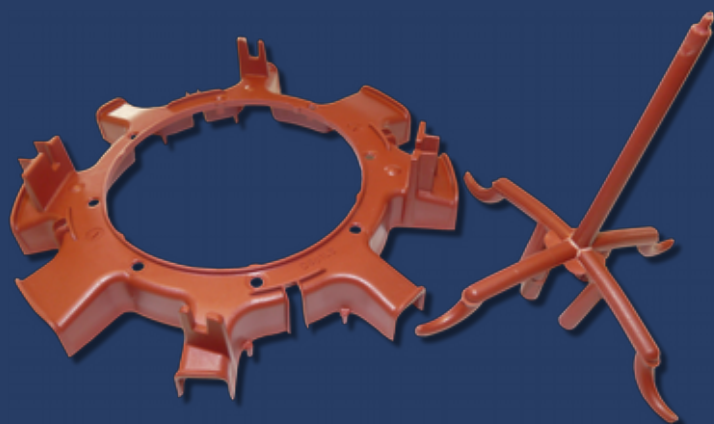
**Midiflow[®]
GMK**



**Konturflow[®]
GTK**



**Ringelflow[®]
GRF-1**



Injected by:

Konturflow[®] - GTK

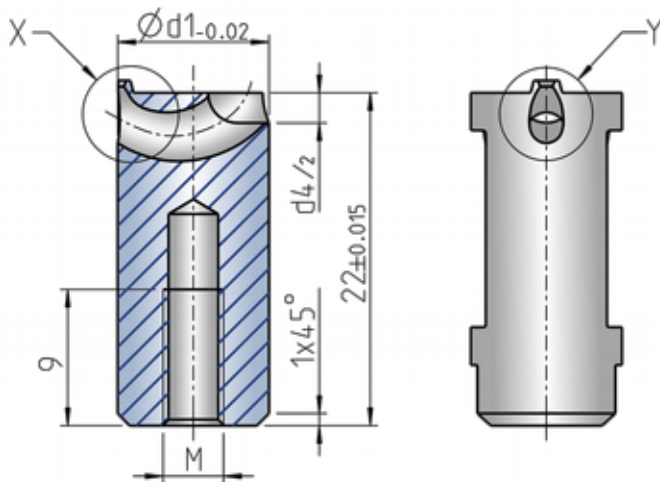
Material: PA66 GF25

Weight: 14 g

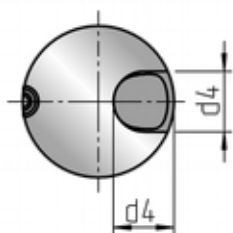
Firma / Company:

Kindtner Werkzeugbau GmbH
Künzelsau
Deutschland / Germany

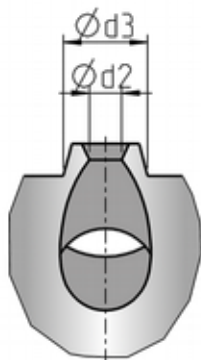
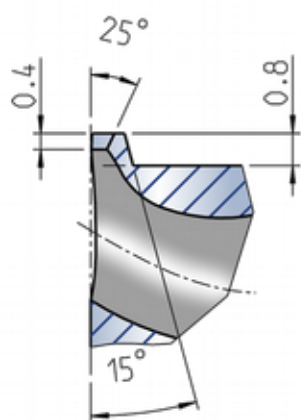
Standardflow GTR



Größenstempel ($\varnothing d2$)



Size stamp ($\varnothing d2$)



Size Table GTR 10

Article No.	d1	d2	d3	d4	M	Viscosity (Rheology)		
						high flowability	regular flowability	poor flowability
GTR 10-08		0,8	2,1			8	7	5
GTR 10-10		1	2,3			14	12	9
GTR 10-12	10	1,2	2,5	4	4	20	16	10
GTR 10-14		1,4	2,7			30	23	15
GTR 10-16		1,6	2,9			40	30	20
Weight in grams								

Size Table GTR 12

Article No.	d1	d2	d3	d4	M	Viscosity (Rheology)		
						high flowability	regular flowability	poor flowability
GTR 12-08		0,8	2,1			8	7	5
GTR 12-10		1	2,3			14	12	9
GTR 12-12		1,2	2,5			20	16	10
GTR 12-14	12	1,4	2,7	5	5	30	23	15
GTR 12-16		1,6	2,9			40	30	20
GTR 12-18		1,8	3,1			54	40	27
GTR 12-20		2	3,3			68	52	34
Weight in grams								

Size Table GTR 14

Article No.	d1	d2	d3	d4	M	Viscosity (Rheology)		
						high flowability	regular flowability	poor flowability
GTR 14-12		1,2	2,5			20	16	10
GTR 14-14		1,4	2,7			30	23	15
GTR 14-16		1,6	2,9			40	30	20
GTR 14-18	14	1,8	3,1	6	6	54	40	27
GTR 14-20		2	3,3			68	52	34
GTR 14-22		2,2	3,5			85	65	43
GTR 14-24		2,4	3,7			100	80	50
Weight in grams								

Technical information

For tunnel gating of small to medium-sized moldings along a flat separating plane. The projecting calotte ensures concealed degating.

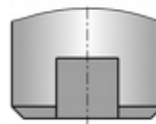
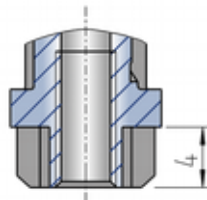
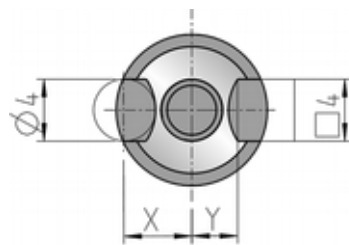
- Available gate diameters from 0,8 to 2,4 mm.
- Usable for all thermoplastics including fillers up to 50 % glass fibre.

Standardflow GTR

Anti-rotation locking system

Anti-rotation locking system dimensions

Artikel Nr.	Abstand Zyl.Stift X	Abstand Passfeder Y
Article No.	Parallel pin distance X	Key distance Y
GTR 10	4,5 mm	3,0 mm
GTR 12	5,2 mm	3,8 mm
GTR 14	6,0 mm	4,5 mm

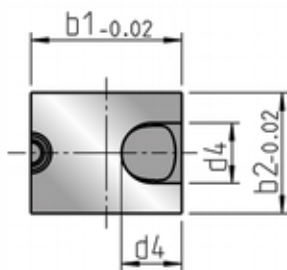
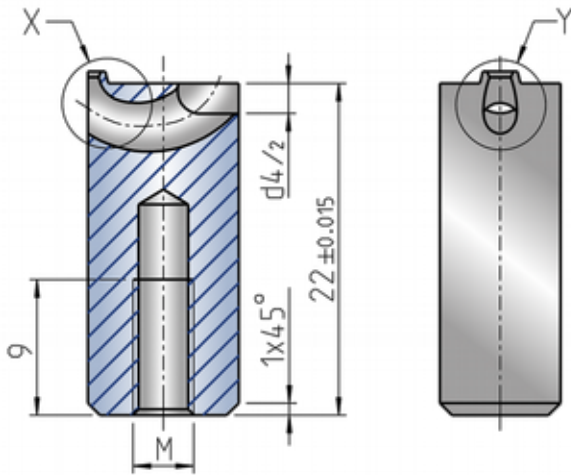


Installation instruction - Anti-rotation locking system

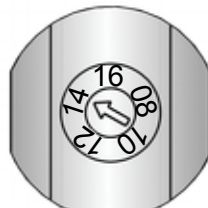
The insert can be secured against inadvertent rotation by a parallel pin and key system.

In most cases the gate insert is adequately secured by the bolt.

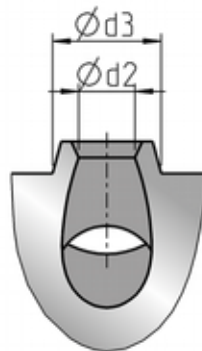
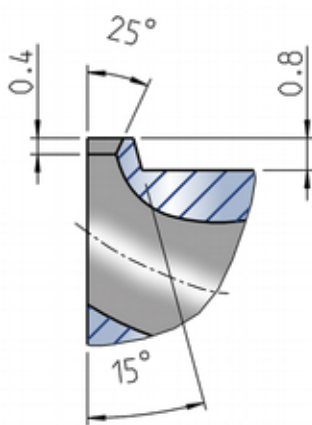
Standardflow GTE



Größenstempel (Ø d2)



Size stamp (Ø d2)



Size Table GTE 10

Article No.	b1	b2	d2	d3	d4	M	Viscosity (Rheology)		
							high flowability	regular flowability	poor flowability
GTE 10-08			0,8	2,1			8	7	5
GTE 10-10			1	2,3			14	12	9
GTE 10-12	10	8	1,2	2,5	4	4	20	16	10
GTE 10-14			1,4	2,7			30	23	15
GTE 10-16			1,6	2,9			40	30	20

Weight in grams

Size Table GTE 12

Article No.	b1	b2	d2	d3	d4	M	Viscosity (Rheology)		
							high flowability	regular flowability	poor flowability
GTE 12-08			0,8	2,1			8	7	5
GTE 12-10			1	2,3			14	12	9
GTE 12-12			1,2	2,5			20	16	10
GTE 12-14	12	10	1,4	2,7	5	5	30	23	15
GTE 12-16			1,6	2,9			40	30	20
GTE 12-18			1,8	3,1			54	40	27
GTE 12-20			2	3,3			68	52	34

Weight in grams

Size Table GTE 14

Article No.	b1	b2	d2	d3	d4	M	Viscosity (Rheology)		
							high flowability	regular flowability	poor flowability
GTE 14-12			1,2	2,5			20	16	10
GTE 14-14			1,4	2,7			30	23	15
GTE 14-16			1,6	2,9			40	30	20
GTE 14-18	14	12	1,8	3,1	6	6	54	40	27
GTE 14-20			2	3,3			68	52	34
GTE 14-22			2,2	3,5			85	65	43
GTE 14-24			2,4	3,7			100	80	50

Weight in grams

Technical information

For tunnel gating of small to medium-sized moldings along a flat separating plane. The projecting calotte ensures concealed degating.

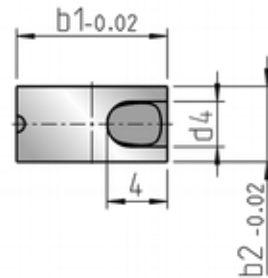
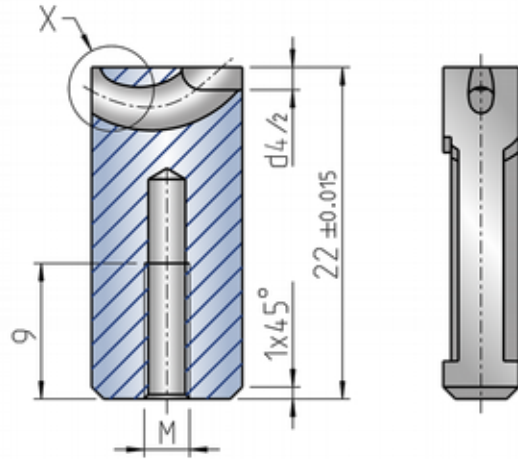
- Available gate diameters from 0,8 to 2,4 mm.
- Usable for all thermoplastics including fillers up to 50 % glass fibre.

Miniflow[®] - GTM

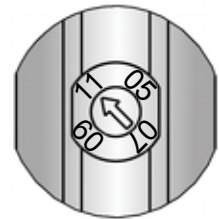


Size Table GTM						Viscosity (Rheology)		
Article No.	b1	b2	d2	d4	M	high	regular	poor
						flowability	flowability	flowability
GTM 10-05			0,5			4	4	3
GTM 10-07	10	5	0,7	3	3	6	5	4
GTM 10-09			0,9			12	9	7
GTM 10-11			1,1			17	14	9

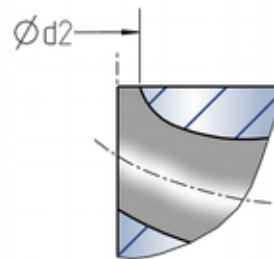
Weight in grams



Größenstempel (Ø d2)



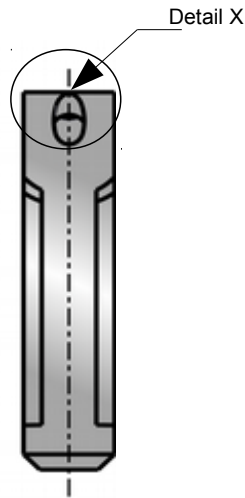
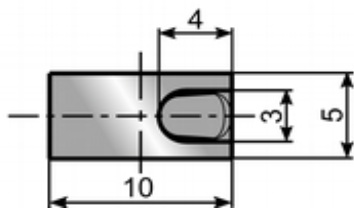
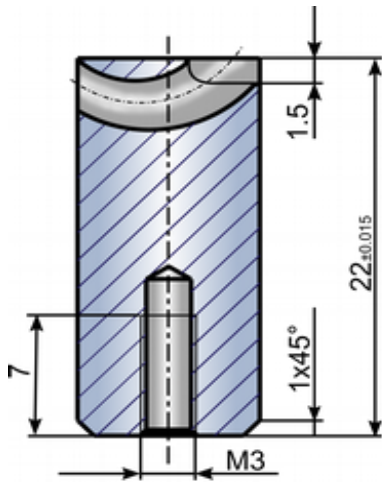
Size stamp (Ø d2)



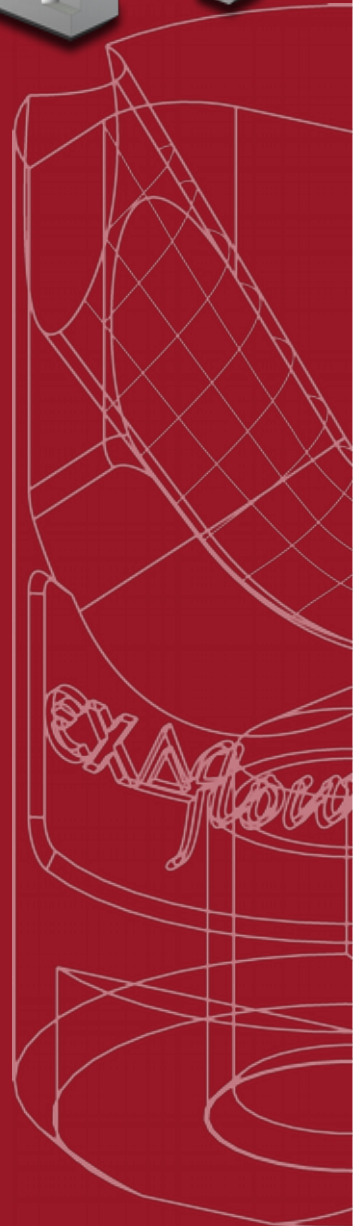
Technical information

For tunnel gating of small, thin-walled moldings. This gate insert possesses no calotte and is therefore suitable for very thin-walled moldings.

- Available gate diameters from 0,5 to 1,1 mm.
- Usable for all thermoplastics including fillers up to 50 % glass fibre.



Detail X

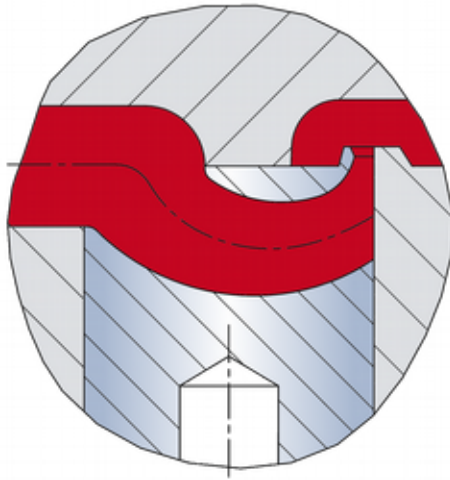
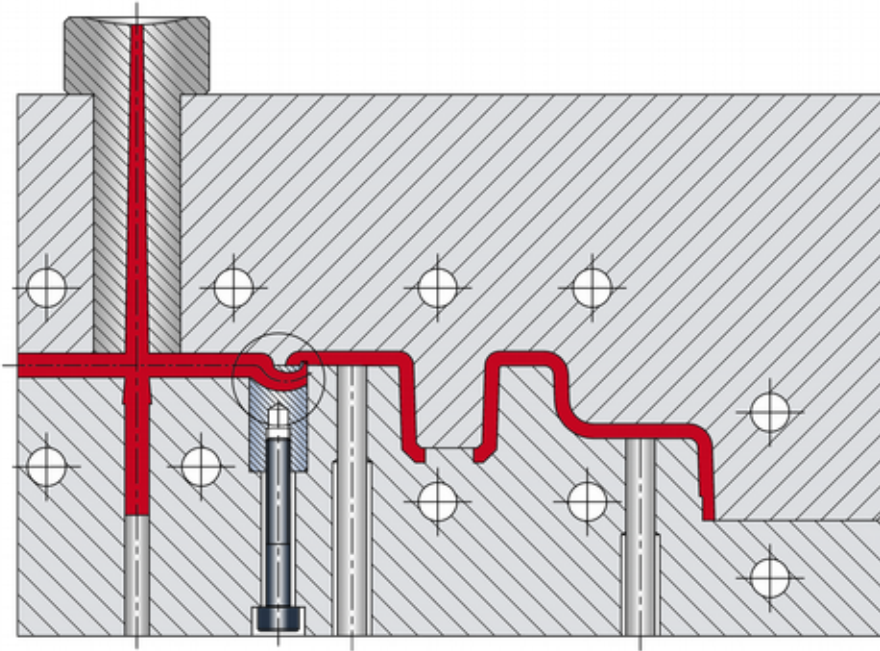


Technical information

For tunnel gating of small, thin-walled moldings. This gate insert has a closed gate diameter and is therefore suitable for the use of low article weight and for very thin-walled moldings.

- the closed surface enables the creation of individual gate diameter.
- usable for all thermoplastics including fillers up to 50 % glass fibre.

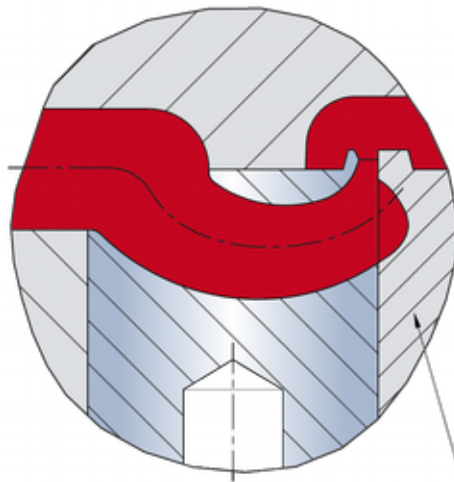
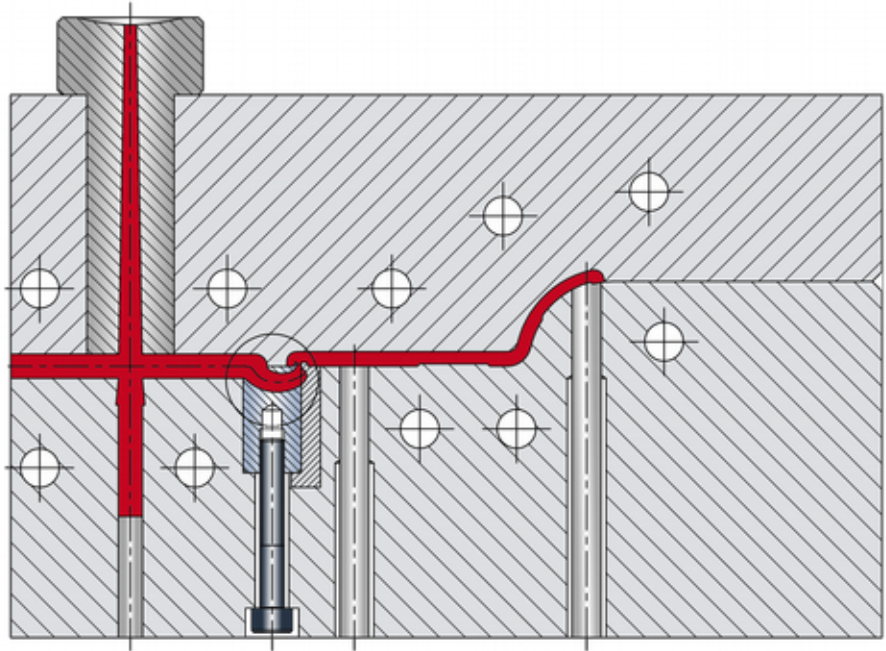
Installation example: Standard



Technical information

*The front of the gate insert is sealed
Off by the mould cavity.*

- *to reduce pressure loss.*
- *to avoid jetting.*



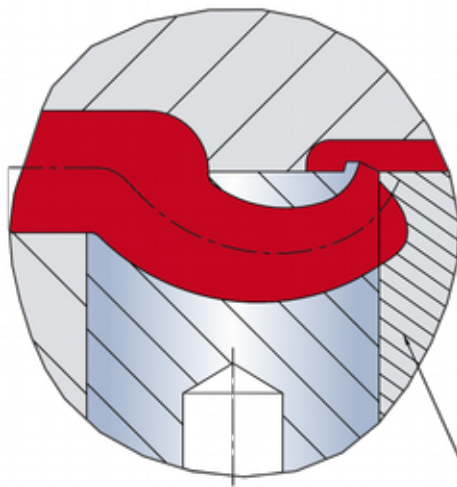
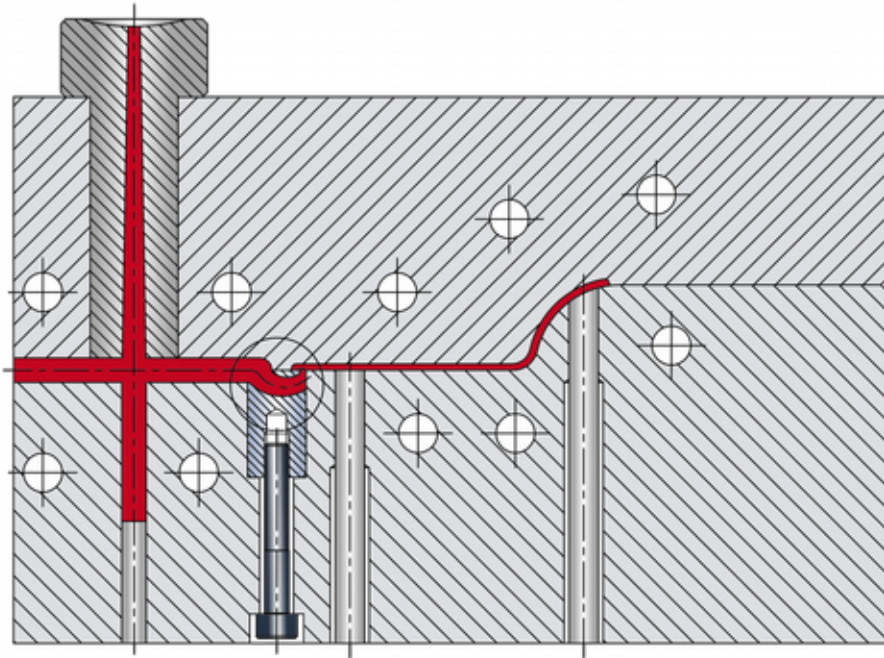
Optionally, provide a dead-end recess

Technical information

The front of the gate insert is fully sealed off by a companion calotte (baffle) on the cavity or by an auxiliary insert.

- to reduce pressure loss.
- to minimize shear.

Installation example: Thin-walled parts Standardflow

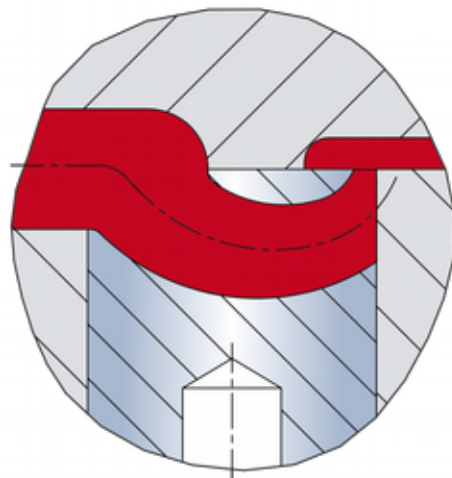
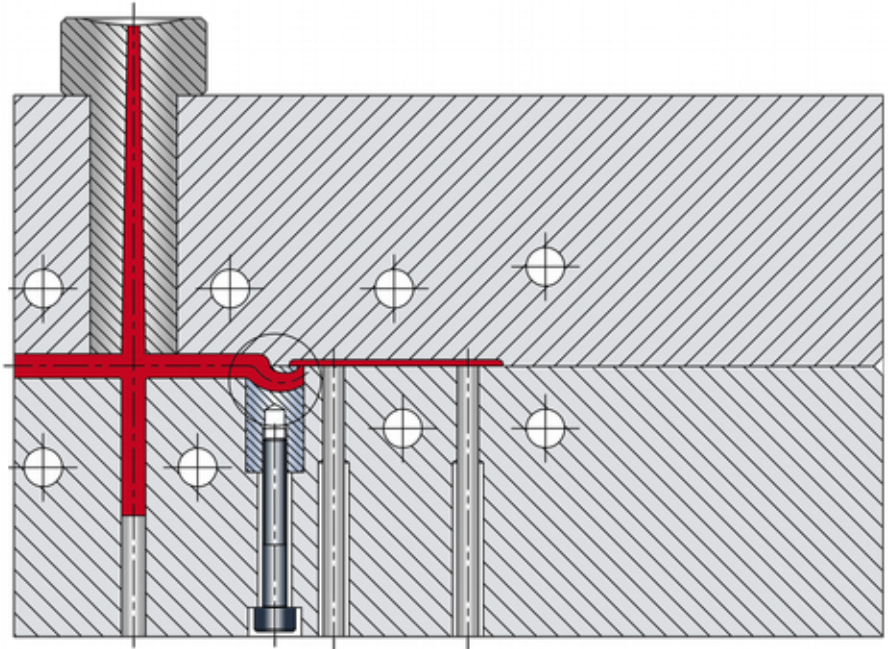


Optionally, provide a dead-end recess

Technical information

The calotte height can be reduced to a minimum of 0,4 mm. This is the height defined by the cutting edge. The front of the gate insert is sealed off by the cavity to the height of the parting line.

- to reduce pressure loss.
- to minimize shear.

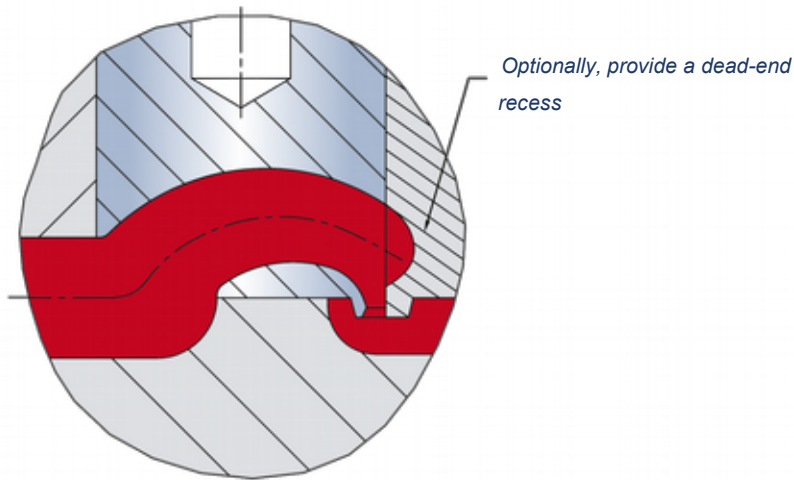
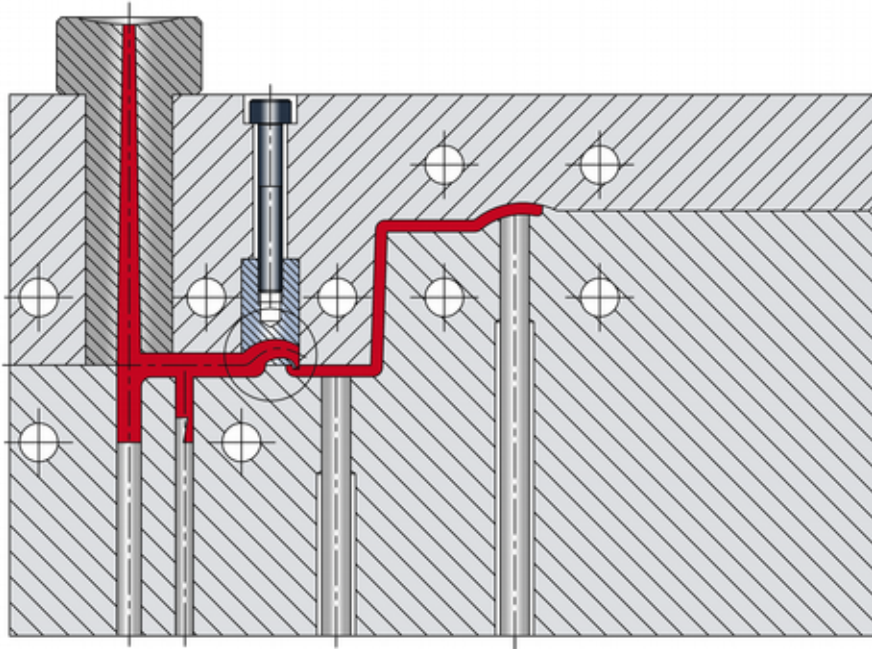


Technical information

*Designed for particularly thin-walled Parts (0,5 to 1,2 mm wall thickness).
The tunnel gate insert has no calotte.
Gating will occur flush with the moulding.*

- *The gating point will be flush with, or slightly projecting from, the bottom surface depending on plastic used.*

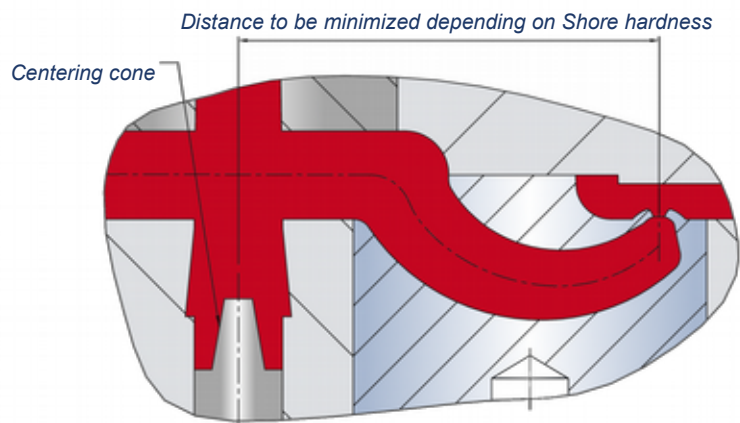
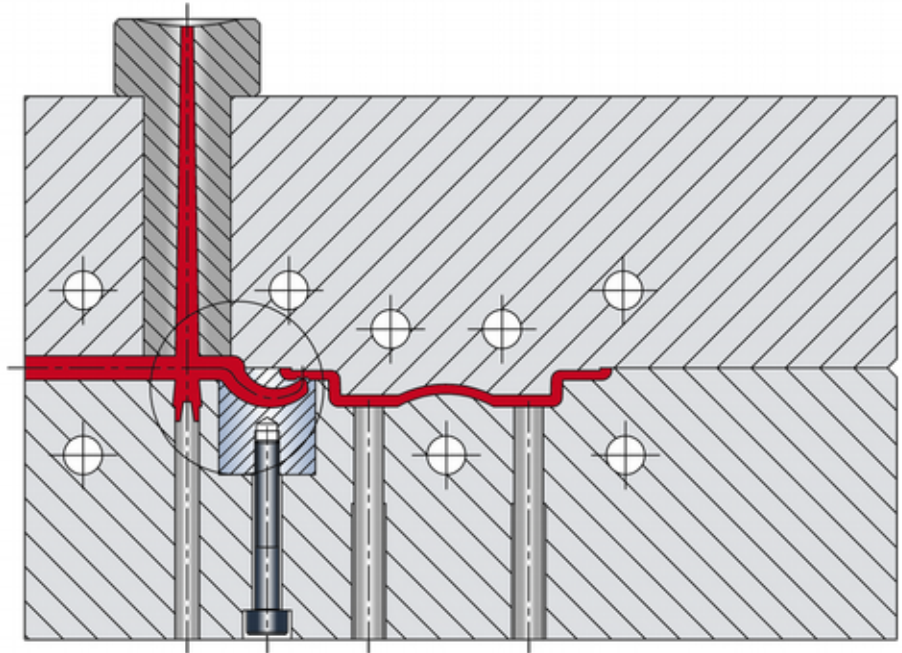
Installation example: Nozzle-side installation



Technical information

The gate insert is screwed into the nozzle side of the mould. The front of the gate insert is sealed off by the cavity.

- to reduce pressure loss.
- to minimize shear.

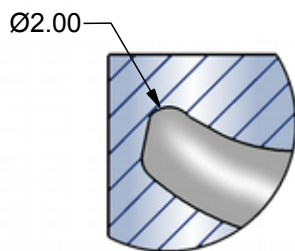
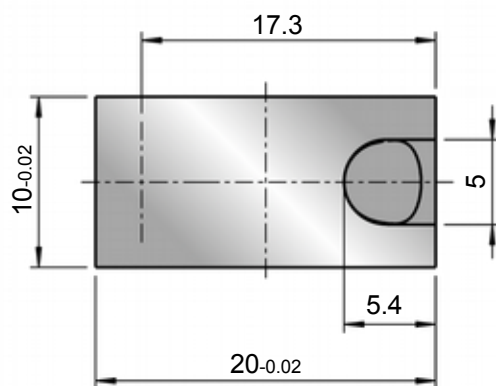
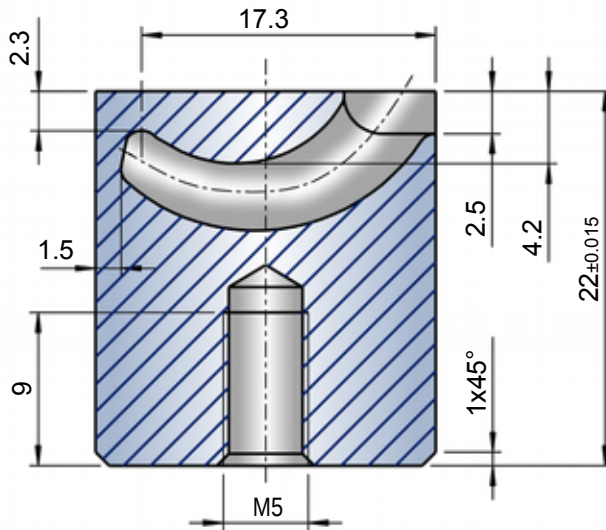
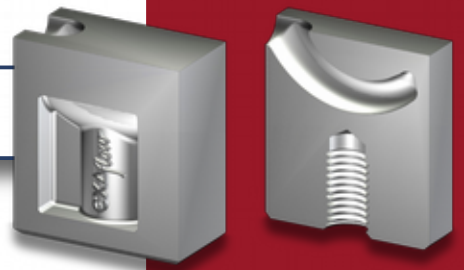


Technical information

When processing thermoplastic elastomers, please observe the following recommendations to ensure reliable de-molding:

- *The distance "L" should decrease with the Shore hardness value.*
- *A centering cone should be provided.*
- *This application instruction applies to elastomers in the medium Shore hardness range up to 100 Shore A.*

Konturflow® - GTK



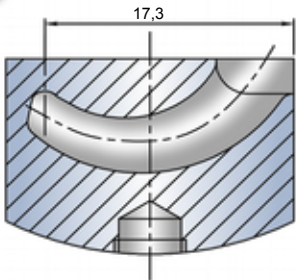
The spherical geometry in the gate area permits gating on inclined or curved surfaces.

Technical information

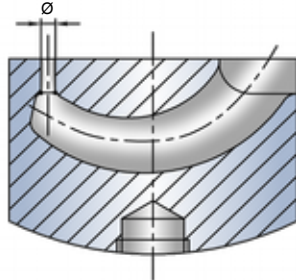
For tunnel gating of small to medium-sized moldings contoured in the gate area.

- Maximum gate diameter (pointed tunnel) up to 1,7 mm.
- Contourable up to 3 mm depth.
- Usable for all thermoplastics including fillers up to 50 % glass fibre.

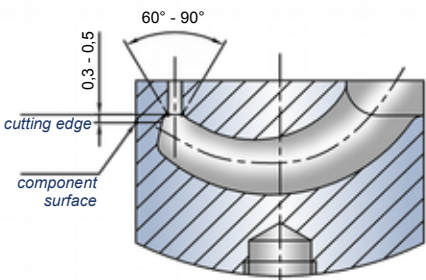
Calotte design: Standard



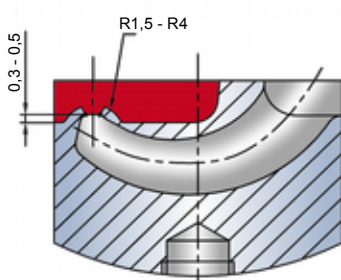
Contourable insert in unfinished state



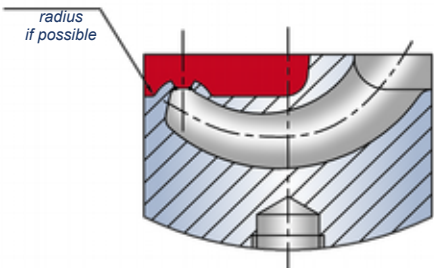
Diameter to be defined in accordance with the table



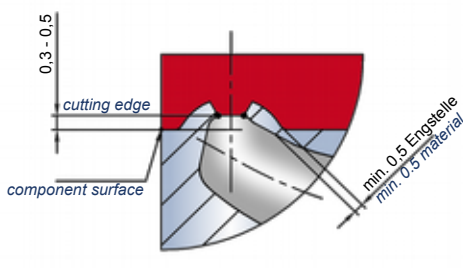
Define 60 to 90 angle at bore / tunnel intersection point



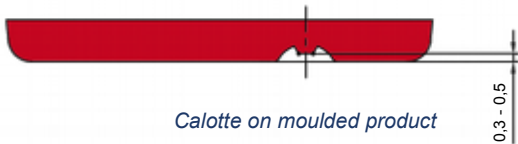
Calotte wall thickness to be between 0.5 and 0.7 mm



Provide radius if possible



Finished calotte drawing



Calotte on moulded product

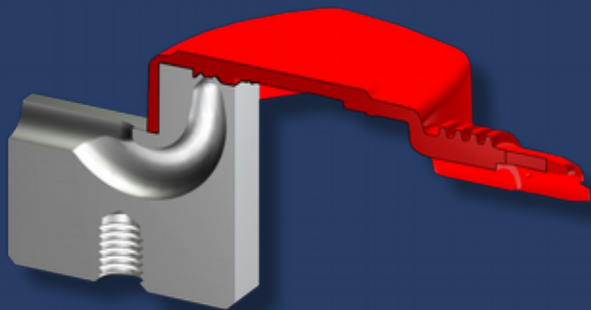
Injected by:

Maxiflow® - GXK-1

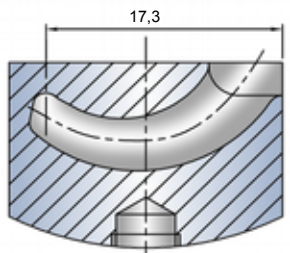
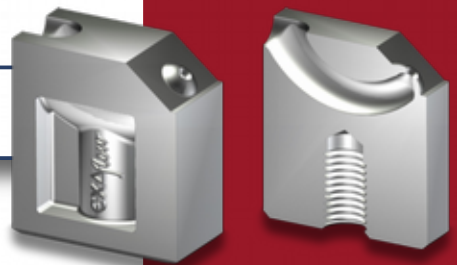
Material: PA66 GF25

Weight: 7,5 g Firma / Company:

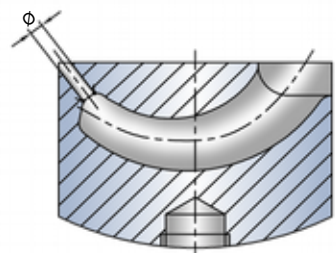
Kindtner Werkzeugbau GmbH
Künzelsau
Deutschland / Germany



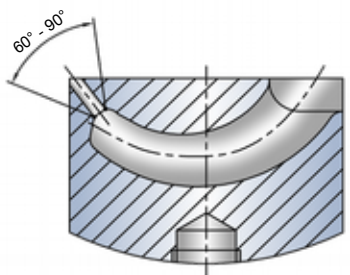
Calotte Design: Inclined Surface



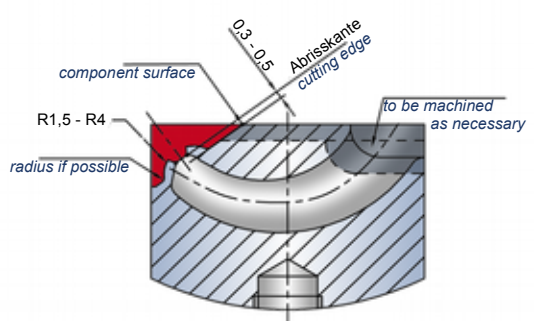
Contourable insert in unfinished state



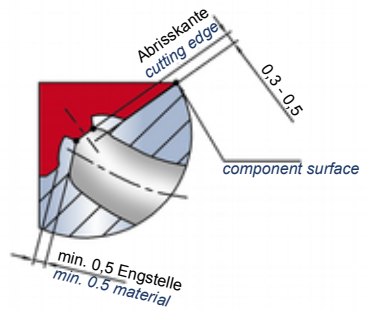
Diameter to be defined in accordance with the table



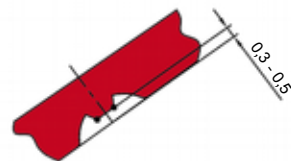
Define 60 to 90 angle at bore / tunnel intersection point



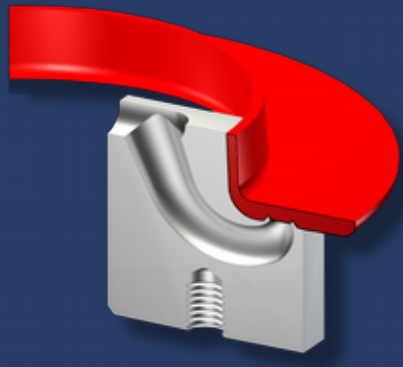
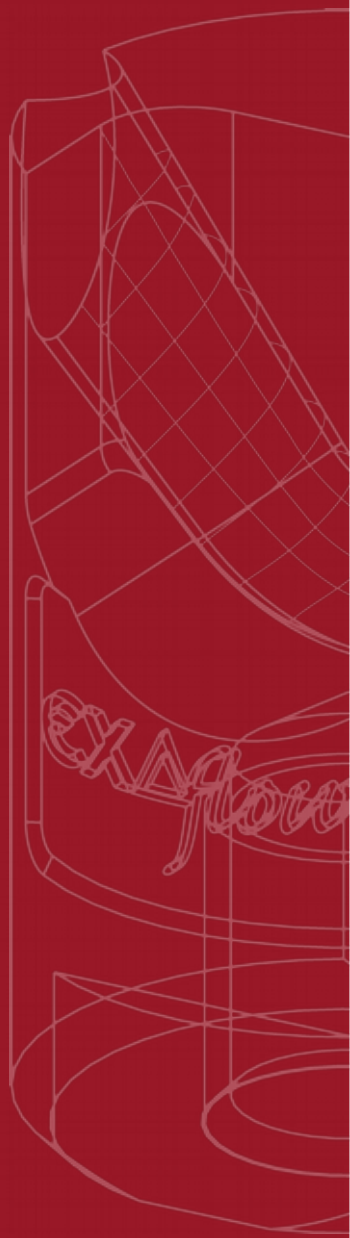
Calotte wall thickness to be between 0.5 and 0.7 mm



Provide radius if possible



Calotte on moulded product



Injected by:

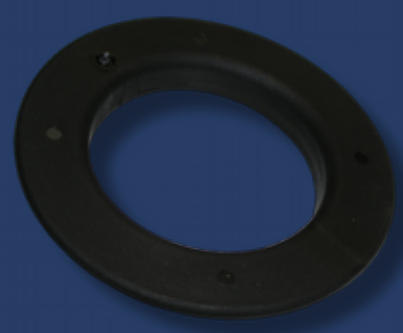
Maxiflow® - GSK-3

Material: PA66 GF35

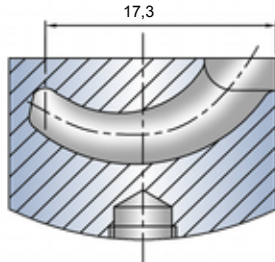
Weight: 18,5 g

Company:

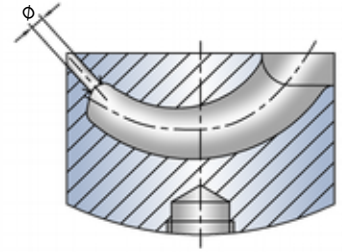
EXAflow® Versuchswerkzeug
Groß-Umstadt
Deutschland / Germany



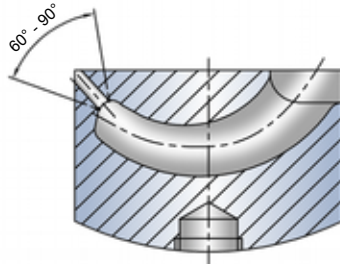
Calotte Design: Curved Surface



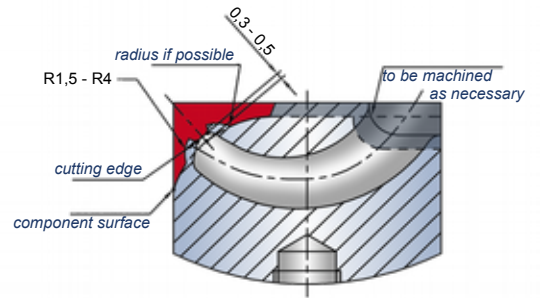
Contourable insert in unfinished state



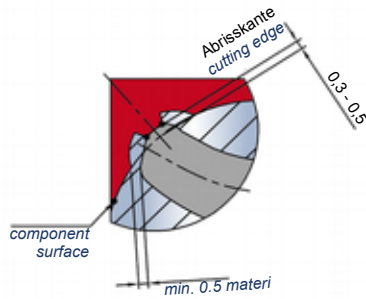
Diameter to be defined in accordance with the table



Define 60 to 90 angle at bore / tunnel intersection point



Calotte wall thickness to be between 0.5 and 0.7 mm



Provide radius if possible



Calotte on moulded product



Anspritzung / Injected by:

Maxiflow® - GXK-1

Material / Material: PA66

Artikelgewicht / Weight: 110 g

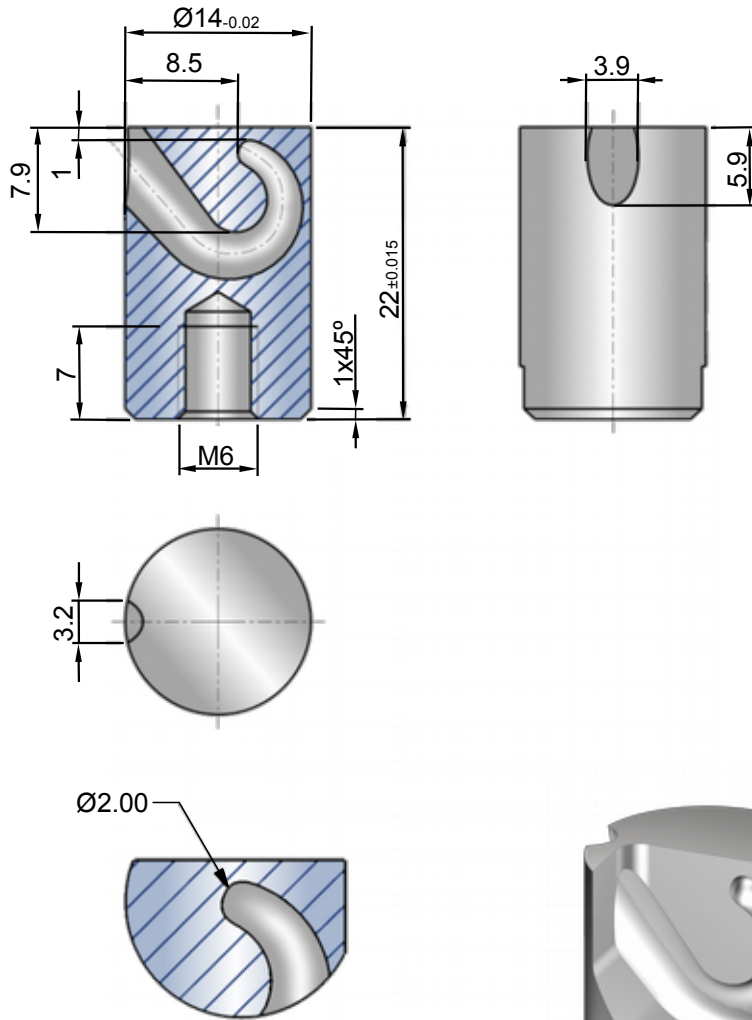
Firma / Company:

Hans Vorbach GmbH & Co. KG

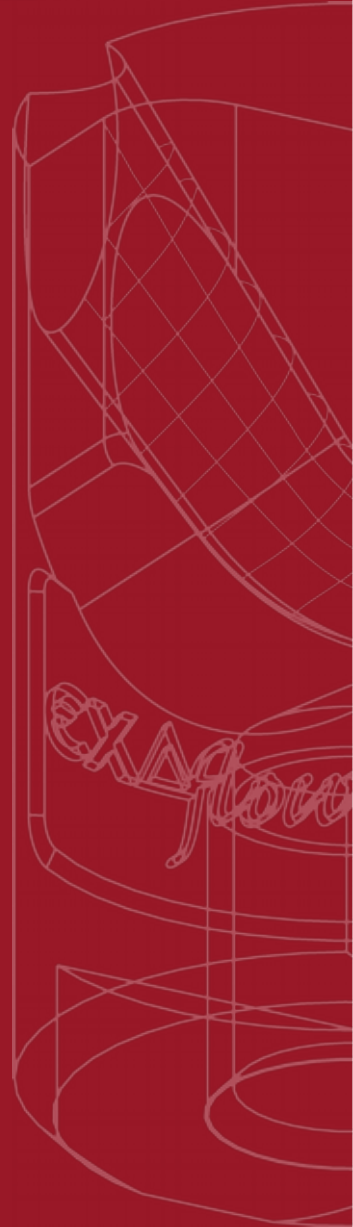
Kaufbeuren

Deutschland / Germany

Ringelflow® - GRF-1



The spherical geometry in the gate area permits gating on inclined or curved surfaces.

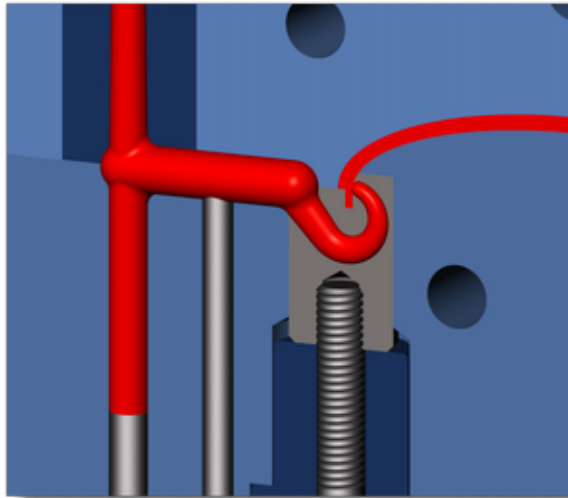


Technical information

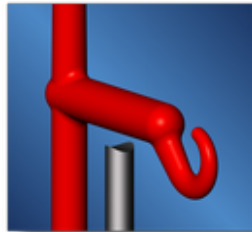
*For rear surface gating of small-to-medium sized mouldings.
Supports gate diameters up to 1,8 mm and shot weights up to 100 g per insert.
Suitable for all common non-reinforced plastic types.*

Ringelflow[®] - GRF-1

Installation example



For best operating results the Ringelflow[®] insert requires one central ejector and one supporting ejector. Please ensure that all sharp edges in the runner are thoroughly rounded. For reliable demoulding, the diameter of the runner must exceed that of the curved tunnel.



Contouring of a supporting ejector



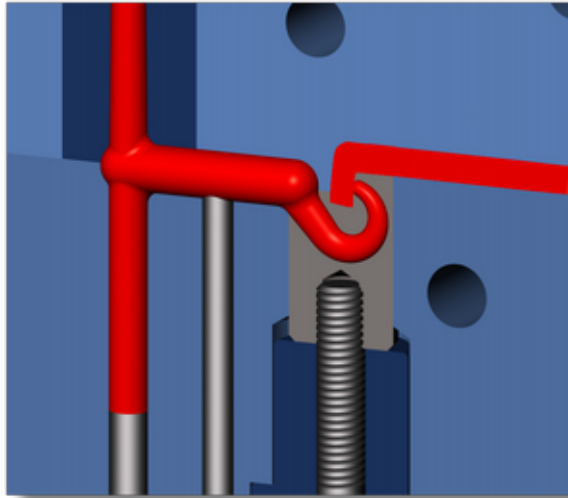
Optimum gate geometry, with edges rounded

Ringelflow[®] - GRF-1 benefits

- Optimum solution to prevent jetting.
- No gate marks on visible external surfaces and bottom wall.
- Ideal for fully rounded edges (e.g., toys, mouldings with sealing edges and joints).
- Permits internal gating of 2-component mouldings.

Ringelflow® - GRF-1

Installation example



For best operating results the Ringelflow® insert requires one central ejector and one supporting ejector. Please ensure that all sharp edges in the runner are thoroughly rounded. For reliable demoulding, the diameter of the runner must exceed that of the curved tunnel.



Contouring of a supporting ejector



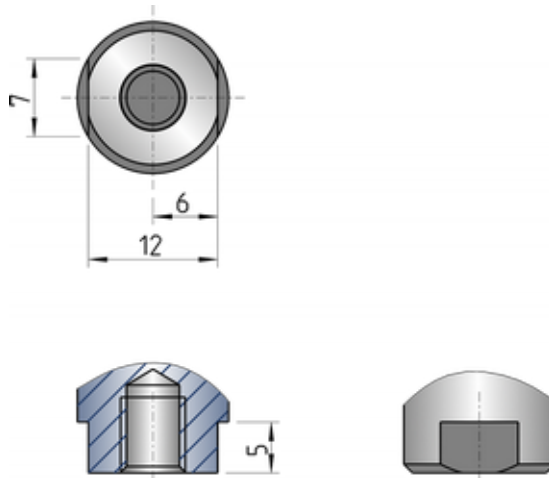
Optimum gate geometry, with edges rounded

Ringelflow® - GRF-1 benefits

- Optimum solution to prevent jetting.
- No gate marks on visible external surfaces and bottom wall.
- Ideal for fully rounded edges (e.g., toys, mouldings with sealing edges and joints).
- Permits internal gating of 2-component mouldings.

Ringelflow[®] - GRF-1

Anti-rotation locking system

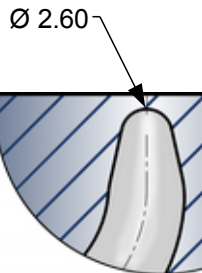
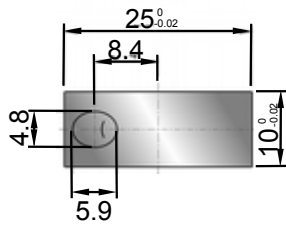
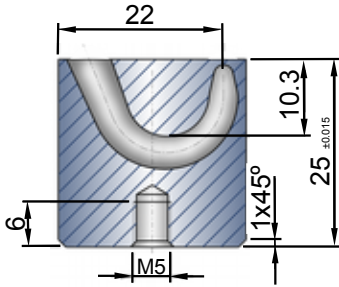


Installation instruction - Anti-rotation locking system

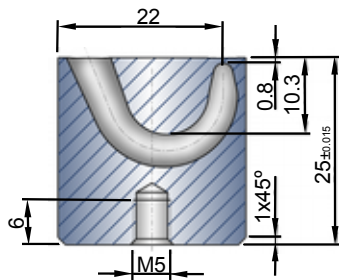
The insert can be secured against inadvertent rotation by a parallel pin and key system.

In most cases the gate insert is adequately secured by the bolt.

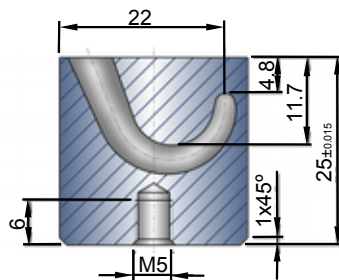
Midiflow GMK



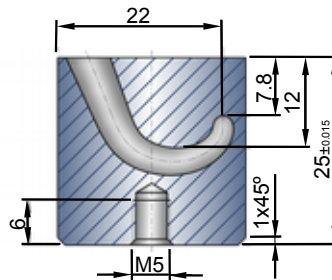
The spherical geometry in the gate area permits gating on inclined or curved surfaces.



GMK-1



GMK-2



GMK-3

Technical information

For bottom (submarine) gating of medium components. Supports contouring to a depth of 8 mm.

Suitable for gate diameters up to 2 mm and shot weights up to 200 g per insert.

Suitable for all common plastics, including reinforced types.



Midiflow GMK-1

Installation example: below the parting line



Installation example: above the parting line



Midiflow GMK-1 benefits

- Gating point may be located up to 8 mm above the parting line.
- Permits gating immediately behind projecting ribs.
- Gate may be remote from moulding wall.
- The spherical geometry in the gate area permits gating on inclined or curved surfaces.

Midiflow GMK-2



Installation example: below the parting line



Installation example: above the parting line



Midiflow GMK-2 benefits

- Gating point may be located up to 5 mm below or above the parting line.
- Permits gating immediately behind projecting ribs.
- Gate may be remote from moulding wall.
- The spherical geometry in the gate area permits gating on inclined or curved surfaces.



Midiflow GMK-3

Installation example: below the parting line



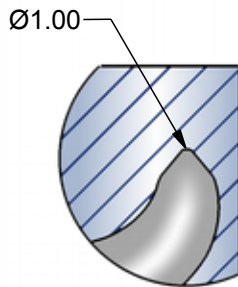
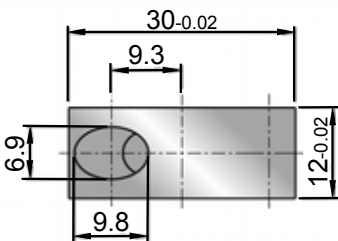
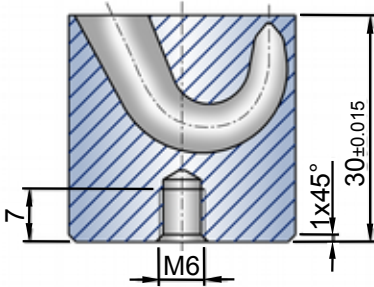
Installation example: above the parting line



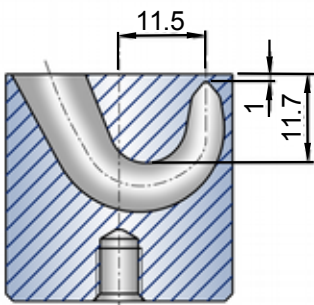
Midiflow GMK-3 benefits

- Gating point may be located up to 8 mm below the parting line.
- Permits gating immediately behind projecting ribs.
- Gate may be remote from moulding wall.
- The spherical geometry in the gate area permits gating on inclined or curved surfaces.

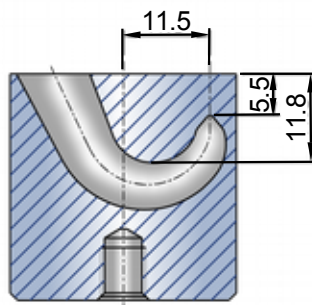
Maxiflow[®] - GXK



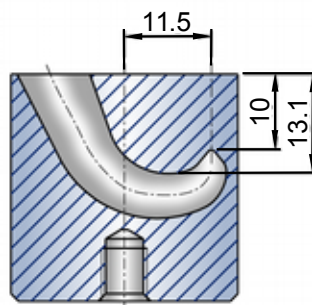
The spherical geometry in the gate area permits gating on inclined or curved surfaces.



GXK-1



GXK-2



GXK-3

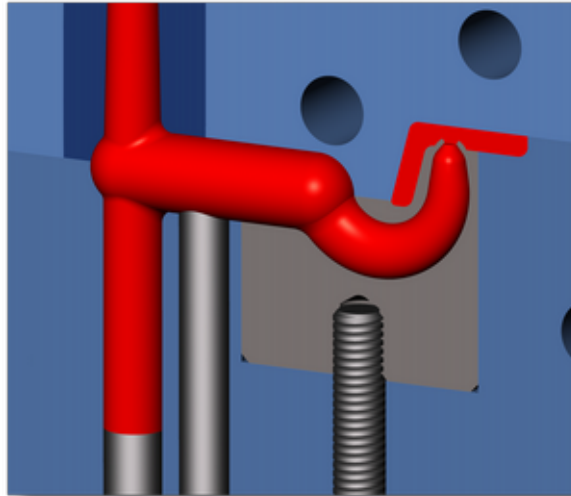
Technical information

For bottom (submarine) gating of medium to-large components. Supports contouring to a depth of 11,5 mm. Suitable for gate diameters up to 3,5 mm and shot weights up to 1,200 g per insert. Suitable for all common plastics, including reinforced types.

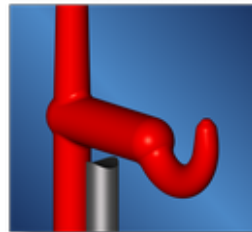


Maxiflow[®] GSK-1

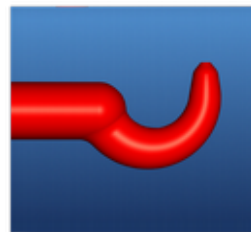
Installation example



For best operating results the Maxiflow[®] insert requires one central ejector and one supporting ejector. Please ensure that all sharp edges in the runner are thoroughly rounded. For reliable demoulding, the diameter of the runner must exceed that of the curved tunnel.



Contouring of a supporting ejector



Optimum gate geometry, with edges rounded

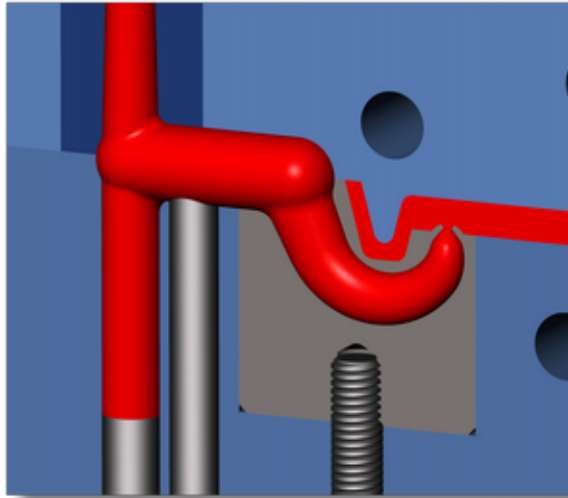
Maxiflow[®] - GSK-1 benefits

- Gating point may be located up to 10 mm above the parting line.
- Permits gating immediately behind projecting ribs.
- Gate may be remote from moulding wall.
- The spherical geometry in the gate area permits gating on inclined or curved surfaces.

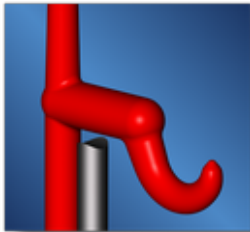
Maxiflow[®] - GXK-2



Installation example



For best operating results the Maxiflow[®] insert requires one central ejector and one supporting ejector. Please ensure that all sharp edges in the runner are thoroughly rounded. For reliable demoulding, the diameter of the runner must exceed that of the curved tunnel.



Contouring of a supporting ejector



Optimum gate geometry, with edges rounded

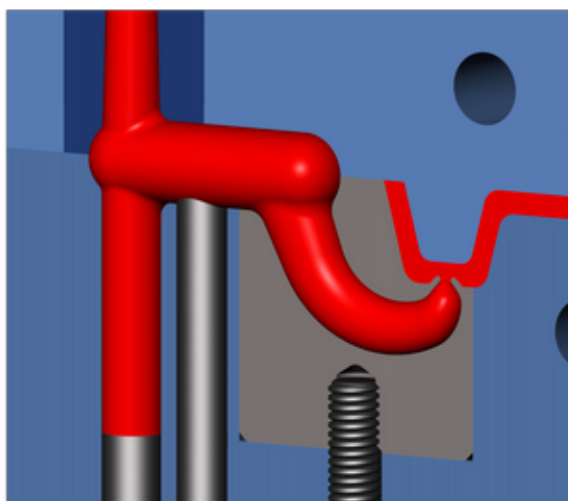
Maxiflow[®] - GXK-2 benefits

- Gating point may be located up to 5 mm above or below the parting line.
- Gate may be remote from moulding wall.
- The spherical geometry in the gate area permits gating on inclined or curved surfaces.



Maxiflow[®] - GSK-3

Installation example



For best operating results the Maxiflow[®] insert requires one central ejector and one supporting ejector. Please ensure that all sharp edges in the runner are thoroughly rounded. For reliable demoulding, the diameter of the runner must exceed that of the curved tunnel.



Contouring of a supporting ejector



Optimum gate geometry, with edges rounded

Maxiflow[®] - GSK-3 benefits

- Gating point may be located up to 10 mm below the parting line.
- Gate may be remote from moulding wall.
- The spherical geometry in the gate area permits gating on inclined or curved surfaces.

Runner and supporting ejector

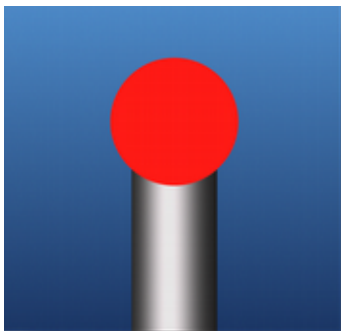


Example of a "Ringelflow[®]" gate configuration

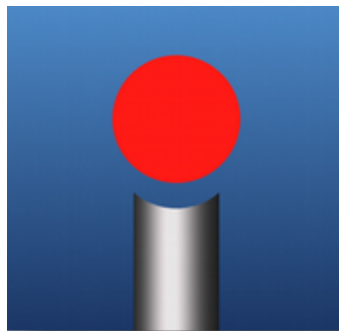


Example of a "Maxiflow[®]" gate configuration

In these examples the contoured supporting ejector is shown displaced towards the bottom for the sake of clarity. For reliable demoulding, the diameter of the runner must exceed that of the curved tunnel.



The supporting ejector, locked against rotation, ends flush with the runner.



Machine the runner contour into the supporting ejector.

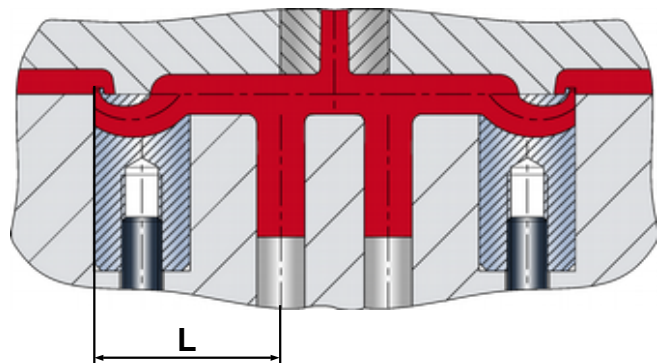
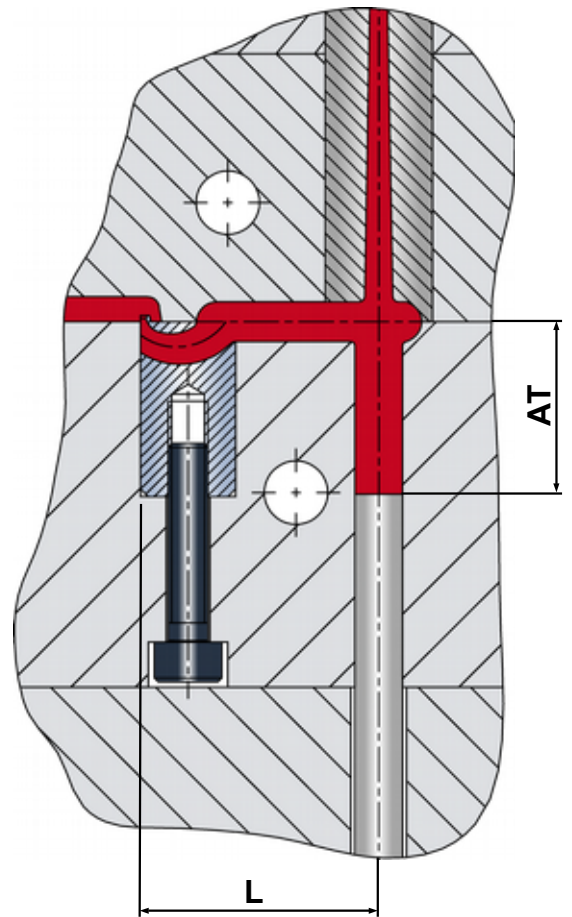
Technical information

Ringelflow[®] and Maxiflow[®] inserts must be used in conjunction with a supporting ejector.

The contoured supporting ejector, locked against rotation, should end flush with the runner so that the runner can slide over the ejector's supporting face.

Installation dimensions GTM GTR/GTE GTK

Plastic group	GTM	GTR/GTE	GTK
HD-PE, LD-PE, PET, PP, PA, PC, PVC. (L)	>15	>20	>25
Runner design	rund round	rund round	rund round
Ejector depth (AT)	>11	>16	>20
ABS, M ABS, ASA, PS, PC/ ABS, POM, PBT. (L)	>20	>25	>30
Runner design	rund round	rund round	rund round
Ejector depth (AT)	>14	>20	>24
Elastomere TPE, TPU, TPP, TPA. (L)	>15	>15	>20
Runner design	arbitrary	arbitrary	arbitrary
Ejector depth (AT)	>11	>11	>16
Brittle plastics	>25	>30	>40
Runner design	half-round	half-round	half-round
Ejector depth (AT)	>18	>24	>32

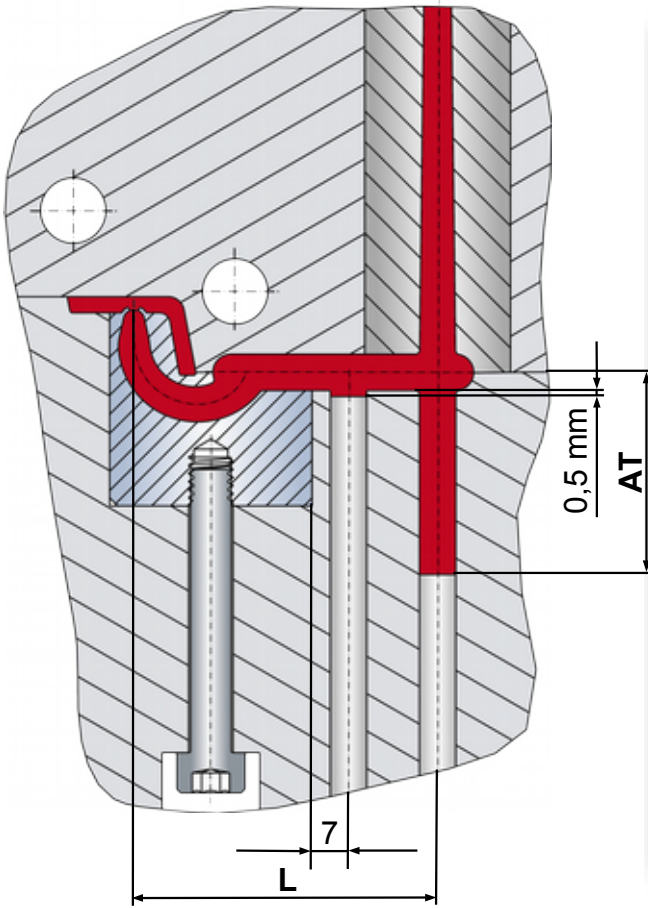


Technical information

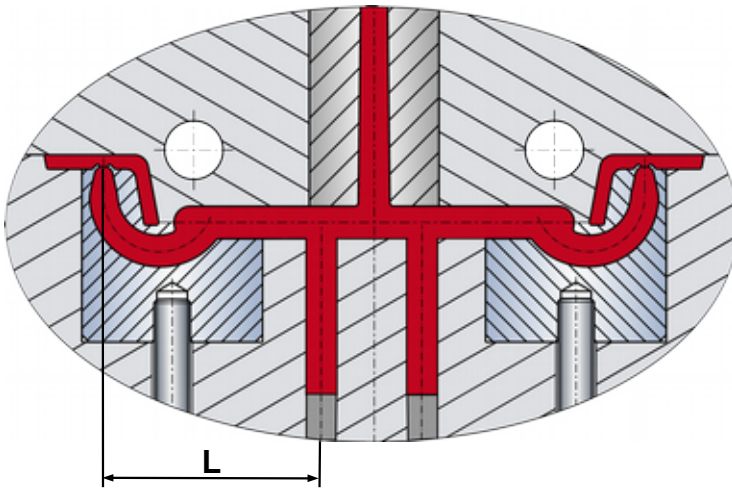
Recommended distances "L" from the injection point to the sprue ejector are given above for the various material groups.

The distance "AT" describes the correlated ejector depth.

Installation dimensions GXK GMK



Plastic group	GXK	GMK
HD-PE, LD-PE, PET, PP, PA, PC, PVC. (L)	>35	>30
Runner design	round	round
Ejector depth (AT)	>35	>30
ABS, M ABS, ASA, PS, PC/ABS, POM, PBT. (L)	>40	>35
Runner design	round	round
Ejector depth (AT)	>40	>35
Elastomere TPE, TPU, TPP, TPA. (L)	>30	>25
Runner design	arbitrary	arbitrary
Ejector depth (AT)	>30	>16
Brittle plastics	on request	on request
Runner design	half-round	half-round
Ejector depth (AT)	on request	on request



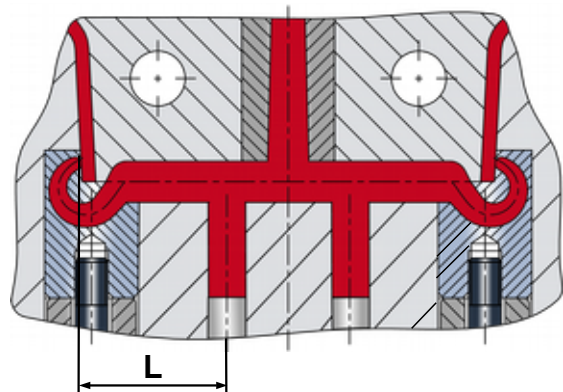
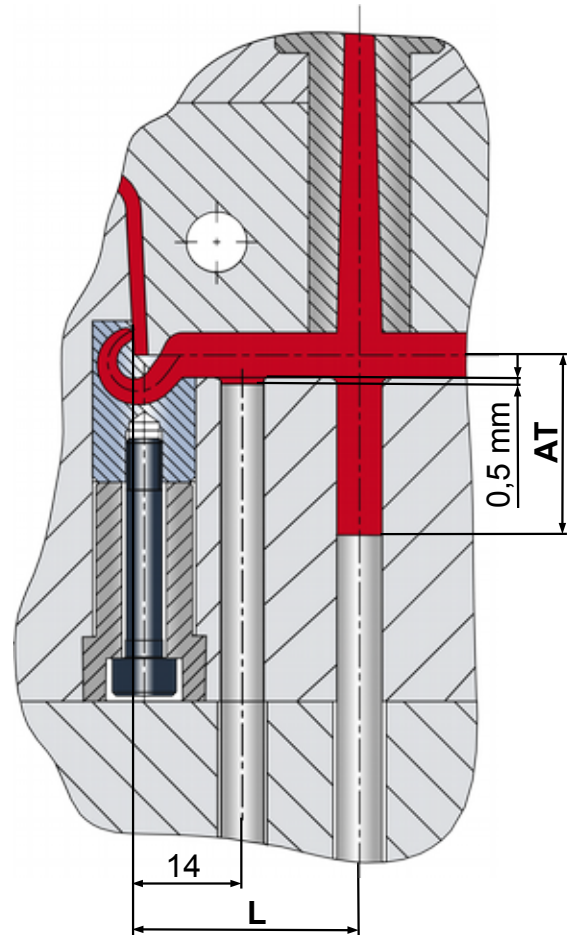
Technical information

Recommended distances "L" from the injection point to the sprue ejector are given above for the various material groups.

The distance "AT" describes the correlated ejector depth.

Installation dimensions Ringelflow® - GRF

Materialgroup	GRF
HD-PE, LD-PE, PET, PP, PA, PC, PVC. (L)	>30
Kanalausführung Runner design	round
Ejector depth (AT)	>30
ABS, M ABS, ASA, PS, PC/ABS, POM, PBT. (L)	>30
Runner design	round
Ejector depth (AT)	>30
Elastomere TPE, TPU, TPP, TPA. (L)	>20
Runner design	arbitrary
Ejector depth (AT)	>20
Brittle plastics	on request
Runner design	half-round
Ejector depth (AT)	on request

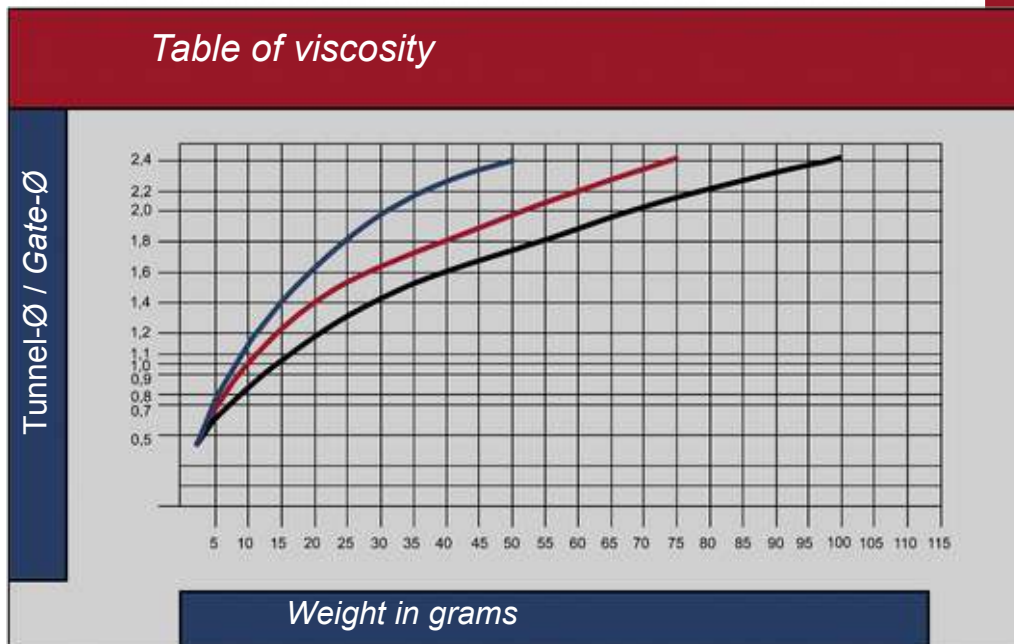


Technical information

Recommended distances "L" from the injection point to the sprue ejector are given above for the various material groups.

The distance "AT" describes the correlated ejector depth.

Table of viscosity Standard Tunnel Gates



Low Viscosity

(PA, PE, PC, PP, PET, PVC, PS, SB, TPA, TPE, TPU)



Medium Viscosity

(ABS, ASA, PS, PC/ABS, PBT, SAN)



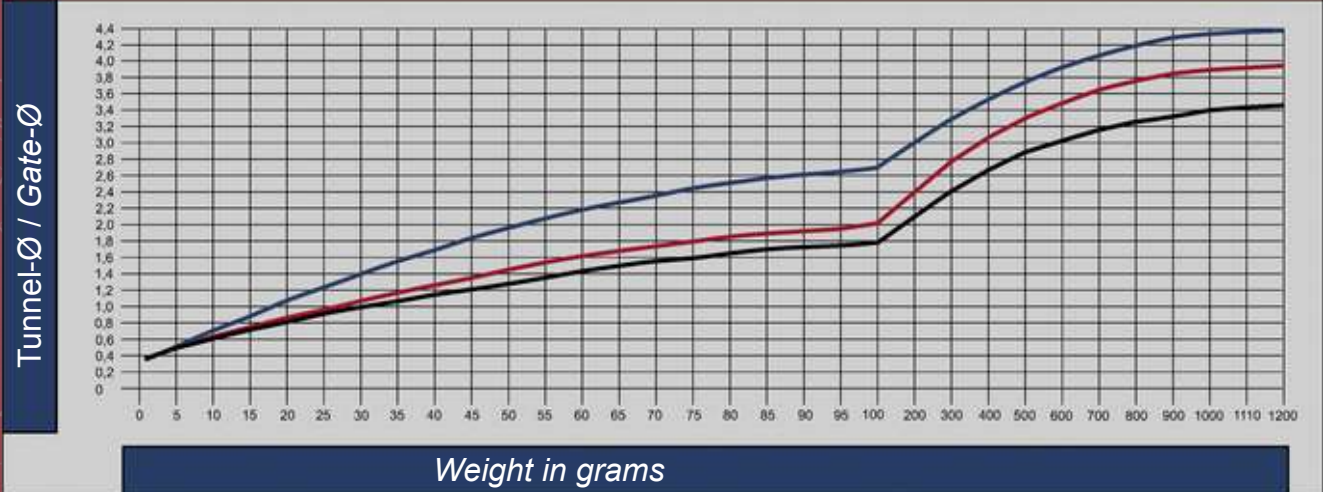
High Viscosity

(PC, PPS, PSU, POM-H, PES, PPO, PEI, PC-ABS, PC-PBT, PMMA, PVC)



Table of viscosity for contourable Inserts

Table of viscosity



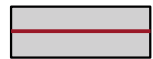
Low Viscosity

(PA, PE, PC, PP, PET, PVC, PS, SB, TPA, TPE, TPU)



Medium Viscosity

(ABS, ASA, PS, PC/ABS, PBT, SAN)



High Viscosity

(PC, PPS, PSU, POM-H, PES, PPO, PEI, PC-ABS, PC-PBT, PMMA, PVC)



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Internet www.exaflow.de