

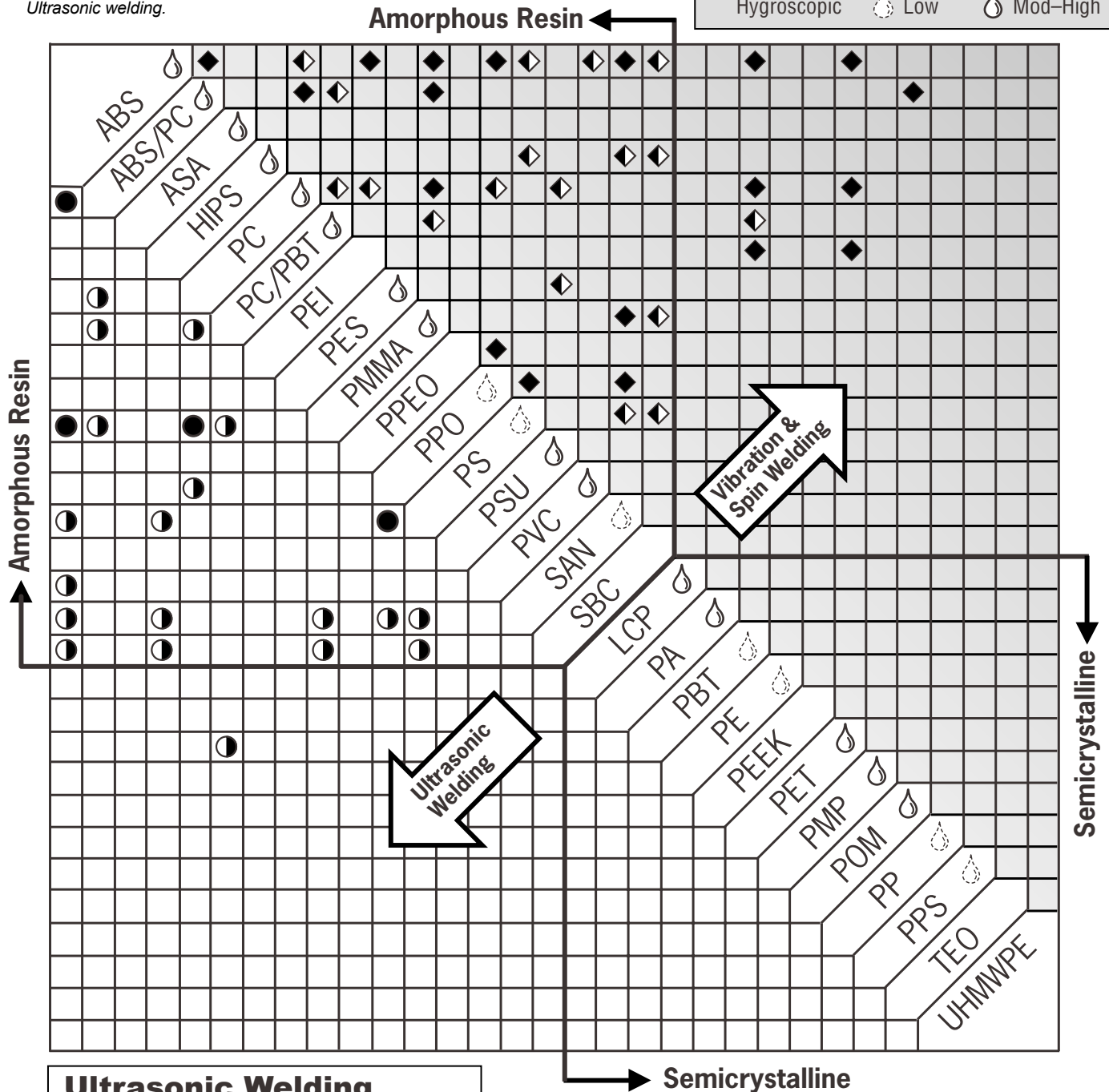




For Ultrasonic Welding use the lower left side. For Vibration and Spin Welding use the upper right portion. Then select the two materials and find their intersection. For example: Spin Welding ABS to PEI – Move to the right from the ABS label and up from the PEI label to determine these materials have good compatibility (◆ symbol). Moving to the left from PEI and down from ABS we find this pair is not compatible for Ultrasonic welding.

### Vibration & Spin Welding

- ◆ Good Compatibility
- ◊ Compatibility Based Upon Material Composition
- Hygroscopic     Low     Mod-High



### Ultrasonic Welding

- Good Compatibility
- ◐ Compatibility Based Upon Material Composition
- Hygroscopic     Low     Mod-High

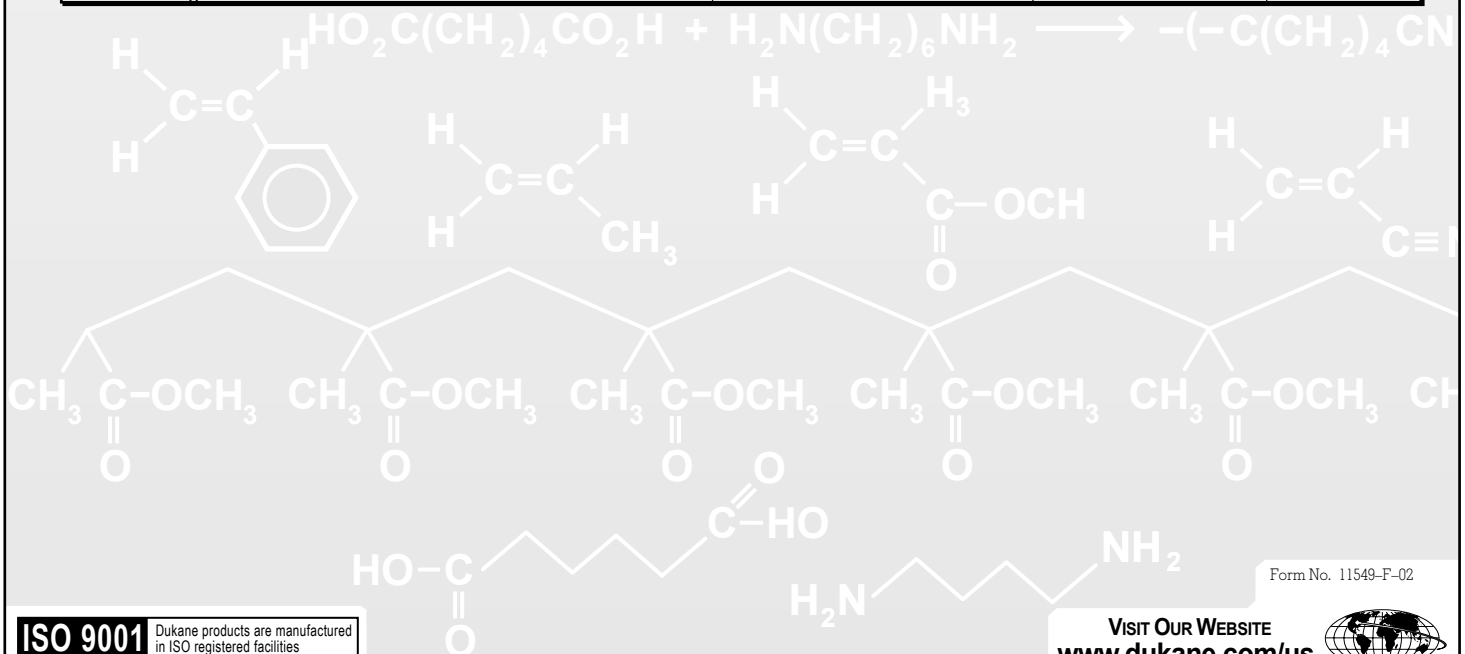
For Ultrasonic Welding use the lower left half. For Vibration and Spin Welding use the upper right portion. Then select the two materials and find their intersection. For example: Spin Welding ABS to PEI – Move to the right from the ABS label and up from the PEI label to determine these materials have good compatibility (◆ symbol). Moving to the left from PEI and down from ABS we find this pair is not compatible for Ultrasonic welding (blank intersection).

Actual compatibility is based on individual application requirements, material, part evaluation and testing.

Form No. 11549-F-02



Code	Chemical Name	Trade Name(s)	Type	Hygroscopic
ABS	Acrylonitrile Butadiene Styrene	Cycolac, Lustran	Amorphous Resin	Mod
ABS/PC	ABS/Polycarbonate	Cycloy, Pulse	Amorphous Resin	Mod
ASA	Acrylonitrile Styrene Acrylate	Centrex, Gelay, Luran	Amorphous Resin	Mod
HIPS	High-Impact Polystyrene		Amorphous Resin	Mod
PC	Polycarbonate	Lexan, Calibre, Novarex	Amorphous Resin	Mod
PC/PBT	Polycarbonate/Polyester	Xenoy Macroblend	Amorphous Resin	Mod
PEI	Polyetherimide	Ultem	Amorphous Resin	--
PES	Polyethersulfone	Ultrason	Amorphous Resin	Mod
PMMA	Polymethyl Methacrylate (Acrylic)	Acrylite, Plexiglass, Zylar	Amorphous Resin	Mod
PPEO	Polyphenylene Ether/Oxide	Prevex	Amorphous Resin	--
PPO	Polyphenylene Oxide	Noryl	Amorphous Resin	Low
PS	Polystyrene	Dylark, Styron	Amorphous Resin	Low
PSU	Polysulfone	Udel	Amorphous Resin	Mod
PVC	Polyvinyl Chloride	Novablend, Ultrachem	Amorphous Resin	Low
SAN	Styrene-Acrylonitrile	Lustran, Styvex, Tyril	Amorphous Resin	Mod
SBC	Styrene Block Copolymers	K-Resin	Amorphous Resin	--
LCP	Liquid Crystal Polymer	Vectra, Xydar	Semi-Crystalline	Mod
PA	Polyamide (Nylon)	Celstran, Ultramid, Zytel	Semi-Crystalline	High
PBT	Polybutylene Terephthalate (Polyester)	Celanex, Ultradur, Valox	Semi-Crystalline	Low
PE	Polyethylene	Aspun, Clysar, Dowlex	Semi-Crystalline	Low
PEEK	Polyetheretherketone	Arlon	Semi-Crystalline	--
PET	Polyethylene Terephthalate (Polyester)	Mylar, Rynite, Cleartuf	Semi-Crystalline	Mod
PMP	Polymethylpentene	TPX	Semi-Crystalline	High
POM	Polyoxymethylene (Polyacetal )	Acetal, Celcon, Delrin	Semi-Crystalline	Mod
PP	Polypropylene	Astryon, Fortilene, Marlex	Semi-Crystalline	Low
PPS	Polyphenylene Sulfide	Fortron, Ryton, Supac	Semi-Crystalline	Low
TEO	Thermoplastic Elastomer, Olefinic	Sarlink, Flexathane, TPO	Semi-Crystalline	--
UHMWPE	Ultra-High Molecular Weight Polyethylene	Cadco	Semi-Crystalline	--



Form No. 11549-F-02

**ISO 9001** Dukane products are manufactured in ISO registered facilities

VISIT OUR WEBSITE  
[www.dukane.com/us](http://www.dukane.com/us)

