

## Guideline for Thermoplastic Resins

Materials	Mould Shrinkage	Specific Gravity	Drying Condition Time/Temperature °C	Melt Temperature °C	Mould Temperature °C
ABS	0.4-0.8	1.04	2-4 hrs. 70-80	220-260	40-80
ACETAL	2.0-3.5	1.41	Not required	175-220	45-85
ACRYLIC	0.4-0.8	1.18	2-4hrs. 50-60	190-260	50-80
EVA	1.0-2.0	0.926 - 0.950	Not required	150-210	20-35
NYLON 6	1.0-1.8	1.14	2-4hrs. 80-90	230-280	40-80
NYLON 66	1.0-2.2	1.14	2-4hrs. 80-90	270-290	40-80
POLYCARBONATE	0.6-0.8	1.21	2-4hrs. 120	280-320	80-100
LD POLYETHYLENE	1.0-5.0	0.918 - 0.935	Not required	190-240	2-60
HD POLYETHYLENE	1.5-3.5	0.945 - 0.965	Not required	200-260	25-60
POLYPROPYLENE	1.0-2.0	0.905	Not required	190-275	20-60
POLYURETHANE	0.5-2.0	1.11-1.22	1-3hrs. 80	180-230	25-65
POLYSTYRENE	0.4-0.8	1.05	Not required	230-275	30-60

These properties are intended as guidelines only and refer to unmodified materials.  
For more detailed information please refer to manufacturers literature.