

POLYMER TYPE	ABBREVIATION	TEMPERATURE °C		DRYING		DEW POINT °C	MOISTURE CONTENT %
		MELT	MOLD	TEMP. °C	TIME (HRS)		
POLYPROPYLENE	PP	190-232	33-66	80	2	NA	NA
NYLON 6/6T	PA	277-299	66-108	80	4	-17	0.2
NYLON 6T	PA	244-280	55-94	83	2	-17	0.2
NYLON 6/10	PA	277-299	66-108	80	2	-17	0.2
NYLON 11	PA	235-288	38-66	80	4	-17	0.2
NYLON 6/12	PA	249-285	60-94	80	4	-17	0.2
NYLON, AMORPHOUS	PA	272-299	66-99	80	4	-34	0.1
NYLON 12	PA	222-274	66-105	80	4	-40	0.1
NYLON 6/6 IMPACT MODIFIED	PA	277-299	66-108	80	4	-18	0.2
POLYCARBONATE	PC	288-316	83-122	122	4	-29	0.02
POLYSTYRENE	PS	210-249	38-66	83	2	NA	NA
STYRENE ACRYLONITRILE	SAN	238-280	52-83	83	2	NA	NA
ACRYLONITRILE BUTADIENE STYRENE	ABS	205-238	63-85	83	2	-18	0.1
HIGH DENSITY POLYETHYLENE	HDPE	194-233	22-66	80	2	NA	NA
LOW DENSITY POLYETHYLENE	LDPE	194-233	22-66	80	2	NA	NA
ACETAL	POM	183-219	80-108	122	2	-32	0.15
POLYSULFONE	PSU	333-372	94-149	135	4	-32	0.15
POLYBUTYLENE TEREPHTHALATE	PBT	238-272	80-108	122	4	-29	0.03
POLYETHYLENE TEREPHTHALATE	PET	260-299	135-163	122	4	-40	0.01
POLYURETHANE THERMOPLASTIC ELASTOMER	TPUR	185-219	38-60	108	6	-18	0.01
POLYPHENYLENE SULFIDE	PPS	308-330	135-176	149	6	NA	0.04
POLYETHERSULFONE	PES	344-377	135-178	149	6	-32	0.04
POLYESTER THERMOPLASTIC ELASTOMER	TPE	310-238	22-49	94	2-4	NA	NA
POLYPHENYLENE OXIDE, MODIFIED	PPO	249-288	66-94	94	2	-18	0.1
ACRYLIC	PMMA	183-219	80-108	94	4	-18	0.02
POLYCARBONATE/ACRYLIC ALLOY	PC/PMMA	238-266	33-66	83	3-4	-18	0.02
POLYETHERIMIDE	PEI	355-399	135-177	149	4	-29	0.04
POLYETHERETHERKETONE	PEEK	349-400	163-219	149	3	-29	0.1
RIGID THERMOPLASTIC POLYURETHANE	RTPU	222-244	52-94	108	4-6	-32	0.01
RIGID THERMOPLASTIC POLYURETHANE	RTPU	238-260	94-122	133	4-6	-32	0.01
POLYCARBONATE/ABS ALLOY	PC/ABS	244-274	52-94	94	4	-29	0.02
STYRENIC THERMOPLASTIC ELASTOMER	TES	183-233	16-38	80	2	NA	NA
OLEFINIC THERMOPLASTIC ELASTOMER	TEO	183-210	15-66	80	2	-18	0.03
POLYMETHYLPENTENE	PMP	266-305	66-94	80	2	NA	NA
PERFLUOROALKOXY	PFA	344-385	149-233	122	2	NA	NA
ETHYLENE TETRAFLUOROETHYLENE	ETFE	294-345	66-149	122	2	NA	NA
POLYVINYLIDENE FLUORIDE	PVDF	210-288	83-105	122	2	NA	NA
LIQUID CRYSTAL POLYMER	LCP	333-366	66-122	149	8	-29	NA
LIQUID CRYSTAL POLYMER	LCP	363-398	66-94	149	8	-29	NA
FLUORINATED ETHYLENE PROPYLENE	FEP	344-385	94+	122	2-4	NA	NA
POLYPHTHALAMIDE	PPA	302-330	135-163	80	6	-32	0.05
POLYPHTHALAMIDE HOT WATER MOLDABLE	PPA	330-344	66-163	80	6	-29	0.1
THERMOPLASTIC POLYIMIDE	TPI	399-416	177-233	205	6	-40	0.01
POLYSULFONE/POLYCARBONATE ALLOY	PSU/PC	283-327	66-99	122	4	-29	0.02
NYLON, HIGH TEMPERATURE	NHT	310-344	135-163	80	4	-40	0.1
ALIPHATIC POLYKETONE	PK	222-260	83-149	60	4	-32	0.02
SYNDIOTACTIC POLYSTYRENE	SPS	294-327	72-149	83	2	-29	0.02
POLYTRIMETHYLENE TEREPHTHALATE	PTT	233-260	88-122	127	4-6	-40	0.01

This information is intended to be used only as guideline for designers and processors of modified thermoplastics for injection molding. Because injection mold design and processing is complex, a set solution will not solve all problems. Observation on a “trial and error” basis may be required to achieve desired results. Please try to ask your resin supplier as for your ideal processing condition.

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