

Processing / Drying Temperatures

Material	Process Melt Temp. (°F)	Mold Temperatures (°F)	Drying Temperatures (°F)	Hours	BD
ABS High Impact	440-510	90-180	190	4	42
ABS High Heat	510-540	140-180	190	4	42
ABS Med Impact	440-510	90-180	190	4	42
Acetal Copolymer / Homopolymer	380-420	140-220	200-210	1.5	40
Acrylic General Purpose	420-485	120-180	180	1.5	42
Acrylic High Heat	420-485	120-180	180	2.5	42
Acrylic High Impact	420-485	120-180	180	2.5	42
Nylon 6/6	500-560	120-180	180	4	41
Nylon 6	470-530	100-180	180	4	41
Nylon 6/12	460-510	100-180	180	4	41
Nylon 12	400-450	80-120	180	4	41
Polycarbonate	540-570	160-200	250	3.5	40
PET - Bottle	520-560	60-120	340	5	52
PBT	460-490		260	2.5	48
PBT 30% Glass	460-490				
Polyether	680-720	220-330	310	4	52
Polyethylene - Low Density	340-440	50-100			
Polyethylene - High Density	390-490	50-150			
PPO	480-580	150-220	210	2.5	49
Polypropylene	420-520	60-150			
Polystyrene - General Purpose	360-460	50-120			
Polystyrene - High Heat	400-480	50-120			
Polystyrene - High Impact	400-480	50-120			
PVC Rigid	320-420	50-120			
PVC Semi	320-420	50-120			
PVC Flexible	320-420	50-120			