



Borouge® PP Resin
Bormod™ Homopolymer PP
Bormod™ Copolymer PP
Bormod™ PP Impact Copolymer
Borclear™ Homopolymer PP
Fibremod™ Glass Fiber PP
Anteo™ LLDPE
Borstar® HDPE
Borstar® LDPE



DURACON® POM
DURANEX® PBT
DURAFIDE® PPS
LAPEROS® LCP
TOPAS® COC



SABIC® PP Resin
SABIC® LLDPE
SABIC® LDPE
Multimodal HDPE
Unimodal HDPE
SABIC® PS Resin
LEXAN™ PC Resin
CYCOLAC™ ABS
SABIC® Glass Fiber PP
SABIC® Homopolymer PP
SABIC® Impact Copolymer PP



Ultramid® PA6
Ultramid® PA66
Ultraform® POM
Bycolene® GPPS
Bycolene® HIPS



Ingeo™ PLA



POLYLAC® ABS
POLYLAC® MABS
WONDERLOY® PC/ABS
WONDERLITE® PC



Hostaform® POM
Celcon® POM
AMCEL POM
ZYTEL PA6 & PA66



Terluran® ABS
Styrolution® HIPS
Styrolution® GPPS
Rigidex® HDPE



Zytel® PA6
Zytel® PA66
Delrin® POM



台塑企業

HDPE & LDPE & LLDPE
PP Resin



LG Chem ABS
LG Chem MABS
LG Chem Homopolymer PP
LG Chem Copolymer PP
Lupoy® PC/ABS



Starex® ABS
LOTTE Chemical PE, PP, PC



Makrolon® PC
Bayblend® PC/ABS

Polymer	Specific Gravity	Drying Temperature (°F/Time)	Max Moisture Content for Injection Molding (%)	Mold Temp. (°F)	Melt Temp. (°F)	Mold Shrinkage (in/in)	Rule of Thumb Tonnage (Tons per Square Inch)	Vent Depth (in)	Vent Land (in)
ABS	1.04	180 / 3 Hrs	0.1	120-140	440-465	0.003-0.007	2.5-3.5	0.0015-0.0025	0.030-0.050
MABS	1.07	175 / 2-4 Hrs	0.04	105-175	465-520	0.004-0.007	2.5-3.5	0.0015-0.0025	0.030-0.050
PC/ABS	1.08-1.22	250 / 3 Hrs	0.03	150-190	460-500	0.005-0.007	4.0-5.0	0.0015-0.0030	0.030-0.050
HDPE	0.940-0.965	Not required	NH	50-200	400-500	0.025-0.035	2.5-3.5	0.0008-0.0010	0.050-0.060
LDPE	0.915-0.935	Not required	NH	70-140	400-500	0.015-0.026	2.0-3.0	0.0005-0.0007	0.040-0.050
LLDPE	0.915-0.930	Not required	NH	70-160	400-500	0.015-0.035	2.0-3.0	0.0005-0.0007	0.040-0.050
PP (Homopolymer)	0.9	Not required	NH	100-210	460-520	0.010-0.025	2.5-3.5	0.0010-0.0020	0.040-0.050
PP (Copolymer)	0.9	Not required	NH	100-210	460-520	0.010-0.025	2.5-3.5	0.0010-0.0020	0.040-0.050
GPPS	1.04	170 / 2 Hrs	NH	60-160	390-475	0.003-0.007	2.0-2.5	0.0010-0.0030	0.030-0.050
HIPS	1.05	170 / 2 Hrs	NH	60-160	390-475	0.003-0.007	2.0-2.5	0.0010-0.0030	0.050-0.060
POM (Acetal)	1.41	180 / 1 Hr	0.02	170-200	370-390	0.018-0.035	3.0-4.0	0.0005-0.0015	0.040-0.050
PA6 (Nylon 6)	1.13	165 / 2-4 Hrs	0.2	180-200	460-520	0.009-0.012	3.0-4.0	0.0005-0.0010	0.040-0.050
PA66 (Nylon 66)	1.14	165 / 2-4 Hrs	0.2	150-200	520-530	0.015-0.020	3.0-4.0	0.0005-0.0010	0.020-0.040
PC	1.2	250 / 2-4 Hrs	0.02	160-250	500-600	0.005-0.007	4.0-5.0	0.0010-0.0030	0.050-0.060
PLA	1.24	130 / 2-6 Hrs	0.02	68-140	338-374	0.002-0.006	2.0-4.0	0.0010-0.0020	0.040-0.050
PEEK	1.32	300 / 3-4 Hrs	0.02	300-400	662-752	0.006-0.012	4.0-5.0	0.0005-0.0010	0.030-0.040
PVC	1.38	165-195 / 1.5-2.5 Hrs	0.02-0.05	85-115	320-375	0.001-0.005	2.5-4.0	0.0005-0.0010	0.030-0.050
PET	1.38	300-320 / 3-5 Hrs	0.02	275-290	520-550	0.015-0.025	3.0-5.0	0.0008-0.0012	0.040-0.060
PPS	1.35	275-300 / 2-4 Hrs	0.02	275-325	580-650	0.004-0.008	4.0-5.0	0.0005-0.0010	0.030-0.050
PEI	1.27	300 / 4-6 Hrs	0.02	158-347	644-780	0.005-0.007	4.0-5.0	0.0008-0.0015	0.040-0.050