



# General Polymers

## Thermoplastic Materials

Material	Process Melt Temp. (°F)	Mold Temp.	Temp (°F)	Hours
ABS High Impact	440-510	90-180	190	4
ABS High Heat	510-540	140-180	190	4
ABS Med Impact	440-510	90-180	190	4
Acetal	380-420	140-220	Homo 200 Co 210	1.5
Acrylic Gen Purpose	420-485	120-180	180	1.5
Acrylic High Heat	420-485	120-180	180	2.5
Acrylic High Impact	420-485	120-180	180	2.5
Nylon 6/6	500-560	120-180	180	4
Nylon 6	470-530	100-180	180	4
Nylon 6/10	460-510	100-180	180	4
Nylon 12	400-450	80-120	180	4
Polycarbonate Med Vis.	540-570	160-200	250	3.5
PET - Bottle	520-560	60-120	340	5
PBT	460-490		260	2.5
PBT 30% Glass Filled	460-490			
Polyetherimide	680-720	220-330	310	4
Polyethylene LD	340-440	50-100		
Polyethylene HD	390-490	50-150		
PPO	480-580	150-220	210	2.5
Polypropylene	420-520	60-150		
Polystyrene Gen 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 Rigid	320-420	50-120		
PVC Flexible	320-420	50-120		
SAN	400-500	70-120	180	3

**Contact Us: 800-920-8033 or [Info@GP-Materials.com](mailto:Info@GP-Materials.com)**

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