Bank of America Tower 2508
12 Harcourt Rd, Central
Hong Kong

Plastic Materials Overview

Name	Grade	Spec. Grav.	Shrink %	D-Temp °F (°C)	D-Time (h)	Mold °F (°C)	Process °F (°C)
Acetal	Acetal	1.39-1.42	1.8-2.2	175-220 (80-105)	2-3 h	170-220 (80-105)	370-440 (190-225)
Acrylic	PMMA	1.08-1.20	0.2-0.6	150-200 (65-90)	3-6h	100-200 (40-95)	350-500 (175-260)
Acrylonitrile Butadiene Styrene	ABS	1.02-1.05	0.4-0.8	170-200 (75-95)	2-4h	120-190 (50-90)	425-500 (220-260)
Chlorinated Polyvinylchloride	CPVC	1.20-1.30	0.5-2.5	160-180 (70-80)	1-2h	50-175 (10-80)	375-435 (190-225)
High Density Polyethylene	HDPE	0.95-0.96	1.5-4.5	140-160 (60-70)	1-2h	80-100 (25-40)	380-550 (195-290)
High Impact Polystyrene	HIPS	1.04-1.06	0.4-0.8	N/A	N/A	70-140 (20-60)	410-500 (210-260)
Ionomer	Ionomer	0.94-0.98	0.4-0.8	140-175 (60-80)	2-4h	40-120 (5-50)	420-530 (215-275)
Linear Low Density Polyethylene	LLDPE	0.91-0.93	1.5-4.5	N/A	N/A	70-90 (20-30)	325-550 (165-290)
Low Density Polyethylene	LDPE	0.91-0.93	1.5-4.5	N/A	N/A	70-90 (20-30)	325-550 (165-290)
Nylon-11	Nylon-11	1.04-1.05	1.0-2.0	150-200 (65-95)	3-4h	100-150 (40-65)	440-550 (225-285)
Nylon-12	Nylon-12	0.97-1.06	0.6-1.6	160-200 (70-95)	3-10h	100-180 (40-80)	450-570 (230-300)
Nylon-12/12	Nylon-12/12	1.06-1.08	1.0-1.5	160-220 (70-105)	2-4h	100-250 (40-120)	500-580 (260-305)
Nylon-4/6	Nylon-4/6	1.18-1.21	1.6-2.0	180-220 (80-105)	2-4h	180-300 (80-150)	580-600 (305-315)
Nylon-6	Nylon-6	1.10-1.14	0.8-1.5	150-200 (65-95)	2-6h	120-200 (50-95)	460-520 (240-270)
Nylon-6/10	Nylon-6/10	1.07-1.08	1.0-2.0	160-200 (70-95)	2-4h	120-220 (50-105)	480-550 (250-290)
Nylon-6/12	Nylon-6/12	1.03-1.08	1.0-1.5	150-200 (65-95)	2-4h	100-200 (40-95)	450-550 (230-290)
Nylon-6/6	Nylon-6/6	1.09-1.14	1.0-2.0	160-220 (70-105)	2-4h	100-200 (40-95)	500-580 (260-305)
PC-ABS Alloy	PC-ABS	1.10-1.14	0.4-0.8	180-220 (80-105)	3-5h	120-200 (50-95)	480-540 (250-280)
PC-PET Alloy	PC-PET	1.20-1.22	0.6-1.0	190-230 (90-110)	3-5h	130-190 (55-90)	490-550 (255-290)
PC-Polyester Alloy	PC-Polyester	1.18-1.22	0.4-1.0	190-240 (90-115)	3-5h	90-170 (30-75)	480-550 (250-290)
Polyaryletherketone	PAEK	1.37-1.50	1.2-1.6	300-320 (150-160)	2-10h	300-425 (150-220)	700-800 (370-425)
Polybutylene Terephthalate	PBT	1.30-1.34	0.6-2.0	200-280 (95-140)	2-5h	100-200 (40-95)	450-500 (230-260)
Polycarbonate	PC	1.15-1.21	0.5-0.8	240-260 (115-125)	3-5h	160-220 (70-105)	500-620 (260-325)
Polyester	Polyester	1.36-1.40	1.5-2.0	200-270 (95-130)	3-4h	60-120 (15-50)	450-510 (230-265)
Polyetheretherketone	PEEK	1.37-1.50	1.0-2.0	290-310 (145-155)	2-10h	325-425 (165-220)	660-750 (350-400)
Polyetherimide	PEI	1.27-1.36	0.4-0.7	250-300 (120-150)	4-6h	175-350 (80-175)	640-800 (340-425)
Polyethersulfone	PES	1.37-1.50	0.8-1.0	260-300 (125-150)	2-10h	250-360 (120-180)	640-730 (340-385)
Polyethylene Terepthalate	PET	1.25-1.40	0.2-0.5	250-325 (120-160)	3-6h	50-200 (10-90)	480-580 (250-305)
Polyethylene Terepthalate Glycol	PETG	1.25-1.40	0.2-0.5	150-175 (65-80)	3-6h	50-150 (10-65)	300-500 (150-260)
Polyphenylene Oxide	PPO	1.05-1.10	0.5-0.7	190-240 (90-115)	2-4h	140-200 (60-95)	490-590 (255-310)
Polyphenylene Sulfide	PPS	1.34-1.40	1.0-1.2	250-320 (120-160)	2-4h	280-320 (140-160)	580-640 (305-340)
Polypropylene	PP	0.89-0.92	1.0-2.0	N/A	N/A	70-140 (20-60)	390-510 (200-265)
Polystyrene	PS	1.04-1.06	0.3-0.7	N/A	N/A	50-150 (10-65)	350-525 (175-275)
Polysulfone	PSU	1.23-1.25	0.4-0.8	250-300 (120-150)	4-16h	200-325 (95-165)	625-725 (330-385)
Polyurethane	PUR	1.18-1.20	0.4-0.8	180-280 (80-140)	4-12h	50-150 (10-65)	425-525 (220-275)
Polyvinylchoride	PVC	1.20-1.34	0.5-2.5	160-180 (70-80)	1-2h	70-125 (20-50)	330-400 (165-205)
Styrene Acrylonitrile	SAN	1.07-1.11	0.3-0.7	160-180 (70-80)	1-2h	110-180 (45-80)	420-500 (215-260)
Thermoplastic Elastomer	TPE	0.90-1.15	0.5-2.0	150-200 (65-95)	2-4h	50-150 (10-65)	350-450 (175-230)
Thermoplastic Elastomer Polyolefin	TPO	0.91-1.10	0.8-2.0	N/A	N/A	50-150 (10-65)	375-500 (190-260)