

Polymer	Specific Gravity	Drying Parameters 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
ABS+Nylon	1.07-1.12	175-190 / 4 hrs	0.1	105-175	465-520	0.008-0.009	3.0-4.0	0.0005-0.0010	0.020-0.040
ASA	1.07	175 / 2-4 hrs	0.04	105-175	465-535	0.004-0.007	2.5-3.5	0.0015-0.0025	0.030-0.050
CoPolyester	1.17-1.19	180-190 / 4-6 hrs	0.02	100-150	500-540	0.005-0.007	3.0-5.0	0.0005-0.0015	0.040-0.060
EVA	0.92-0.97	Not required	NH	60-105	300-425	0.007-0.020	2.0-3.0	0.0005-0.0007	0.040-0.060
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	0.030-0.050
LCP	1.50-1.90	250-300 / 4 hrs	0.01	175-250	550-650	0.000-0.004	1.5-2.5	0.0005-0.0010	0.020-0.040
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	0.020-0.040
PA6 Reinforced	1.18-1.49	165 / 2-4 hrs	0.12	180-220	515-565	0.002-0.005	4.0-5.0	0.0005-0.0025	0.030-0.050
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
PA66 Reinforced	1.22-1.49	165 / 2-4 hrs	0.12	180-220	540-570	0.003-0.008	4.0-5.0	0.0005-0.0025	0.030-0.050
PBT	1.31	280 / 3-4 hrs	0.02	100-200	460-500	0.017-0.023	3.0-4.0	0.0005-0.0015	0.030-0.050
PBT Reinforced	1.52	280 / 3-4 hrs	0.02	140-220	480-525	0.003-0.006	4.0-5.0	0.0005-0.0020	0.030-0.040
PC	1.2	250 / 4 hrs	0.02	160-200	550-600	0.005-0.007	4.0-5.0	0.0010-0.0030	0.030-0.050
PC Reinforced	1.25-1.52	250 / 6 hrs	0.02	190-250	600-650	0.001-0.004	4.0-5.0	0.0010-0.0030	0.030-0.050
PC/ABS	1.08-1.22	250 / 3 hrs	0.03	150-190	460-500	0.005-0.007	3.0-4.0	0.0015-0.0030	0.030-0.050
PC/PBT	1.19-1.24	250 / 3-4 hrs	0.02	130-180	490-520	0.007-0.016	4.0-5.0	0.0005-0.0010	0.030-0.060
PE-HDPE	0.940-0.965	Not required	NH	50-200	400-500	0.025-0.035	2.5-3.5	0.0008-0.0010	0.020-0.040
PE-LDPE	0.915-0.935	Not required	NH	70-140	400-500	0.015-0.026	2.0-3.0	0.0005-0.0007	0.020-0.040
PE-LLDPE	0.915-0.930	Not required	NH	70-160	400-500	0.015-0.035	2.0-3.0	0.0005-0.0007	0.020-0.040
PET Reinforced	1.44-1.73	250 / 3 hrs	0.02	180-250	540-580	0.002-0.005	4.0-5.0	0.0005-0.0010	0.030-0.060
POM Acetal	1.41	180 / 1 hr	NH	170-200	370-390	0.018-0.035	3.0-4.0	0.0005-0.0015	0.040-0.050
PP	0.9	Not required	NH	100-210	460-520	0.010-0.025	2.5-3.5	0.0010-0.0020	0.020-0.040
PPS	1.40-2.00	260 / 3-4 hrs	0.06	275-325	560-640	0.003-0.010	3.5-4.5	0.0005-0.0010	0.030-0.050
PSU	1.30-1.37	260-300 / 4 hrs	0.02	280-350	640-730	0.008-0.010	4.0-5.0	0.0010-0.0015	0.030-0.050

DISCLAIMERS: The summary data listed here is provided free of charge and all advice given are merely suggestions made without a warranty of any kind. The described product properties fall within nominal ranges but should not be used to establish specification limits or as a basis for design. Shrinkage data are general guidelines only, provided solely to allow comparison with other materials. They should not be used as the source of information for generating core and cavity mold dimensions. Bamberger Amco Polymers assumes no obligation or liability for any advice furnished, for the results obtained, or for use of any products in infringement of any patent. Users must make their own representative testing and assumes all risks of use, whether the products is used alone or in combination with other materials. ALL WARRANTIES, EXPRESSED OR IMPLIED, OF MERCHANTABILITY, AND FITNESS FOR A PARTICULAR PURPOSE OR USE ARE EXCLUDED AND DISCLAIMED. All data displayed herein has been obtained via testing of injected molded specimens of natural color. Pigmentation may affect certain properties and impact the results achieved.



SUPPLIER LINE CARD

24/7 CUSTOMER SERVICE

800.262.6685 | WWW.BAPOLYMERS.COM

alphagary

Specialty Compounds

Flexible PVC
Rigid PVC



ColorFast®
ColorRx®
InStruc®
InLube™
InElec®
Surlyn Reflection Series®



Amalloy® Clear & Specialty Polymers
AMCO® PBT
AMCO® PC/ABS
AMCO® PC/PBT
AMCO® PET
AMCO® PPE/Nylon
Bapolan® Acetal (POM) Copolymer
Bapolan® Nylon
Bapolan® PC
Bapolene® ABS
Bapolene® HDPE
Bapolene® LDPE
Bapolene® LLDPE
Bapolene® MABS
Bapolene® PET
Bapolene® PP Homopolymer
Bapolene® EVA Copolymer
Bapolene® PP Impact Copolymer
Bapolene® PP Random Copolymer
Blends
Color Concentrates
PRIMATOP® PP-PE-PS-PET
TRILAC® ABS
TRIMID® PA6 & PA66
TRISTAR® Polycarbonate

BASF

We create chemistry

Ecoflex® Compostable BioPolymer
Ecovio® Compostable BioPolymer
NYPEL® | Recycled PA6 & PA66
PETRA® | Recycled PET
ULTRADUR® | PBT
ULTRAFORM® | POM
ULTRAMID® | PA6, PA66, PA66/6
ULTRAMID® | PA610, PA6T/6
ULTRAMID® ADVANCED | PPA
ULTRASON® | PES, PSU, PPSU



Baystar HDPE
Baystar Medium Density PE
Baystar Metallocene PE
Baystar Rotational Molding PE



Blue Polymers PCR HDPE
Blue Polymers PCR PP



The chemistry inside innovation™

Santoprene® TPV



Marlex® Anew™ Circular PE
Marlex® PE



Desmopan® TPU
Texin® TPU

EASTMAN

DuraStar™ Polymer
Eastalloy™ Polymer
Eastapak™ PET Copolyester
Estar™ Copolyester
Ecdel™ Elastomers
Provista™ Copolymer
Tenite™ Cellulosics
Treva™ Engineering Bioplastic
Tritan™ Copolyester



ENPLAST®

EnFlex® EA TPE Over-Molding Resins
EnFlex® MD Medical Grade TPE
EnFlex® S Styrenic Based TPE
EnFlex S® SEBS
Ensoft® SEBS-SBS
Ravathane® TPU
RAVATUF™ TPO
RAVATUF™ XR TPO with PIR/PCR



Enviroplas Compounds



Formosa Plastics

Formolene® PE
Formolene® PP



PACKAGING RESIN

AlphaPet Performance™ PET
Auriga Polymers Polyclear® PET
StarPet Performance® PET

INEOS

Olefins & Polymers USA

Ineos HDPE
Ineos PP Homopolymer
Ineos PP Impact Copolymer
Ineos PP Random Copolymer
Ineos TPO



DuraTemp™ Specialty PP
Impact Copolymer PP
MedSelect™ Specialty PP
Random Copolymer PP



Ingeo™ PLA Biopolymers



NOVAPOL® PE
SCLAIR® PE



CPPP Copylene™
HPPP Copylene™
RCPD Copylene™



ECHO® Recycled PP
ECHO® Recycled PE
EnViramid® PCR PA6 & PA66
Mafill® PCR & PIR PP
Ravaplen® PIR PP
Ravapura® PCR PE
Scolefin® Prime PP



ENGINEERED THERMOPLASTIC RESINS

CYCOLAC™ Resin ABS
CYCOLAC™ FR Resin ABS
CYCOLOY™ Resin PC/ABS
CYCOLOY™ FR Resins PC/ABS
GELOY™ Resin ASA
LEXAN™ Resin PC
LEXAN™ FR Resin PC
VALOX™ Resin PBT
VALOX™ FR Resins PBT
XENOY™ Resin PC/PBT
XYLEX™ Resin PC/PET

COLORXPRESS™ Service

POLYPROPYLENE

SABIC® PP
SABIC® PPcompound
STAMAX™
- Long Glass Fiber-Reinforced PP

POLYETHYLENE

COHERE™ Metallocene POP
FORTIFY™ POE
SABIC® Butene LLDPE
SUPEER™ Metallocene LLDPE



NORYL™ RESINS

FLEX NORYL™ Resin
NORYL™ Resin
NORYL GTX™ Resin
NORYL PPX™ Resin

ULTEM™ and HIGH HEAT RESINS

EXTEM™ Resin
SILTEM™ Resin
ULTEM™ Resin

LNP™ COMPOUNDS/ PC COPOLYMER RESINS

CYCOLOY™ FR Resin
CYCOLOY™ non-FR Resin
LEXAN™ Copolymer
LEXAN™ FR Resin
LEXAN™ VISUALFX™ Resin
LNP™ COLORCOMP™ Compound
LNP™ ELCRES™
LNP™ ELCRIN™
LNP™ FARADEX™ Compound
LNP™ KONDUIT™ Compound
LNP™ LUBRICOMP™ Compound
LNP™ LUBRILOY™ Compound
LNP™ STAT-KON™ Compound
LNP™ STAT-LOY™ Compound
LNP™ THERMOCOMP™ Compound
LNP™ THERMOTUF™ Compound
LNP™ VERTON™ Compound
VALOX™ FR Resin
XENOY™ FR Resin

COLORXPRESS™ Service



Polypropylene
Polystyrene



ELEVATE® EVA Copolymer
EMAC® and EBAC® Acrylate Resins
MXSTEN® Plastomers
TYMAX® Functionalized Polymers
EPOLENE® Polymers
Westlake LLDPE
Westlake LDPE
Westlake MDPE