



INJECTION MOLDING GUIDELINE

Polymer Type	Melt Temperature (°C)		Mold Temperature (°C)		Drying Temperature (°C)	Drying Time (hrs)
	Low	High	Low	High	(°C)	(Hour)
ABS	190	230	60	85	82	2 - 4
SAN	200	240	60	90	90	3 - 4
PC/ABS	230	260	50	80	90	4
PC/Polyesters	240	260	45	60	60 - 80	3 - 5
PC/PET	240	270	60	90	90 - 100	2 - 4
PC/PBT	240	270	60	90	90 - 100	2 - 4
PC/Copolyester	245	265	45	60	65 - 80	3 - 5
ASA	180	220	40	80	80 - 90	2 - 3
PC/ASA	220	270	50	80	80 - 90	2 - 4
PA/ABS*	230	260	60	80	80	2 - 4
PBT/ABS	230	250	60	80	80 - 120	2 - 5
PBT/ASA	240	260	60	100	100 - 130	2 - 4
PA6*	240	280	60	90	80	4
PA66*	270	310	60	90	80	4
高抗冲PA66*	250	280	60	90	80	4
MXD6*	250	280	100	120	80	2 - 4
PA56*	270	290	55	90	80	3 - 5
PA610*	270	300	70	120	80	2 - 4
PBT	240	260	50	100	140	2
PC*	280	330	70	100	100 - 120	4
POM	170	220	60	100	90 - 110	3 - 6
POK	230	250	80	100	60 - 80	4 - 6
PP	190	230	30	60	70 - 90	2 - 3
m-PPE (一般通用)	250	280	55	80	80 - 90	3 - 4
m-PPE (高温)	260	300	90	120	110 - 120	3 - 4
PPS	300	350	130	170	150	6
PS	190	230	40	60	70 - 80	2
LDPE	180	210	20	60	80	2
HDPE	180	220	20	60	80	2
TPO	180	220	20	60	80	2
TPEE	210	240	40	70	90	2 - 4
SBS	160	220	40	70	80	2
SEBS	170	250	40	70	80	2
PMMA	180	220	40	80	90	4

*De-humidify Dryer is recommended for moisture sensitive plastics. Under normal conditions, 10%-20% of the crushed material may be added subject to manufacturers own testing and quality requirement. However, for parts requested the higher physical properties, the crushed material loading percentage must be tested. Since generally the crushed material is in high water content, longer drying time is recommended when the production contained with crushed material.

Notice: The above "Injection Molding Guideline" should only be consider as a reference point and a guideline to injection molding. Manufacturers and molders must carry out their own test and fine tune the optimal injection molding condition for the particular products or parts. No warranty is given by Cheng Yu Plastic Company Limited concerning the accuracy and completeness of the information presented.