

Plastic Injection Molding Material Shrinkage Guide



Material	Recommended Tonnage (per in ²)	Shrink Values	Vent Depth (in.)
<i>Acrylonitrile Butadiene Styrene (ABS)</i>	2.5 - 3.5	.004 - .008	.0010 - .0020
<i>ABS/Polycarbonate Blend (PC/ABS)</i>	3.0 - 4.0	.004 - .007	.0015 - .0030
<i>Acetal (POM)</i>	3.0 - 4.0	.020 - .035	.0005 - .0015
<i>Acrylic (PMMA)</i>	3.0 - 4.0	.002 - .010	.0015 - .0020
<i>Ethylene Vinyl Acetate (EVA)</i>	2.0 - 3.0	.010 - .030	.0005 - .0007
<i>Ionomer</i>	2.5 - 3.5	.003 - .020	.0005 - .0007
<i>High Density Polyethylene (HDPE)</i>	2.5 - 3.5	.015 - .030	.0008 - .0010
<i>Low Density Polyethylene (LDPE)</i>	2.0 - 3.0	.015 - .035	.0005 - .0007
<i>Polyamide - Nylon (PA) Filled</i>	4.0 - 5.0	.005 - .010	.0003 - .0010
<i>Polyamide - Nylon (PA) Unfilled</i>	3.0 - 4.0	.007 - .025	.0005 - .0020
<i>Polybutylene Terephthalate (PBT)</i>	3.0 - 4.0	.008 - .010	.0005 - .0015
<i>Polycarbonate (PC)</i>	4.0 - 5.0	.005 - .007	.0010 - .0030
<i>Polyester</i>	2.5 - 3.5	.006 - .022	.0005 - .0010
<i>Polyetheretherketone (PEEK)</i>	4.0 - 5.0	.010 - .020	.0005 - .0007
<i>Polyetherimide (PEI)</i>	3.0 - 4.0	.005 - .007	.0010 - .0015
<i>Polyethylene (PE)</i>	2.5 - 3.5	.015 - .035	.0005 - .0020
<i>Polyethersulfone (PES)</i>	3.0 - 4.0	.002 - .007	.0005 - .0007
<i>Polyphenylene Oxide (PPO)</i>	3.0 - 4.0	.005 - .007	.0010 - .0020
<i>Polyphenylene Sulfide (PPS)</i>	3.5 - 4.5	.002 - .005	.0005 - .0010
<i>Polyphthalamide (PPA)</i>	3.5 - 4.5	.005 - .007	.0005 - .0020
<i>Polypropylene (PP)</i>	2.5 - 3.5	.010 - .030	.0005 - .0020
<i>Polystyrene (PS)</i>	2.0 - 2.5	.002 - .008	.0015 - .0020
<i>Polysulphone (PSU)</i>	4.0 - 5.0	.006 - .008	.0010 - .0015
<i>Polyurethane (PUR)</i>	2.5 - 3.5	.010 - .020	.0004 - .0010
<i>Polyvinyl Chloride (PVC)</i>	2.5 - 3.5	.002 - .030	.0005 - .0020
<i>Thermoplastic Elastomer (TPE)</i>	2.5 - 3.5	.005 - .020	.0008 - .0010

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