

Extruded Sheet and Rollstock Thermoforming Information

Material	Forming Range (°F)	Ideal Forming Temp (°F)	Maximum Heating Speed* (mils/sec)	Maximum Cooling Speed (mils/sec)	Maximum Demolding Temp (°F)	Mold Shrinkage (inch/inch)	Type of Heating Elements Required
High Impact ABS	340-390	370	1.8	2.5	180	0.0050-0.0070	Any Type
Medium Impact ABS	340-390	365	1.8	2.5	175	0.0050-0.0070	Any Type
Low Impact ABS	340-390	365	1.8	2.5	175	0.0045-0.0065	Any Type
Noryl EN265	325-400	370	1.4	1.4	210	0.0050-0.0070	Any Type
High Impact Polystyrene (HIPS)	330-350	340	2.0	2.5	175	0.0045-0.0065	Any Type
High Density Polyethylene (HDPE)	330-400	370	1.6	1.5	155	0.0220-0.0300	Any Type
Low Density Polyethylene (LDPE)	290-350	325	1.7	1.5	135	0.0250-0.0320	Any Type
High Molecular Weight Polyethylene (HMWPE)	330-400	360	1.6	1.5	155	0.0220-0.0320	Any Type
Copolymer Polypropylene	325-355	340	1.6	1.5	175	0.0200-0.0280	Any Type
Formalloy™ TPO	300-350	330	1.6	1.5	160	0.0110-0.0130	Any Type
Extreme TPO	300-330	315	1.6	1.5	160	0.008-0.0100	Any Type
EnviroTuf 22 (Glass filled PP)	300-350	330	1.6	1.5	160	0.0110-0.0130	Any Type
Tuf-Glas (Acrylic)	340-390	365	1.8	2.5	175	0.0050-0.0070	Any Type
SunGard® / DuraGard®(Polycarbonate)	360-420	385	1.7	2.5	190	0.0060-0.0090	Any Type
WeatherPro Acrylic/ABS	340-390	365	1.8	2.5	175	0.0050-0.0072	Any Type
PETG	330-380	350	1.4	2.0	135	0.0050-0.0070	Any Type
GTX	380-425	410	-	-	-	0.0130-0.0140	Any Type

* Assumes two-sided heat

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Floorlite TPR-1	290-320	300	1.0	1.0	140	0.0130-0.0220	Any Type
Floorlite TPR-2 Plus	290-320	300	1.0	1.0	140	0.0140-0.0280	Any Type
Floorlite C	290-320	300	1.0	1.0	140	0.0110-0.0220	Any Type
SoundX 100 Mass Loaded PVC (Flexible)	340-360	350	1.0	1.0	140	0.0050-0.0090	Any Type
Straight PVC (Rigid)	330-370	355	1.3	1.5	155	0.0040-0.0050	Any Type
FR ABS (Non-PVC)	340-390	365	1.7	2.5	180	0.0050-0.0070	Any Type
PC / ABS	360-420	385	1.7	2.5	190	0.0060-0.0090	Any Type
Royalite® HG & R52 (PVC/Acrylic)	330-380	355	1.3	2.5	155	0.0040-0.0060	Any Type
Royalite® R57 & R59	325-400	360	1.6	2.5	160	0.0045-0.0065	Any Type
Royalite® R60 & R61	330-380	360	1.3	2.5	155	0.0040-0.0065	Any Type
Royalite® R63 (PVC/ABS)	340-380	365	1.6	2.5	160	0.0045-0.0065	Any Type
Royalite® R85/21 (UV Cap ABS)	340-390	370	1.8	2.5	170	0.0050-0.0070	Any Type
Royalite® R104	280-340	Back – 355 Front - 315	1.2	1.5	160	0.0050-0.0070	Ceramic, Nichrome Wire, Calrod, Radiant

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For additional information, please contact Spartech at 800-677-4338 (800-67-SHEET), e-mail info@spartech.com or visit our website at www.spartech.com

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