

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
TufGlas® (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) Conductive	340–380	365	1.6	2.5	160	0.0045–0.0065	Any Type
Royalite® R64 (PE) Conductive	340–400	370	1.7	1.6	155	0.200–0.0320	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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11650 Lakeside Crossing Ct., Maryland Heights, MO, 63146 • 800-677-4338 • www.spartech.com

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