

# Plastic Injection Molding Material Shrinkage Guide

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

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