



Setup Temperatures for Thermal Pressing Inserts

****general rule-if your plastic is not listed, set the machine temp to 28°C/50°F above the melt temp found on your plastic's data sheet**

COMMON BRAND NAMES	PLASTIC	START TEMP °F	START TEMP °C	MAX TEMP °F	MAX TEMP °C
CYCOLAC	ABS	300	149	500	260
CYCOLOY	ABS/POLYCARBONATE	375	191	575	302
CELCON DELTRIN	ACETAL	300	149	450	232
PLEXI GLASS	ACRYLIC	300	149	425	218
	ACRYLIC/POLYCARBONATE	350	177	500	260
	ACRYLONITRILE	330	166	425	218
PE-TFE	FLORINATED ETHYLENE PROPYLENE	550	288	650	343
XYDAR LCP	LIQUID CRYSTAL POLYMER(filled/unfilled)	480	249	650	343
NORYL	PHENYLENE OXIDE	270	132	490	254
NYLON 66	POLYAMIDE(glass filled)	450	232	550	288
NYLON	POLYAMIDE	375	191	500	260
DURAFLEX	POLYBTYLENE	240	116	380	193
LEXAN	POLYCARBONATE	420	216	560	293
XENOY	POLYCARBONATE/POLYESTER	450	232	650	343
CELANEX	POLYESTER	375	191	525	274
VALOX	POLYETHER SULFONE	550	288	700	371
ULTEM	POLYETHERMIDE	450	232	800	427
P/E	POLYETHYLENE	300	149	500	260
RADEL R 5000	POLYPHENYLSULFONE	550	288	700	371
VESPEC	POLYIMIDE	675	357	800	427
	POLYMETHYPENTANE	460	238	610	321
PREVEX	POLYPHENYLELE OXIDE	350	177	625	329
PPS RYTON	POLYPHENYLENE SULFIDE	540	282	670	354
	POLYPHTHALAMIDE	560	293	660	349
	POLYPROPYLENE	325	163	550	288
	POLYSTYRENE	300	149	500	260
	POLYURETHANE(THERMOPLASTIC)	310	154	525	274
PVC	POLYVINYLCHLORIDE COPOLYMER	250	121	400	204
	POLYSULFONE	500	260	700	260
HIPS	POLYSTYRENE	290	143	500	260