

# PRIMEX PLASTICS CORPORATION

A subsidiary of ICC Industries Inc.

## Mold Shrinkage

Polymer	Typical Value (in/in)
ABS	.003 - .006
HIPS	.003 - .006
LDPE	.016 - .022
Heavy Gauge HDPE	Male Tool – MD .020, TD .016 Female Tool – MD .027, TD .022
Thin Gauge HDPE	TF – Mold Temp @ 170°F .015 - .035 PF – Mold Temp @ 100°F .014 - .020
HMWPE	Approximately 5% more than HDPE
PP	MD .010 - .015
High Melt Strength PP	MD .015 - .018
PETG	MD .003 - .006
Tuff-X	Material specific contact Paul or Matt for suggested values
Tuff-X HG	MD .012 - .015

Values are expressed as typical of the polymer and should not be considered or used as specifications. Values are intended to represent reference/starting points for setting up and ordering tooling. Actual values based on individual applications/processes may be different and Primex always recommends that tool prototyping be conducted before mold drawings are finalized.

MD = Machine Direction (with the grain, typically the length)  
TD = Transverse Direction (across the grain, typically the width)  
TF = Thermoforming  
PF = Pressure Forming

**Note:** These typical results are based on test procedures, which are believed to be reliable. Due to variable conditions or methods of processing, NO GUARANTEES OR WARRANTIES ARE EXPRESSED OR IMPLIED INCLUDING THE IMPLIED WARRANTY OF MERCHANTABILITY AND FITNESS FOR A SPECIFIC PURPOSE, nor any recommendations made to infringe on any patents.

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