

Polymer Shrinkage

Material	Density g/cm ³	Molding Shrinkage (%)
LDPE	0.92-0.93	1.5-5.0%
LLDPE	0.92-0.94	2.0-2.2%
EVA	0.92-0.94	0.7-3.5%
HDPE	0.95-0.97	1.5-4.0%
HDPE (30%GF)	1.18-1.28	0.2-0.6%
PP (homopolymer)	0.90-0.92	1.0-2.5%
PP (copolymer)	0.89-0.91	1.0-2.5%
PP (10~40% Talc)	0.97-1.27	0.8-2.2%
PP (10~40% CaCO ₃)	0.97-1.25	0.7-1.8%
PP (10~40% Mica)	0.99-1.33	0.5-1.5%
PP (10~30% GF)	0.97-1.14	0.2-0.8%
PP (40% GF)	1.22-1.23	0.3-0.5%
PS	1.04-1.05	0.4-0.8%
PS (20%GF)	1.2	0.1-0.3%
PS (30%GF)	1.29	0.1-0.2%
HIPS	1.03-1.06	0.4-0.7%
SAN	1.06-1.08	0.3-0.5%
SAN (20%GF)	1.22-1.40	0.1-0.3%
ABS	1.04-1.08	0.4-0.9%
ABS (20%GF)	1.18-1.22	0.1-0.2%
ABS (30%GF)	1.29	0.2-0.3%
PMMA	1.17-1.20	MD 0.1-0.4% / TD 0.2-0.8%
PMMA	1.15	0.3-0.8%
MXD6 (20%GF)	1.52	0.43%
MXD6 (30%GF)	1.46	0.51-0.57%
MXD6 (40%GF)	1.56	0.42-0.49%
MXD6 (50%GF)	1.65-1.67	0.35-0.47%
MXD6 (55%GF)	1.7	0.21%
MXD6 (60%GF)	1.79	0.40%
MXD6 (20%CF)	1.43	0.15%
MXD6 (30%CF)	1.35	0.23%
MXD6 (20%MR)	1.64	0.44%
PC (10%GF)	1.27	MD 0.3-0.5% / TD 0.4-0.6%
PC (20%GF)	1.35	MD 0.1-0.3% / TD 0.3-0.5%
PC (30%GF)	1.43	MD 0.5-0.25% / TD 0.25-0.45%
PC (40%GF)	1.52	MD 0.05-0.25% / TD 0.2-0.4%

Polymer Shrinkage

PC (50%GF)		
PC (10%CF)	1.24	MD 0.1-0.3% / TD 0.3-0.5%
PC (20%CF)	1.28	MD 0.05-0.2% / TD 0.2-0.4%
PC (30%CF)	1.31	MD 0.01-0.15% / TD 0.2-0.4%
PC (10%GF 10%CF)	1.31	MD 0.1-0.3% / TD 0.2-0.4%
PC (10%GF 20%CF)	1.35	MD 0.02-0.15% / TD 0.15-0.35%
PC (10%PTFE)	1.28	0.70%
PC (30%PTFE)	1.39	0.90%
PC/ABS	1.25	0.5-0.7%
PC/ABS	1.13	0.4-0.6%
PC/ABS	1.12	0.3-0.5%
PC/ABS (10%GF)	1.28	MD 0.2-0.4% / TD 0.3-0.5%
PC/ABS (20%GF)	1.34	MD 0.1-0.3% / TD 0.2-0.4%
PC/ABS (30%GF)	1.44	MD 0.05-0.25% / TD 0.2-0.4%
PC/PET	1.2-1.26	0.5-1.9%
PC/PBT	1.3	0.5-0.7%
PA6	1.13-1.16	MD 1.0-1.8% / TD 1.3-2.2%
PA6 (10%GF)	1.2	MD 0.4% / TD 1.3%
PA6 (15%GF)	1.23	MD 0.4% / TD 1.3%
PA6 (20%GF)	1.27	MD 0.3% / TD 1.2%
PA6 (30%GF)	1.36	MD 0.3% / TD 1.0%
PA6 (33%GF)	1.39	MD 0.3% / TD 1.0%
PA6 (35%GF)	1.41	MD 0.3% / TD 1.0%
PA6 (40%GF)	1.49	MD 0.2% / TD 0.8%
Toughed PA6	1.02-1.07	MD 1.5% / TD 2.2%
PA66	1.13-1.15	0.7-1.8%
PA66 (15%GF)	1.21-1.23	0.5-0.98%
PA66 (30~33%GF)	1.25-1.40	0.2-0.6%
PA66 (50%GF)	1.56	0.2-0.7%
PA66 (30%CF)	1.3-1.31	0.30%
PA66 (40%CF)	1.36-1.38	0.20%
PA66 (30%PTFE)	1.2	1.00%
PA66 (10%PTFE)	1.34	0.70%
PA46	1.18	1.8-2.0%
PA46 (15%GF)	1.3	0.5-0.9%
PA46 (30%GF)	1.41	0.4-0.6%
PA46 (50%GF)	1.62	0.2-0.4%
PPA (33%GF)	1.48	MD 0.2-0.4% / TD 0.4-0.8%
PPA (45%GF)	1.59	MD 0.2% / TD 0.6%
PPA (30%MD)	1.45	MD 1.1% / TD 1.1%
PPA (45%MD)	1.53	MD 1.0% / TD 1.0%
PPA (65%MD)	1.9	MD 0.3% / TD 0.5%

Polymer Shrinkage

PA11	1.03-1.05	1.20%
PA12	1.01-1.02	0.3-1.5%
PA610	1.08-1.1	0.5-1.5%
PA612	1.06-1.1	1.10%
PA612 (30%GF)	1.30-1.38	0.2-0.5%
PA612 (10%PTFE)	1.13	1.20%
PPA	1.17	1.5-2.0%
PPA (15%GF)	1.26	0.5-0.7%
PPA (33%GF)	1.43	0.2-0.5%
PPA (45%GF)	1.56	0.2-0.3%
POM (homopolymer)	1.42	1.8-2.5%
POM (copolymer)	1.4	2.0-2.2%
POM (10%GB)	1.47	MD 1.9% / TD 1.6%
POM (25%GB)	1.58	MD 1.8% / TD 1.5%
POM (10%GF)	1.46	1.10%
POM (25%GF)	1.59	MD 0.4% / TD 1.2%
POM (10%MF)	1.49	1.70%
POM (20%MF)	1.55-1.59	0.90%
POM (20%CF)	1.46	0.40%
POM (10%PTFE)	1.46	2.00%
POM (20%PTFE)	1.51	2.0-2.5%
IM POM	1.29-1.35	1.2-1.7%
mPPE	1.06-1.10	0.5-0.7%
mPPE (10%GF)	1.15-1.17	MD 0.2-0.4% / TD 0.3-0.5%
mPPE (15%GF)	1.19-1.21	MD 0.2-0.4% / TD 0.3-0.5%
mPPE (20%GF)	1.22-1.24	MD 0.1-0.2% / TD 0.2-0.4%
mPPE (30%GF)	1.31-1.33	MD 0.1-0.2% / TD 0.2-0.4%
mPPE (25%GF 15%Filler)	1.42	MD 0.05-0.25% / TD 0.1-0.3%
mPPE (5%PTFE)	1.11	0.5-0.7%
mPPE (10%PTFE)	1.12	0.5-0.7%
mPPE (15%PTFE)	1.15	0.5-0.7%
PPE/PA6 alloy	1.11	MD 1.2-1.4% / TD 1.1-1.3%
PPE/PA6 (20%GF)	1.26	MD 0.3-0.5% / TD 0.4-0.6%
PPE/PA66 alloy	1.10-1.13	MD 1.1-1.3% / TD 1.1-1.3%
PET	1.29-1.40	0.2-3.0%
PET (15%GF)	1.33	0.1-0.4%
PET (30%GF)	1.55-1.70	0.2-0.9%
PET (45%GF)	1.58-1.74	0.2-0.9%
PETG	1.27	0.2-0.5%
PCTG	1.23	0.2-0.5%

Polymer Shrinkage

PBT	1.3-1.43	1.2-2.5%
PBT (UL-HB)	1.26-1.30	(3mm) MD 2.2-2.3% TD 2.0-2.1%
PBT (UL-HB)	1.26-1.31	(1mm) MD 1.5-1.6% TD 1.4-1.5%
PBT (UL-V2-V0)	1.42	(3mm) MD 2.2-2.4% TD 2.0%
PBT (UL-V2-V0)	1.42	(1mm) MD 1.4% TD 1.4%
PBT (15%GF)	1.41	(3mm) MD 0.4-0.7% TD 1.3-1.5%
PBT (15%GF)	1.41	(1mm) MD 0.5% TD 1.0%
PBT (20%GF)	1.48	0.4-1.4%
PBT (30%GF)	1.52	(3mm) MD 0.2-0.3% TD 0.5-1.3%
PBT (30%GF)	1.52	(1mm) MD 0.1-0.3% TD 0.4-0.8%
PBT (45%GF)	1.67	(3mm) MD 0.2% TD 0.9%
PBT (45%GF)	1.67	(1mm) MD 0.1% TD 0.6%
PPS	1.31-1.35	MD 1.1-1.6% TD 1.6-1.8%
PPS (30%GF)	1.57	MD 0.3-0.4% TD 0.6-0.7%
PPS (40%GF)	1.68	MD 0.3% TD 0.5-0.7%
PPS (50%GF)	1.75	MD 0.4% TD 0.6%
PPS (65%GF/MF)	1.91-1.98	MD 0.2-0.3% TD 0.4-0.6%
PPS (30%CF)	1.44	MD 0.1% TD 0.6%
LCP	1.35-1.84	0.1-0.6%
LCP (15%GF)	1.5	MD 0.1% TD 0.4%
LCP (30%GF)	1.62	MD 0.2% TD 0.4%
LCP (30%GF)	1.62	MD 0-0.2% TD 0.1-0.78%
LCP (50%GF)	1.79	MD 0.2% TD 0.4%
LCP (30%CF)	1.49	MD 0.1% TD 0.3%
PAI	1.42	0.6-0.85%
PAI (30%GF)	1.61	0.1-0.25%
PEI	1.27	0.5-0.7%
PSF	1.23	0.6-0.7%
PSF (25%MD)	1.48	MD 0.5% TD 0.5%
PSF (40%MD)	1.61	MD 0.5% TD 0.8%
PSF (10%GF)	1.41	MD 0.4% TD 0.5%
PSF (20%GF)	1.47	MD 0.3% TD 0.5%
PSF (30%GF)	1.52	MD 0.2% TD 0.6%
PSF (40%GF)	1.66	MD 0.2% TD 0.6%
PES	1.37	0.6-0.7%
PES (10%GF)	1.45	0.5-0.6%
PES (20%GF)	1.51	0.4-0.6%
PES (30%GF)	1.53-1.60	0.4-0.6%
PPSF	1.29-1.37	0.5-0.8%

Polymer Shrinkage

PI	1.33-1.43	0.80%
PI (30%GF)	1.56	0.40%
PI (30%CF)	1.43	0.20%
TPU (Shore A 72)	1.04	0.8-1.2%
TPU (Shore A 92)	1.09	0.6-1.0%
TPU (Shore D 67)	1.11	0.4-0.6%
TPU (20%GF)	1.22-1.36	0.4-1.0%
TPU (30%LGF)	1.43	0.2-0.6%
TPU (40%LGF)	1.52	0.1-0.5%
TPU (60%LGF)	1.76	0.1-0.3%
TPU (20%BaSO ₄)	1.24-1.32	0.4-1.2%
TPU (40%BaSO ₄)	1.48-1.55	0.4-1.2%
PVC	1.65-1.70	0.5-2.5%
Silicone	1.08-1.14	0-0.5%
TPO	0.95-1.0	0.8-1.0%
TPV	0.94-1.05	1.5-2.5%