

**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	330–350	340	2.0	2.5	175	0.0045–0.0065	Any Type
High Density Polyethylene	330–400	370	1.6	1.5	155	0.0220–0.0300	Any Type
Low Density Polyethylene	290–350	325	1.7	1.5	135	0.0250–0.0320	Any Type
High Molecular Weight Polyethylene	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	300–350	330	1.6	1.5	160	0.0110–0.0130	Any Type
TufGlas®	340–390	365	1.8	2.5	175	0.0050–0.0070	Any Type
SunGard®/DuraGard®	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

**Call 800-677-4338 or email [marketing@spartech.com](mailto:marketing@spartech.com) to order these products.**

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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	340–360	350	1.0	1.0	140	0.0050–0.0090	Any Type
Straight PVC	330–370	355	1.3	1.5	155	0.0040–0.0050	Any Type
FR ABS	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	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 Conductive	340–380	365	1.6	2.5	160	0.0045–0.0065	Any Type
Royalite® R64 Conductive	340–400	370	1.7	1.6	155	0.200–0.0320	Any Type
Royalite® R85/21	340–390	370	1.8	2.5	170	0.0050–0.0070	Any Type
Royalite® R104 & R105	280–340	Back – 355 Front – 315	1.0	1.5	160	0.0050–0.0070	Ceramic, Nichrome Wire, Calrod, Radiant
Royalite® R755	330–380	355	1.3	2.5	155	0.0040–0.0060	Any Type
Royalite® R503	290–320	300	1.0	1.0	140	0.0130–0.0220	Any Type

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