

Stress Relaxation:

	MATERIAL	Heat Up	Hold	Cool Down	Environment
1	ABS	10°C per hour to 93°C	1h per 10mm thickness	20°C per hour	Nitrogen
2	PMMA	2 hours to 80°C	1h per 10mm thickness	20°C per hour	Nitrogen
3	POM-C	4 hours to 155°C	1h per 10mm thickness	20°C per hour	Nitrogen or Air
4	POM-H	4 hours to 160°C	1h per 10mm thickness	20°C per hour	Nitrogen or Air
5	PET	4 hours to 177°C	1h per 10mm thickness	20°C per hour	Oil or Nitrogen
6	ECTFE	10°C per hour to 107°C	1h per 10mm thickness	20°C per hour	Nitrogen
7	PBT	4 hours to 150°C	1h per 10mm thickness	20°C per hour	Nitrogen or Air
8	PVDF	2 hours to 135°C	1h per 10mm thickness	20°C per hour	Nitrogen
9	PA 6	4 hours to 150°C	1h per 10mm thickness	20°C per hour	Oil or Nitrogen
10	PA 66	4 hours to 177°C	1h per 10mm thickness	20°C per hour	Oil or Nitrogen
11	PA - GF	4 hours to 191°C	1h per 10mm thickness	20°C per hour	Oil or Nitrogen
12	PCTFE	3 hours to 107°C	2h per 10mm thickness	20°C per hour	Air
13	PEEK	2 hours to 150°C then 2 hours to 191°C	2h per 10mm thickness	20°C per hour	Air
14	PC	4 hours to 135°C	1h per 10mm thickness	20°C per hour	Air
15	PC-GF	4 hours to 143°C	1h per 10mm thickness	20°C per hour	Air
16	PE (LDPE)	2 hours to 79°C	1h per 10mm thickness	20°C per hour	Nitrogen
17	PE (HDPE)	2 hours to 121°C	1h per 10mm thickness	20°C per hour	Nitrogen
18	PE (UHMW)	2 hours to 104°C	1h per 10mm thickness	20°C per hour	Nitrogen
19	PP	2 hours to 85°C	1h per 10mm thickness	20°C per hour	Air
20	PPSU	4 hours to 199°C	1h per 10mm thickness	20°C per hour	Nitrogen or Air
21	PPS	4 hours to 177°C	1h per 10mm thickness	20°C per hour	Air

22	PAI	4 hours to 150°C then 4 hours to 216°C then 4 hours to 243°C then 4 hours to 260°C	1 day 1day 1 Dy 3-10 days	20°C per hour	Air
23	TPX	10°C per hour to 93°C	1h per 10mm thickness	20°C per hour	Nitrogen
24	PSU	4 hours to 166°C	1h per 10mm thickness	20°C per hour	Air
25	PEI	4 hours to 199°C	1h per 10mm thickness	20°C per hour	Air
26	PEI-GF	4 hours to 204°C	1h per 10mm thickness	20°C per hour	Air
27	PPE/PPO	10°C per hour to 121°C	1h per 1cm thickness	10°C per hour	Nitrogen
28	PPE/PPO - GF	10°C per hour to 127°C	1h per 1cm thickness	10°C per hour	Nitrogen
29	PTFE	3 hours to 274°C	1h per 10mm thickness	20°C per hour	Air