

# Resin drying chart

Drying temperature, time and target moisture by resin family



| Resin                          | Hygroscopic?                           | Drying temp                                                     | Drying time                         | Target moisture                                        |
|--------------------------------|----------------------------------------|-----------------------------------------------------------------|-------------------------------------|--------------------------------------------------------|
| Nylon 6 (PA6), unfilled        | Yes, performance                       | 176°F / 80°C                                                    | 2–6 h                               | 0.03–0.12%                                             |
| Nylon 6 (PA6), glass-filled    | Yes, performance                       | 150–180°F / 66–82°C                                             | 2–5 h                               | Scale by polymer fraction                              |
| Nylon 66 (PA66), unfilled      | Yes, performance                       | 175–180°F / 80–82°C                                             | 2–4 h from a fresh bag              | 0.03–0.2%                                              |
| Nylon 66 (PA66), glass-filled  | Yes, performance                       | 176–180°F / 80–82°C                                             | 2–4 h, often longer                 | Scale by polymer fraction                              |
| Nylon 11 / Nylon 12            | Yes, but low absorption                | PA11 176–194°F / 80–90°C / PA12 176–212°F / 80–100°C            | PA11 ≥4 h / PA12 2–4 h dehumidified | PA12 <0.1%                                             |
| PPA                            | Yes                                    | 248°F / 120°C                                                   | 4 h                                 | 0.03–0.06%                                             |
| Polycarbonate (PC)             | Yes, performance                       | 248–250°F / 120–121°C                                           | 2–4 h                               | ≤0.02%                                                 |
| PC/ABS                         | Yes, performance                       | 212–230°F / 100–110°C                                           | 2–4 h; 4–6 h regrind or filled      | 0.02–0.04%                                             |
| ABS                            | Yes, cosmetic                          | 176–203°F / 80–95°C                                             | 2–4 h                               | 0.1% general / 0.02–0.05% plating                      |
| Acetal, POM homopolymer        | Weak; toughened grades are hygroscopic | 176°F / 80°C                                                    | 2–4 h; toughened 4–8 h              | Dry only above 0.2% / Toughened <0.05%                 |
| Acetal, POM copolymer          | Essentially no                         | 180–248°F / 82–120°C                                            | 3–4 h                               | No published maximum / Dry only if exposed to moisture |
| PET, bottle / preform          | Yes, strongly                          | 300–350°F / 149–177°C                                           | 4–6 h                               | 0.005% (50 ppm)                                        |
| PET, injection grade           | Yes, performance                       | 250–275°F / 120–135°C                                           | 2–4 h virgin; 4–6 h regrind         | <0.02% (200 ppm)                                       |
| PBT                            | Yes, performance                       | 250°F / 121°C typical / (176–284°F / 80–140°C published)        | 2–4 h                               | 0.02%                                                  |
| PEI                            | Yes, performance                       | 302°F / 150°C                                                   | 4–6 h; cumulative ≤24 h             | 0.02%                                                  |
| PEEK                           | Not hygroscopic, but must be dried     | 302–320°F / 150–160°C                                           | 2–4 h                               | <0.02%                                                 |
| PPS                            | Resin no; mineral fillers yes          | 230–325°F / 110–163°C                                           | 2–4 h                               | 0.02%                                                  |
| PSU                            | Yes, absorbs very rapidly              | 275–325°F / 135–163°C                                           | 2–4 h (shorter at higher temp)      | 0.02–0.05%                                             |
| PPSU / PES                     | Yes                                    | 275–350°F / 135–177°C                                           | 3–5 h                               | 0.02–0.05%                                             |
| TPU                            | Yes, strongly                          | 194–230°F / 90–110°C / Aliphatic 104–140°F / 40–60°C            | 1–4 h                               | <0.02–0.05%                                            |
| Acrylic (PMMA)                 | Yes, cosmetic                          | 158–208°F / 70–98°C                                             | 2–4 h                               | <0.02% strict / 0.05–0.1% non-critical                 |
| SAN                            | Mild                                   | 175–176°F / 79–80°C                                             | 2–4 h                               | 0.04–0.08%                                             |
| ASA                            | Yes, cosmetic                          | 176–194°F / 80–90°C                                             | 2–6 h                               | 0.04–0.1%                                              |
| Polystyrene / HIPS             | No, surface moisture only              | 160–167°F / 71–75°C, only if needed                             | 1–2 h; never >12 h                  | No published maximum                                   |
| PPO / PPE modified             | Barely, saturates at 0.07%             | 212–248°F / 100–120°C / PPE/PP blend grades 149–167°F / 65–75°C | 2–4 h; never >8 h                   | <0.02%                                                 |
| Polypropylene (PP)             | No                                     | 167°F / 75°C, cosmetics only                                    | 2 h when required                   | Up to 0.2% has no effect                               |
| Polyethylene (PE)              | No                                     | Not required                                                    | n/a                                 | n/a                                                    |
| PVC (rigid and flexible)       | No                                     | 120°F / 49°C, optional                                          | 2–3 h                               | Not specified                                          |
| TPV                            | Yes                                    | 176°F / 80°C                                                    | 3 h virgin; 4 h with regrind        | ≤0.08%                                                 |
| TPC-ET (copolyester elastomer) | Yes                                    | 210°F / 100°C                                                   | 2–3 h; not >12 h                    | 0.10%                                                  |
| Styrenic TPE-S                 | No                                     | 140–175°F / 60–80°C, only if needed                             | 2–4 h                               | Not specified                                          |

Typical family-level values from manufacturer processing guides. Always check the data sheet for the grade you run. Use a dehumidifying dryer; dew point –40°F.

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