

# 2K-mold / Over-molding resin adhesion capability guideline

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Material	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	Material	
	ABS	ASA	CA	PA6	PA66	PA Blend	PBT	PC	PC/ABS	PC/PBT	PC/PET	PE	PET	PMMA	POM	PP	PPO	PS	SAN	TPE	TPU	LSR		
1	ABS	Good	Fair	Good	Good	Fair	Good	Good	Good	Good	Good	Fair	Fair	Good	Fair	Poor	Poor	Fair	Good	Good	Good		ABS	1
2	ASA	Good	Fair	Good	Good	Good	Good	Good	Good	Good	Good	Poor	Good	Good	Poor	Poor	Poor	Fair	Good	Fair	Good		ASA	2
3	CA	Fair	Good	Good	Good	Good	Good	Good	Good	Good	Good	Poor	Good	Good	Poor	Poor	Poor	Fair	Good	Good	Good		CA	3
4	PA6	Good	Good	Good	Good	Good	Good	Fair	Good	Good	Good	Fair	Good	Good	Poor	Fair	Poor	Poor	Good	Fair	Good		PA6	4
5	PA66	Good	Good	Good	Good	Good	Fair	Fair	Good	Good	Good	Fair	Good	Good	Poor	Fair	Poor	Poor	Good	Fair	Good		PA66	5
6	PA Blend	Fair	Good	Good	Good	Good	Good	Good	Good	Good	Good	Fair	Good	Good	Fair	Fair	Poor	Poor	Good	Fair	Good		PA Blend	6
7	PBT	Good	Good	Good	Fair	Good	Good	Good	Good	Good	Good	Fair	Good	Fair	Fair	Fair	Good	Fair	Good	Good	Good		PBT	7
8	PC	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Poor	Good	Good	Fair	Poor	Poor	Poor	Good	Fair	Good		PC	8
9	PC/ABS	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Poor	Good	Good	Fair	Poor	Poor	Poor	Good	Fair	Good		PC/ABS	9
10	PC/PBT	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Poor	Good	Good	Fair	Poor	Poor	Poor	Good	Fair	Good		PC/PBT	10
11	PC/PET	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Poor	Good	Good	Fair	Poor	Poor	Poor	Good	Fair	Good		PC/PET	11
12	PE	Fair	Poor	Poor	Fair	Fair	Fair	Poor	Poor	Poor	Poor	Good	Poor	Poor	Poor	Good	Good	Good	Good	Fair	Good		PE	12
13	PET	Fair	Good	Good	Good	Good	Good	Good	Good	Good	Good	Poor	Good	Good	Fair	Poor	Poor	Poor	Good	Fair	Good		PET	13
14	PMMA	Good	Good	Good	Good	Good	Fair	Good	Good	Good	Good	Poor	Good	Good	Poor	Poor	Poor	Poor	Good	Fair	Good		PMMA	14
15	POM	Fair	Poor	Poor	Poor	Fair	Good	Good	Good	Good	Good	Poor	Good	Good	Good	Good	Good	Good	Good	Fair	Good		POM	15
16	PP	Poor	Poor	Poor	Fair	Fair	Fair	Poor	Poor	Poor	Poor	Good	Good	Poor	Good	Good	Fair	Good	Good	Good	Good		PP	16
17	PPO	Poor	Poor	Poor	Poor	Poor	Good	Good	Good	Good	Good	Poor	Good	Good	Good	Good	Good	Good	Good	Good	Good		PPO	17
18	PS	Good	Fair	Poor	Poor	Poor	Fair	Poor	Poor	Poor	Poor	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good		PS	18
19	SAN	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Fair	Good	Good	Good	Good	Good	Good	Good	Good	Good		SAN	19
20	TPE	Good	Fair	Good	Fair	Fair	Fair	Fair	Fair	Fair	Fair	Good	Good	Fair	Good	Good	Good	Good	Good	Good	Good		TPE	20
21	TPU	Good	Good	Good	Good	Good	Good	Good	Good	Good	Good	Fair	Good	Good	Poor	Fair	Good	Good	Good	Good	Good		TPU	21
22	LSR	Good	Good	Good	Good	Good	Good	Poor	Good	Good	Good	Poor	Good	Good	Good	Good	Good	Good	Good	Good	Good		LSR	22

