Processing Conditions

Polypropylene (PP) — RTP 100 Series
EMI Shielding Compounds

Typical Injection Molding Conditions	English	SI Metric
Temperatures		
Rear zone	390 - 420 °F	199 - 216 °C
Center zone	380 - 400 °F	193 - 204 °C
Front zone	370 - 390 °F	188 - 199 °C
Melt	380 - 430 °F	193 - 221 °C
Mold	100 - 125 °F	38 - 52 °C
Pressures		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	5000 - 10000 psi	34 - 69 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa
Speeds		
Fill	0.5 - 1 in/sec	13 - 25 mm/sec
Screw	30 - 60 rpm	30 - 60 rpm
Drying		
Time & Temperature	2 Hrs @ 175 °F	2 Hrs @ 79 °C
Dew Point	n/a °F	n/a °C
Moisture Content	0.10 %	0.10 %

Notes

- Remove hopper magnets
- Uses a reverse barrel profile
- Allow 4 to 5 shots to properly disperse the conductive fibers. The surface finish should have slight silver streaks (not clumps), indicating proper fiber dispersion.
- This information is intended to be used only as a guideline for designers and processors of modified thermoplastics for injection molding. Because injection mold design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.
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