



## Processing Conditions

### Polyphenylene Sulfide (PPS) — RTP 1300 Series EMI Shielding Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	580 - 600 °F	304 - 316 °C
Center zone	570 - 590 °F	299 - 310 °C
Front zone	560 - 580 °F	293 - 304 °C
Melt	585 - 615 °F	307 - 324 °C
Mold	275 - 350 °F	135 - 177 °C

<b>Pressures</b>		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	5000 - 12000 psi	34 - 83 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

<b>Speeds</b>		
Fill	1 - 3 in/sec	25 - 76 mm/sec
Screw	30 - 60 rpm	30 - 60 rpm

<b>Drying</b>		
Time & Temperature	6 Hrs @ 300 °F	6 Hrs @ 149 °C
Dew Point	n/a °F	n/a °C
Moisture Content	0.04 %	0.04 %

#### 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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