Processing Conditions

Polycarbonate/Acrylic Alloy (PC/PMMA) — RTP 1800A Series
EMI Shielding Compounds

Typical Injection Molding Conditions	English	SI Metric
Temperatures		
Rear zone	460 - 480 °F	238 - 249 °C
Center zone	445 - 485 °F	229 - 252 °C
Front zone	395 - 445 °F	202 - 229 °C
Melt	460 - 510 °F	238 - 266 °C
Mold	90 - 150 °F	32 - 66 °C
Pressures		
Injection	8000 - 12000 psi	55 - 83 MPa
Hold	5000 - 10000 psi	34 - 69 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa
Speeds		
Fill	1 - 2 in/sec	25 - 51 mm/sec
Screw	30 - 60 rpm	30 - 60 rpm
Drying		
Time & Temperature	3 to 4 Hrs @ 180 °F	3 to 4 Hrs @ 82 °C
Dew Point	0.0 °F	-18 °C
Moisture Content	0.02 %	0.02 %

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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