



Processing Conditions

Nylon 6 (PA) — RTP 200A Series EMI Shielding Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	480 - 520 °F	249 - 271 °C
Center zone	450 - 510 °F	232 - 266 °C
Front zone	430 - 500 °F	221 - 260 °C
Melt	470 - 535 °F	243 - 279 °C
Mold	130 - 200 °F	54 - 93 °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 - 2 in/sec	13 - 51 mm/sec
Screw	30 - 60 rpm	30 - 60 rpm

Drying		
Time & Temperature	4 Hrs @ 175 °F	4 Hrs @ 79 °C
Dew Point	0.0 °F	-18 °C
Moisture Content	0.20 %	0.20 %

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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