Processing Conditions

Impact-Modified Nylon 6/6 (PA) — RTP 200H Series
EMI Shielding Compounds

Typical Injection Molding Conditions	English	SI Metric
Temperatures		
Rear zone	530 - 560 °F	277 - 293 °C
Center zone	520 - 550 °F	271 - 288 °C
Front zone	510 - 540 °F	266 - 282 °C
Melt	485 - 560 °F	252 - 293 °C
Mold	175 - 210 °F	79 - 99 °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	n/a °F	n/a °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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