



Processing Conditions

Polyetherimide (PEI) — RTP 2100 Series EMI Shielding Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	680 - 720 °F	360 - 382 °C
Center zone	670 - 710 °F	354 - 377 °C
Front zone	660 - 700 °F	349 - 371 °C
Melt	670 - 750 °F	354 - 399 °C
Mold	275 - 350 °F	135 - 177 °C

Pressures		
Injection	12000 - 18000 psi	83 - 124 MPa
Hold	8000 - 15000 psi	55 - 103 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	4 Hrs @ 300 °F	4 Hrs @ 149 °C
Dew Point	-20 °F	-29 °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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