



Processing Conditions

Olefinic Thermoplastic Elastomer (TEO) — RTP 2800 Series EMI Shielding Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	370 - 390 °F	188 - 199 °C
Center zone	350 - 370 °F	177 - 188 °C
Front zone	340 - 360 °F	171 - 182 °C
Melt	360 - 410 °F	182 - 210 °C
Mold	60 - 150 °F	16 - 66 °C

Pressures

Injection	12000 - 18000 psi	83 - 124 MPa
Hold	5000 - 12000 psi	34 - 83 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

Speeds

Fill	0.5 - 1 in/sec	13 - 25 mm/sec
Screw	30 - 60 rpm	30 - 60 rpm

Drying

Time & Temperature	2 Hrs @ 175 °F	2 Hrs @ 79 °C
Dew Point	0.0 °F	-18 °C
Moisture Content	0.03 %	0.03 %

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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