Processing Conditions

Polycarbonate (PC) — RTP 300 Series
EMI Shielding Compounds

Typical Injection Molding Conditions	English	SI Metric
Temperatures		
Rear zone	540 - 560 °F	282 - 293 °C
Center zone	520 - 540 °F	271 - 282 °C
Front zone	510 - 520 °F	266 - 271 °C
Melt	530 - 580 °F	277 - 304 °C
Mold	160 - 250 °F	71 - 121 °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	1 - 2 in/sec	25 - 51 mm/sec
Screw	30 - 60 rpm	30 - 60 rpm
Drying		
Time & Temperature	4 Hrs @ 250 °F	4 Hrs @ 121 °C
Dew Point	-20 °F	-29 °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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