



## Processing Conditions

### Acetal (POM) — RTP 800 Series EMI Shielding Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	370 - 410 °F	188 - 210 °C
Center zone	360 - 400 °F	182 - 204 °C
Front zone	350 - 390 °F	177 - 199 °C
Melt	360 - 425 °F	182 - 218 °C
Mold	180 - 225 °F	82 - 107 °C

<b>Pressures</b>		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	5000 - 10000 psi	34 - 69 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

<b>Speeds</b>		
Fill	1 - 2 in/sec	25 - 51 mm/sec
Screw	30 - 60 rpm	30 - 60 rpm

<b>Drying</b>		
Time & Temperature	2 Hrs @ 250 °F	2 Hrs @ 121 °C
Dew Point	-20 °F	-29 °C
Moisture Content	0.15 %	0.15 %

#### 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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