



Processing Conditions

Polyurethane Thermoplastic Elastomer (TPU) — RTP 1200 Series PermaStat Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	325 - 340 °F	163 - 171 °C
Center zone	340 - 360 °F	171 - 182 °C
Front zone	370 - 390 °F	188 - 199 °C
Melt	350 - 420 °F	177 - 216 °C
Mold	60 - 150 °F	16 - 66 °C

Pressures		
Injection	7000 - 12000 psi	48 - 83 MPa
Hold	5000 - 9000 psi	34 - 62 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

Speeds		
Fill	1 - 2 in/sec	25 - 51 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

Drying		
Time & Temperature	6 Hrs @ 225 °F	6 Hrs @ 107 °C
Dew Point	0.0 °F	-18 °C
Moisture Content	0.03 %	0.03 %

Notes

- 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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