



## Processing Conditions

### Polyester Thermoplastic Elastomer (TPE) — RTP 1500 Series PermaStat Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	380 - 410 °F	193 - 210 °C
Center zone	410 - 420 °F	210 - 216 °C
Front zone	420 - 430 °F	216 - 221 °C
Melt	410 - 430 °F	210 - 221 °C
Mold	70 - 100 °F	21 - 38 °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	0.5 - 1 in/sec	13 - 25 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

<b>Drying</b>		
Time & Temperature	2 to 4 Hrs @ 200 °F	2 to 4 Hrs @ 93 °C
Dew Point	n/a °F	n/a °C
Moisture Content	n/a %	n/a %

#### 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.
- No information supplied by RTP Company constitutes a warranty regarding product performance or use. Any information regarding performance or use is only offered as suggestion for investigation for use, based upon RTP Company or other customer experience. RTP Company makes no warranties, expressed or implied, concerning the suitability or fitness of any of its products for any particular purpose. It is the responsibility of the customer to determine that the product is safe, lawful and technically suitable for the intended use. The disclosure of information herein is not a license to operate under, or a recommendation to infringe any patents.