



## Processing Conditions

### Nylon 6 (PA) — RTP 200A Series PermaStat Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	380 - 410 °F	193 - 210 °C
Center zone	390 - 420 °F	199 - 216 °C
Front zone	400 - 430 °F	204 - 221 °C
Melt	380 - 460 °F	193 - 238 °C
Mold	150 - 200 °F	66 - 93 °C

#### Pressures

Injection	10000 - 15000 psi	69 - 103 MPa
Hold	4000 - 10000 psi	28 - 69 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	4 Hrs @ 175 °F	4 Hrs @ 79 °C
Dew Point	0.0 °F	-18 °C
Moisture Content	0.20 %	0.20 %

#### 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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