



Processing Conditions

Impact-Modified Nylon 6/6 (PA) — RTP 200H Series PermaStat Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	430 - 500 °F	221 - 260 °C
Center zone	450 - 510 °F	232 - 266 °C
Front zone	480 - 520 °F	249 - 271 °C
Melt	465 - 520 °F	241 - 271 °C
Mold	150 - 225 °F	66 - 107 °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	2 Hrs @ 175 °F	2 Hrs @ 79 °C
Dew Point	-20 °F	-29 °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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