



Processing Conditions

Olefinic Thermoplastic Elastomer (TEO) — RTP 2800 Series PermaStat Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	320 - 350 °F	160 - 177 °C
Center zone	330 - 360 °F	166 - 182 °C
Front zone	350 - 375 °F	177 - 191 °C
Melt	360 - 400 °F	182 - 204 °C
Mold	60 - 150 °F	16 - 66 °C
Pressures		
Injection	5000 - 10000 psi	34 - 69 MPa
Hold	2000 - 7000 psi	14 - 48 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa
Speeds		
Fill	0.5 - 1 in/sec	13 - 25 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm
Drying		
Time & Temperature	2 Hrs @ 175 °F	2 Hrs @ 79 °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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