



## Processing Conditions

### Polycarbonate (PC) — RTP 300 Series PermaStat Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	400 - 420 °F	204 - 216 °C
Center zone	410 - 430 °F	210 - 221 °C
Front zone	420 - 450 °F	216 - 232 °C
Melt	430 - 470 °F	221 - 243 °C
Mold	150 - 250 °F	66 - 121 °C

#### Pressures

Injection	6000 - 10000 psi	41 - 69 MPa
Hold	4000 - 8000 psi	28 - 55 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 @ 250 °F	4 Hrs @ 121 °C
Dew Point	-20 °F	-29 °C
Moisture Content	0.02 %	0.02 %

#### Notes

- Do not exceed 520 F (271 C)
- 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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