



Processing Conditions

Polyvinylidene Fluoride (PVDF) — RTP 3300 Series PermaStat Compounds

Typical Injection Molding Conditions

| | English | SI Metric |
|---------------------|--------------|--------------|
| Temperatures | | |
| Rear zone | 325 - 340 °F | 163 - 171 °C |
| Center zone | 340 - 360 °F | 171 - 182 °C |
| Front zone | 370 - 390 °F | 188 - 199 °C |
| Melt | 350 - 420 °F | 177 - 216 °C |
| Mold | 150 - 250 °F | 66 - 121 °C |

| | | |
|------------------|------------------|-----------------|
| Pressures | | |
| Injection | 7000 - 12000 psi | 48 - 83 MPa |
| Hold | 5000 - 9000 psi | 34 - 62 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 @ 250 °F | 2 Hrs @ 121 °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.
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