



Processing Conditions

Polystyrene (PS) — RTP 400 Series PermaStat Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
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 - 450 °F	193 - 232 °C
Mold	100 - 150 °F	38 - 66 °C

Pressures		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	5000 - 10000 psi	34 - 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 @ 180 °F	2 Hrs @ 82 °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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