



Processing Conditions

Aliphatic Polyketone (PK) — RTP 4500 Series PermaStat Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	400 - 420 °F	204 - 216 °C
Center zone	420 - 430 °F	216 - 221 °C
Front zone	430 - 440 °F	221 - 227 °C
Melt	410 - 460 °F	210 - 238 °C
Mold	150 - 250 °F	66 - 121 °C

Pressures		
Injection	10000 - 18000 psi	69 - 124 MPa
Hold	8000 - 10000 psi	55 - 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	4 Hrs @ 140 °F	4 Hrs @ 60 °C
Dew Point	-25 °F	-32 °C
Moisture Content	0.02 %	0.02 %

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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