



Processing Conditions

Polytrimethylene Terephthalate (PTT) — RTP 4700 Series PermaStat Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	430 - 445 °F	221 - 229 °C
Center zone	440 - 455 °F	227 - 235 °C
Front zone	450 - 465 °F	232 - 241 °C
Melt	430 - 485 °F	221 - 252 °C
Mold	190 - 250 °F	88 - 121 °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	4 to 6 Hrs @ 260 °F	4 to 6 Hrs @ 127 °C
Dew Point	-40 °F	-40 °C
Moisture Content	0.01 %	0.01 %

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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