



Processing Conditions

High Density Polyethylene (HDPE) — RTP 700 Series PermaStat Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	320 - 370 °F	160 - 188 °C
Center zone	330 - 380 °F	166 - 193 °C
Front zone	340 - 390 °F	171 - 199 °C
Melt	350 - 400 °F	177 - 204 °C
Mold	70 - 125 °F	21 - 52 °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	0.5 - 1 in/sec	13 - 25 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

Drying		
Time & Temperature	2 Hrs @ 175 °F	2 Hrs @ 79 °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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