



Processing Conditions

Polyurethane Thermoplastic Elastomer (TPU) — RTP 1200 Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	320 - 360 °F	160 - 182 °C
Center zone	350 - 390 °F	177 - 199 °C
Front zone	370 - 410 °F	188 - 210 °C
Melt	365 - 425 °F	185 - 218 °C
Mold	100 - 140 °F	38 - 60 °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	6 Hrs @ 225 °F	6 Hrs @ 107 °C
Dew Point	0.0 °F	-18 °C
Moisture Content	0.01 %	0.01 %

Notes

- Desiccant type dryer required
- 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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