



Processing Conditions

Polyethersulfone (PES) — RTP 1400 Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	650 - 670 °F	343 - 354 °C
Center zone	660 - 680 °F	349 - 360 °C
Front zone	670 - 690 °F	354 - 366 °C
Melt	650 - 710 °F	343 - 377 °C
Mold	275 - 350 °F	135 - 177 °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	6 Hrs @ 300 °F	6 Hrs @ 149 °C
Dew Point	-25 °F	-32 °C
Moisture Content	0.04 %	0.04 %

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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