



Processing Conditions

Polyester Thermoplastic Elastomer (TPE) — RTP 1500 Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	380 - 410 °F	193 - 210 °C
Center zone	410 - 440 °F	210 - 227 °C
Front zone	420 - 450 °F	216 - 232 °C
Melt	410 - 460 °F	210 - 238 °C
Mold	70 - 120 °F	21 - 49 °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 to 4 Hrs @ 200 °F	2 to 4 Hrs @ 93 °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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