



Processing Conditions

Amorphous Nylon (PA) — RTP 200E Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	520 - 540 °F	271 - 282 °C
Center zone	530 - 550 °F	277 - 288 °C
Front zone	540 - 560 °F	282 - 293 °C
Melt	520 - 570 °F	271 - 299 °C
Mold	150 - 210 °F	66 - 99 °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 Hrs @ 175 °F	4 Hrs @ 79 °C
Dew Point	-30 °F	-34 °C
Moisture Content	0.10 %	0.10 %

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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