



Processing Conditions

Nylon 12 (PA) — RTP 200F Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	420 - 490 °F	216 - 254 °C
Center zone	430 - 500 °F	221 - 260 °C
Front zone	440 - 510 °F	227 - 266 °C
Melt	430 - 525 °F	221 - 274 °C
Mold	150 - 220 °F	66 - 104 °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 - 3 in/sec	25 - 76 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

Drying		
Time & Temperature	4 Hrs @ 175 °F	4 Hrs @ 79 °C
Dew Point	-40 °F	-40 °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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