



Processing Conditions

Impact-Modified Nylon 6/6 (PA) — RTP 200H Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	525 - 540 °F	274 - 282 °C
Center zone	530 - 550 °F	277 - 288 °C
Front zone	540 - 560 °F	282 - 293 °C
Melt	530 - 570 °F	277 - 299 °C
Mold	150 - 225 °F	66 - 107 °C

Pressures		
Injection	10000 - 18000 psi	69 - 124 MPa
Hold	5000 - 12000 psi	34 - 83 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

Speeds		
Fill	2 - 3 in/sec	51 - 76 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

Drying		
Time & Temperature	4 Hrs @ 175 °F	4 Hrs @ 79 °C
Dew Point	0.0 °F	-18 °C
Moisture Content	0.20 %	0.20 %

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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