



## Processing Conditions

### Rigid Thermoplastic Polyurethane (RTPU) — RTP 2300A Series Specialty Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	400 - 430 °F	204 - 221 °C
Center zone	410 - 440 °F	210 - 227 °C
Front zone	420 - 450 °F	216 - 232 °C
Melt	430 - 470 °F	221 - 243 °C
Mold	125 - 200 °F	52 - 93 °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 - 2 in/sec	13 - 51 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

#### Drying

Time & Temperature	4 to 6 Hrs @ 225 °F	4 to 6 Hrs @ 107 °C
Dew Point	-25 °F	-32 °C
Moisture Content	0.01 %	0.01 %

#### Notes

- Desiccant type dryer required
- Critical moisture content requirement
- 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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