



Processing Conditions

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

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	430 - 460 °F	221 - 238 °C
Center zone	440 - 470 °F	227 - 243 °C
Front zone	450 - 480 °F	232 - 249 °C
Melt	460 - 500 °F	238 - 260 °C
Mold	200 - 250 °F	93 - 121 °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 @ 270 °F	4 to 6 Hrs @ 132 °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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