



Processing Conditions

Polymethylpentene (PMP) — RTP 3000 Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	480 - 520 °F	249 - 271 °C
Center zone	500 - 540 °F	260 - 282 °C
Front zone	520 - 560 °F	271 - 293 °C
Melt	510 - 580 °F	266 - 304 °C
Mold	150 - 200 °F	66 - 93 °C

Pressures		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	7000 - 9000 psi	48 - 62 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	2 Hrs @ 175 °F	2 Hrs @ 79 °C
Dew Point	n/a °F	n/a °C
Moisture Content	n/a %	n/a %

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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