



Processing Conditions

Perfluoroalkoxy (PFA) — RTP 3100 Series Specialty Compounds

Typical Injection Molding Conditions

| | English | SI Metric |
|---------------------|--------------|--------------|
| Temperatures | | |
| Rear zone | 600 - 630 °F | 316 - 332 °C |
| Center zone | 625 - 650 °F | 329 - 343 °C |
| Front zone | 640 - 690 °F | 338 - 366 °C |
| Melt | 650 - 725 °F | 343 - 385 °C |
| Mold | 300 - 450 °F | 149 - 232 °C |

| Pressures | | |
|------------------|------------------|-----------------|
| Injection | 8000 - 12000 psi | 55 - 83 MPa |
| Hold | 3000 - 7000 psi | 21 - 48 MPa |
| Back | 50 - 100 psi | 0.34 - 0.69 MPa |

| Speeds | | |
|---------------|----------------|----------------|
| Fill | 0.5 - 1 in/sec | 13 - 25 mm/sec |
| Screw | 60 - 90 rpm | 60 - 90 rpm |

| Drying | | |
|--------------------|----------------|----------------|
| Time & Temperature | 2 Hrs @ 250 °F | 2 Hrs @ 121 °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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