



## Processing Conditions

### Ethylene Tetrafluoroethylene (ETFE) — RTP 3200 Series Specialty Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	525 - 575 °F	274 - 302 °C
Center zone	575 - 625 °F	302 - 329 °C
Front zone	585 - 635 °F	307 - 335 °C
Melt	560 - 650 °F	293 - 343 °C
Mold	150 - 300 °F	66 - 149 °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	1 - 2 in/sec	25 - 51 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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