



## Processing Conditions

### Polyvinylidene Fluoride (PVDF) — RTP 3300 Series Specialty Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	360 - 480 °F	182 - 249 °C
Center zone	380 - 500 °F	193 - 260 °C
Front zone	415 - 525 °F	213 - 274 °C
Melt	410 - 550 °F	210 - 288 °C
Mold	180 - 220 °F	82 - 104 °C

<b>Pressures</b>		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	5000 - 10000 psi	34 - 69 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

<b>Speeds</b>		
Fill	0.5 - 1 in/sec	13 - 25 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

<b>Drying</b>		
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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