



Processing Conditions

Liquid Crystal Polymer (LCP) — RTP 3400-4 Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	680 - 715 °F	360 - 379 °C
Center zone	690 - 725 °F	366 - 385 °C
Front zone	700 - 735 °F	371 - 391 °C
Melt	685 - 750 °F	363 - 399 °C
Mold	150 - 200 °F	66 - 93 °C

Pressures

Injection	10000 - 18000 psi	69 - 124 MPa
Hold	8000 - 15000 psi	55 - 103 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

Speeds

Fill	2 - 3 in/sec	51 - 76 mm/sec
Screw	100 - 200 rpm	100 - 200 rpm

Drying

Time & Temperature	8 Hrs @ 300 °F	8 Hrs @ 149 °C
Dew Point	-20 °F	-29 °C
Moisture Content	n/a %	n/a %

Notes

- The key to successfully molding this material is to start mold open cycles as soon as the screw reaches its retracted position.
- 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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