



Processing Conditions

Polyphthalamide (PPA) — RTP 4000 Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	565 - 595 °F	296 - 313 °C
Center zone	575 - 605 °F	302 - 318 °C
Front zone	585 - 615 °F	307 - 324 °C
Melt	575 - 625 °F	302 - 329 °C
Mold	275 - 325 °F	135 - 163 °C

Pressures		
Injection	10000 - 18000 psi	69 - 124 MPa
Hold	5000 - 12000 psi	34 - 83 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	6 Hrs @ 175 °F	6 Hrs @ 79 °C
Dew Point	-25 °F	-32 °C
Moisture Content	0.05 %	0.05 %

Notes

- Desiccant type dryer required
- 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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