



Processing Conditions

Hot Water Moldable Polyphthalamide (PPA) — RTP 4000A Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	600 - 620 °F	316 - 327 °C
Center zone	610 - 630 °F	321 - 332 °C
Front zone	620 - 640 °F	327 - 338 °C
Melt	625 - 650 °F	329 - 343 °C
Mold	150 - 325 °F	66 - 163 °C

Pressures		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	5000 - 12000 psi	34 - 83 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

Speeds		
Fill	3 - 5 in/sec	76 - 127 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

Drying		
Time & Temperature	6 Hrs @ 175 °F	6 Hrs @ 79 °C
Dew Point	-20 °F	-29 °C
Moisture Content	0.10 %	0.10 %

Notes

- Desiccant type dryer required
- Maintain resin dryness with a hopper dryer set at 175 F (79 C).
- Use of higher mold temperatures may improve part appearance.
- 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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