



Processing Conditions

Thermoplastic Polyimide (TPI) — RTP 4200 Series Specialty Compounds

Typical Injection Molding Conditions

	English	SI Metric
Temperatures		
Rear zone	700 - 730 °F	371 - 388 °C
Center zone	730 - 750 °F	388 - 399 °C
Front zone	750 - 770 °F	399 - 410 °C
Melt	750 - 780 °F	399 - 416 °C
Mold	350 - 450 °F	177 - 232 °C

Pressures		
Injection	20000 - 28000 psi	138 - 193 MPa
Hold	8000 - 12000 psi	55 - 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 @ 400 °F	6 Hrs @ 204 °C
Dew Point	-40 °F	-40 °C
Moisture Content	0.01 %	0.01 %

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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