



## Processing Conditions

### Polysulfone/Polycarbonate Alloy (PSU/PC) — RTP 4300 Series Specialty Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	530 - 560 °F	277 - 293 °C
Center zone	550 - 570 °F	288 - 299 °C
Front zone	560 - 580 °F	293 - 304 °C
Melt	540 - 620 °F	282 - 327 °C
Mold	150 - 210 °F	66 - 99 °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	1 - 2 in/sec	25 - 51 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

<b>Drying</b>		
Time & Temperature	4 Hrs @ 250 °F	4 Hrs @ 121 °C
Dew Point	-20 °F	-29 °C
Moisture Content	0.02 %	0.02 %

#### 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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