



# Processing Conditions

## Polysulfone (PSU) — RTP 900 Series Specialty Compounds

### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	610 - 650 °F	321 - 343 °C
Center zone	625 - 670 °F	329 - 354 °C
Front zone	635 - 680 °F	335 - 360 °C
Melt	630 - 700 °F	332 - 371 °C
Mold	200 - 300 °F	93 - 149 °C

<b>Pressures</b>		
Injection	10000 - 18000 psi	69 - 124 MPa
Hold	5000 - 15000 psi	34 - 103 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 @ 275 °F	4 Hrs @ 135 °C
Dew Point	-25 °F	-32 °C
Moisture Content	0.15 %	0.15 %

### 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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