

RTP Company Processing Conditions

RTP SERIES	POLYMER TYPE	TEMPERATURE °F		DRYING		DEW POINT °F	MOISTURE CONTENT %
		MELT	MOLD	TEMP (°F)	TIME (HRS)		
100	POLYPROPYLENE (PP)	375-450	90-150	175	2	NA	NA
200	NYLON 6/6† (PA)	530-570	150-225	175	4	0	0.20
200A	NYLON 6† (PA)	470-535	130-200	180	2	0	0.20
200B	NYLON 6/10 (PA)	530-570	150-225	175	2	0	0.20
200C	NYLON 11 (PA)	435-550	100-150	175	4	0	0.20
200D	NYLON 6/12† (PA)	480-545	140-200	175	4	0	0.20
200E	NYLON, AMORPHOUS (PA)	520-570	150-210	175	4	-30	0.10
200F	NYLON 12† (PA)	430-525	150-220	175	4	-40	0.10
200H	NYLON 6/6 IMPACT MODIFIED (PA)	530-570	150-225	175	4	0	0.20
300	POLYCARBONATE† (PC)	550-600	180-250	250	4	-20	0.02
400	POLYSTYRENE† (PS)	410-480	100-150	180	2	NA	NA
500	STYRENE ACRYLONITRILE† (SAN)	460-535	125-180	180	2	NA	NA
600	ACRYLONITRILE BUTADIENE STYRENE† (ABS)	400-460	145-185	180	2	0	0.10
700	HIGH DENSITY POLYETHYLENE (HDPE)	380-450	70-150	175	2	NA	NA
700A	LOW DENSITY POLYETHYLENE (LDPE)	380-450	70-150	175	2	NA	NA
800	ACETAL (POM)	360-425	175-225	250	2	-25	0.15
900	POLYSULFONE (PSU)	630-700	200-300	275	4	-25	0.15
1000	POLYBUTYLENE TEREPHTHALATE† (PBT)	460-520	175-225	250	4	-20	0.03
1100	POLYETHYLENE TEREPHTHALATE† (PET)	500-570	275-325	250	4	-40	0.01
1200	POLYURETHANE THERMOPLASTIC ELASTOMER† (TPUR)	365-425	100-140	225	6	0	0.01
1300	POLYPHENYLENE SULFIDE (PPS)	585-625	275-350	300	6	NA	0.04
1400	POLYETHERSULFONE† (PES)	650-710	275-350	300	6	-25	0.04
1500	POLYESTER THERMOPLASTIC ELASTOMER† (TPE)	410-460	70-120	200	2-4	NA	NA
1700	POLYPHENYLENE OXIDE, MODIFIED (PPO)	480-550	150-200	200	2	0	0.10
1800	ACRYLIC (PMMA)	360-425	175-225	200	4	0	0.02
1800A	POLYCARBONATE/ACRYLIC ALLOY (PC/PMMA)	460-510	90-150	180	3-4	0	0.02
2100	POLYETHERIMIDE† (PEI)	670-750	275-350	300	4	-20	0.04
2200	POLYETHERETHERKETONE† (PEEK)	660-750	325-425	300	3	-20	0.10
2300A	RIGID THERMOPLASTIC POLYURETHANE† (RTPU)	430-470	125-200	225	4-6	-25	0.01
2300C	RIGID THERMOPLASTIC POLYURETHANE† (RTPU)	460-500	200-250	270	4-6	-25	0.01
2500	POLYCARBONATE/ABS ALLOY† (PC/ABS)	470-525	125-200	200	4	-20	0.02
2700	STYRENIC THERMOPLASTIC ELASTOMER (TES)	360-450	60-100	175	2	NA	NA
2800	OLEFINIC THERMOPLASTIC ELASTOMER† (TEO)	360-410	60-150	175	2	0	0.03
3000	POLYMETHYLPENTENE (PMP)	510-580	150-200	175	2	NA	NA
3100	PERFLUOROALKOXY (PFA)	650-725	300-450	250	2	NA	NA
3200	ETHYLENE TETRAFLUOROETHYLENE (ETFE)	560-650	150-300	250	2	NA	NA
3300	POLYVINYLIDENE FLUORIDE (PVDF)	410-550	180-220	250	2	NA	NA
3400-3	LIQUID CRYSTAL POLYMER (LCP)	630-690	150-250	300	8	-20	NA
3400-4	LIQUID CRYSTAL POLYMER (LCP)	685-750	150-200	300	8	-20	NA
3500	FLUORINATED ETHYLENE PROPYLENE (FEP)	650-725	200+	250	2-4	NA	NA
4000	POLYPHTHALAMIDE† (PPA)	575-625	275-325	175	6	-25	0.05
4000A	POLYPHTHALAMIDE HOT WATER MOLDABLE (PPA)	625-650	150-325	175	6	-20	0.10
4200	THERMOPLASTIC POLYIMIDE† (TPI)	750-780	350-450	400	6	-40	0.01
4300	POLYSULFONE/POLYCARBONATE ALLOY (PSU/PC)	540-620	150-210	250	4	-20	0.02
4400	NYLON, HIGH TEMPERATURE (NHT)	590-650	275-325	175	4	-40	0.10
4500	ALIPHATIC POLYKETONE (PK)	430-500	180-300	140	4	-25	0.02
4600	SYNDIOTACTIC POLYSTYRENE (SPS)	560-620	160-300	180	2	-20	0.02
4700	POLYTRIMETHYLENE TEREPHTHALATE (PTT)	450-500	190-250	260	4-6	-40	0.01

†Hygroscopic Materials

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. No information supplied by RTP Company constitutes a warranty regarding product performance or use. Any information regarding performance or use is only offered as suggestion for investigation for use, based upon RTP Company or other customer experience. RTP Company makes no warranties, expressed or implied, concerning the suitability or fitness of any of its products for any particular purpose. It is the responsibility of the customer to determine that the product is safe, lawful and technically suitable for the intended use. The disclosure of information herein is not a license to operate under, or a recommendation to infringe any patents.

Technical Support: 800-433-4787 (Local callers 507-454-6900)

Web site: www.rtpcompany.com • E-mail: rtp@rtpcompany.com

World Headquarters: Winona, MN