

RTP Company Processing Conditions

RTP SERIES	POLYMER TYPE	TEMPERATURE °C		DRYING		DEW POINT °C	MOISTURE CONTENT %
		MELT	MOLD	TEMP (°C)	TIME (HRS)		
100	POLYPROPYLENE (PP)	191-232	32-66	79	2	NA	NA
200	NYLON 6/6† (PA)	277-299	66-107	79	4	-18	0.20
200A	NYLON 6† (PA)	243-279	54-93	82	2	-18	0.20
200B	NYLON 6/10 (PA)	277-299	66-107	79	2	-18	0.20
200C	NYLON 11 (PA)	224-288	38-66	79	4	-18	0.20
200D	NYLON 6/12† (PA)	249-285	60-93	79	4	-18	0.20
200E	NYLON, AMORPHOUS (PA)	271-299	66-99	79	4	-34	0.10
200F	NYLON 12† (PA)	221-274	66-104	79	4	-40	0.10
200H	NYLON 6/6 IMPACT MODIFIED (PA)	277-299	66-107	79	4	-18	0.20
300	POLYCARBONATE† (PC)	288-316	82-121	121	4	-29	0.02
400	POLYSTYRENE† (PS)	210-249	38-66	82	2	NA	NA
500	STYRENE ACRYLONITRILE† (SAN)	238-279	52-82	82	2	NA	NA
600	ACRYLONITRILE BUTADIENE STYRENE† (ABS)	204-238	63-85	82	2	-18	0.10
700	HIGH DENSITY POLYETHYLENE (HDPE)	193-232	21-66	79	2	NA	NA
700A	LOW DENSITY POLYETHYLENE (LDPE)	193-232	21-66	79	2	NA	NA
800	ACETAL (POM)	182-218	79-107	121	2	-32	0.15
900	POLYSULFONE (PSU)	332-371	93-149	135	4	-32	0.15
1000	POLYBUTYLENE TEREPHTHALATE† (PBT)	238-271	79-107	121	4	-29	0.03
1100	POLYETHYLENE TEREPHTHALATE† (PET)	260-298	135-162	121	4	-40	0.01
1200	POLYURETHANE THERMOPLASTIC ELASTOMER† (TPUR)	185-218	38-60	107	6	-18	0.01
1300	POLYPHENYLENE SULFIDE (PPS)	307-329	135-177	149	6	NA	0.04
1400	POLYETHERSULFONE† (PES)	343-377	135-177	149	6	-32	0.04
1500	POLYESTER THERMOPLASTIC ELASTOMER† (TPE)	210-238	21-49	93	2-4	NA	NA
1700	POLYPHENYLENE OXIDE, MODIFIED (PPO)	249-288	66-93	93	2	-18	0.10
1800	ACRYLIC (PMMA)	182-218	79-107	93	4	-18	0.02
1800A	POLYCARBONATE/ACRYLIC ALLOY (PC/PMMA)	238-266	32-66	82	3-4	-18	0.02
2100	POLYETHERIMIDE† (PEI)	354-399	135-177	149	4	-29	0.04
2200	POLYETHERETHERKETONE† (PEEK)	349-399	163-218	149	3	-29	0.10
2300A	RIGID THERMOPLASTIC POLYURETHANE† (RTPU)	221-243	52-93	107	4-6	-32	0.01
2300C	RIGID THERMOPLASTIC POLYURETHANE† (RTPU)	238-260	93-121	132	4-6	-32	0.01
2500	POLYCARBONATE/ABS ALLOY† (PC/ABS)	243-274	52-93	93	4	-29	0.02
2700	STYRENIC THERMOPLASTIC ELASTOMER (TES)	182-232	16-38	79	2	NA	NA
2800	OLEFINIC THERMOPLASTIC ELASTOMER† (TEO)	182-210	16-66	79	2	-18	0.03
3000	POLYMETHYLPENTENE (PMP)	266-304	66-93	79	2	NA	NA
3100	PERFLUOROALKOXY (PFA)	343-385	149-232	121	2	NA	NA
3200	ETHYLENE TETRAFLUOROETHYLENE (ETFE)	293-343	66-149	121	2	NA	NA
3300	POLYVINYLIDENE FLUORIDE (PVDF)	210-288	82-104	121	2	NA	NA
3400-3	LIQUID CRYSTAL POLYMER (LCP)	332-366	66-121	149	8	-29	NA
3400-4	LIQUID CRYSTAL POLYMER (LCP)	363-399	66-93	149	8	-29	NA
3500	FLUORINATED ETHYLENE-PROPYLENE (FEP)	343-385	93+	121	2-4	NA	NA
4000	POLYPHTHALAMIDE† (PPA)	302-329	135-163	79	6	-32	0.05
4000A	POLYPHTHALAMIDE HOT WATER MOLDABLE (PPA)	329-343	66-163	79	6	-29	0.10
4200	THERMOPLASTIC POLYIMIDE† (TPI)	399-416	177-232	204	6	-40	0.01
4300	POLYSULFONE/POLYCARBONATE ALLOY (PSU/PC)	282-327	66-99	121	4	-29	0.02
4400	NYLON, HIGH TEMPERATURE (NHT)	310-343	135-163	79	4	-40	0.10
4500	ALIPHATIC POLYKETONE (PK)	221-260	82-149	60	4	-32	0.02
4600	SYNDIOTACTIC POLYSTYRENE (SPS)	293-327	71-149	82	2	-29	0.02
4700	POLYTRIMETHYLENE TEREPHTHALATE (PTT)	232-260	87-120	127	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 (International callers +1-507-454-6900)

Web site: www.rtpcompany.com • Email: rtp@rtpcompany.com

World Headquarters: Winona, MN