

ECO-FLEX™ RTPV

Injection Molding Processing Tips

ECO-FLEX RTPVs combine the processability of a thermoplastic with the performance characteristics of thermoset rubber. They are processed using standard thermoplastic injection molding equipment.

Injection molding processing guidelines for ECO-FLEX RTPV:

1. Temperatures (F):

	SA-45A	SA-55A	SA-65A	SA-75A	SA-85A	SA-40D
Rear	340	340	340	340	350	370
Center	350	350	350	350	360	380
Front	350	350	350	350	360	380
Nozzle	360-390	360-390	360-390	360-390	370-400	370-400
Melt	370-400	370-400	370-400	370-400	380-410	380-410
Mold	50-125	50-125	50-125	50-125	50-125	50-125

2. Cooling time depends on wall thickness, grade and tool design. Cushion size is typically 0.250".
3. Injection times range from 0.5 to 2.5 seconds in order to optimize shear.
4. Hold time is typically 3 to 5 seconds (or until gate freezes), and hold pressure is approximately 50% of injection pressure.
5. Injection speed should be medium (50%) to maximum (100%) of machine capacity. Injection rate 10 to 50 g/sec.
6. It is far more effective to increase injection speed than to raise melt temperature for filling a mold.
7. Screw RPM 100-150.
8. Back pressure 50-150 psi.
9. Regrind can be used (recommend 20% regrind to 80% virgin).

DISCLAIMER OF WARRANTY AND LIABILITY:

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SYNESIS