

## **Processing Guidelines**

4138

450 Racetrack Road, P.O. Box 236
Washington, Pennsylvania, 15301
(724) 228 - 1260
washingtonpennplastic.com

## **Pressures**

 Injection
 600 - 1400 psi

 Holding
 150 - 900 psi

 Back
 075 - 200 psi

**Injection Speed** 1.0 - 2.5 in/s

## **Temperatures**

Barrel Zone 1 390-430 °F Barrel Zone 2 390-430 °F Barrel Zone 3 400-430 °F Barrel Zone 4 410-450 °F Nozzle 410-450 °F Hot Runner 410-450 °F 60-140 °F Mold 110-125 °F Hydraulic Oil Temperature

Material Drying is typically not required but for some thin walled parts drying may be required. If needed dry at 160 - 190°F for 1-2 hours.

## **Machine/Shot Information**

Shot Capacity vs. Barrel Capacity 2.5 to 4.0

Cushion 1/8" to 1/4"

Screw Decompression 0.10" to 0.25"

Clamp Tonnage should be 2.5 to 4.0 Tons per square inch of projected part area.

If you have any questions or require further processing information, please e-mail the Technical Service Group @ TechService@washpenn.com

These process conditions are typical processing parameters for injection molding. Use of these operating conditions, however, does not guarantee desired performance for all applications because of potential variability in a variety of factors including, but not limited to, gating, molding equipment, injection mold screw design, dispersion equipment, tooling, tool steel type, cooling capability, and part geometry. Washington Penn Plastic Co., Inc. makes no representations or warranties concerning product performance in any application.