

Processing Guidelines

4139

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
- Mold 60-140 °F
- Hydraulic Oil Temperature 110-125 °F

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