

Processing Guidelines

4197/4193- (Any Color)

Pressures

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|-----------|----------------|
| Injection | 600 - 1300 psi |
| Holding | 150 - 900 psi |
| Back | 075 - 125 psi |

Injection Speed

1.0 - 2.5 in/s

Temperatures

- Barrel Zone 1 410-430 °F
- Barrel Zone 2 410-430 °F
- Barrel Zone 3 410-440 °F
- Barrel Zone 4 410-440 °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