

Processing Guidelines

M2097-002

Pressures

Injection	900 - 2000 psi
Holding	500 - 1300 psi
Back	075 - 125 psi

Injection Speed

0.75 - 2.5 in/s

Temperatures

• Barrel Zone 1	430-470 °F
• Barrel Zone 2	430-470 °F
• Barrel Zone 3	440-480 °F
• Barrel Zone 4	440-480 °F
• Nozzle	450-490 °F
• Hot Runner	450-490 °F
• Mold	60-150 °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