

Processing Guidelines (Optimized Cycle)

PPC4UF0- (Any Color)

Pressures

Injection	41 - 120 Bar
Holding	10 - 80 Bar
Back	5 - 14 Bar

Injection Speed

25.0 – 63.0 mm/s

Temperatures

- Barrel Zone 1 195-210 °C
- Barrel Zone 2 195-210 °C
- Barrel Zone 3 200-215 °C
- Barrel Zone 4 200-215 °C
- Nozzle 200-215 °C
- Hot Runner 200-215 °C
- Mold 15-25 °C
- Hydraulic Oil Temperature 43-51 °C

Material Drying is typically not required but for some thin walled parts drying may be required. If needed dry at 71 – 88°C for 1-2 hours.

Machine/Shot Information

Shot Capacity vs. Barrel Capacity	3.0 to 5.0
Cushion	3.0 – 6.3 mm
Screw Decompression	2.5 – 6.3 mm

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