

## Processing Guidelines

### PPC6FR4TF1- (Any Color)

#### Pressures

Injection	41- 96 Bar
Holding	10 - 62 Bar
Back	05 – 14 Bar

#### Injection Speed

2.5 - 6.5 cm/s

#### Temperatures

• Barrel Zone 1	207-223 °C
• Barrel Zone 2	207-223 °C
• Barrel Zone 3	207-223 °C
• Barrel Zone 4	212-230 °C
• Nozzle	212-230 °C
• Hot Runner	212-230 °C
• Mold	15-60 °C
• Hydraulic Oil Temperature	43-52 °C

*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	3 mm to 6mm
Screw Decompression	2.5 mm to 6 mm
Clamp Tonnage should be	1.0 to 1.6 Tons per square cm of projected part area.

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