

Processing Guidelines (Low Emissions)

PPH4TF2LEO- (Any Color)

Pressures

Injection	41 - 83 Bar
Holding	10 - 41 Bar
Back	5.2 – 6.9 Bar

Injection Speed

2.5 - 6.3 cm/s

Temperatures

- Barrel Zone 1 187-193 °C
- Barrel Zone 2 187-204 °C
- Barrel Zone 3 193-204 °C
- Barrel Zone 4 193-210 °C
- Nozzle 193-215 °C
- Hot Runner 193-215 °C
- Mold 15- 60 °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– 87°C for 1-2 hours.

Machine/Shot Information

Shot Capacity vs. Barrel Capacity	2.5 to 4.0
Cushion	0.32 to 0.64 cm
Screw Decompression	0.25 to 0.64 cm
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