

## Processing Guidelines

### PPH5GF3.5- (Any Color)

#### Pressures

Injection	41- 96 Bar
Holding	10 - 62 Bar
Back	5.1–8.6 Bar

#### Injection Speed

0.75 - 2.5 in/s

#### Temperatures

• Barrel Zone 1	204-221 °C
• Barrel Zone 2	204-221 °C
• Barrel Zone 3	210-221 °C
• Barrel Zone 4	215-226 °C
• Nozzle	215-232 °C
• Hot Runner	215-232 °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	0.32-0.64 cm
Screw Decompression	0.25-0.64 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](mailto:TechService@washpenn.com)