

Processing Guidelines (Low Emissions) PPH6TF1.2LEO- (Any Color)

Pressures

Injection	41 - 93 Bar
Holding	7 - 45 Bar
Back	5 - 7 Bar

Injection Speed

25 - 65 mm/s

Temperatures

• Barrel Zone 1	187-198 °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 160 – 190°F for 1-2 hours.*

Machine/Shot Information

Shot Capacity vs. Barrel Capacity	2.5 to 4.0
Cushion	3 - 6 mm
Screw Decompression	2 – 6 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