

Processing Guidelines

TPO 3910R3- (Any Color)

Pressures

Injection	41 - 96 Bar
Holding	10 - 62 Bar
Back	5 - 10 Bar

Injection Speed

2.5 – 6.4 cm/s

Temperatures

• Barrel Zone 1	205-221 °C
• Barrel Zone 2	205-221 °C
• Barrel Zone 3	210-226 °C
• Barrel Zone 4	215-232 °C
• Nozzle	215-237 °C
• Hot Runner	215-237 °C
• Mold	16-60 °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	0.30 to 0.64 cm
Screw Decompression	0.2 to 0.64 cm
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