

Processing Guidelines

TPO 3985- (Any Color)

Pressures

| | |
|-----------|---------------|
| Injection | 41 - 97 Bar |
| Holding | 10 - 62 Bar |
| Back | 075 - 150 Bar |

Injection Speed

1.9 - 6.3 cm/s

Temperatures

| | |
|-----------------------------|------------|
| • Barrel Zone 1 | 188-210 °C |
| • Barrel Zone 2 | 188-210 °C |
| • Barrel Zone 3 | 188-210 °C |
| • Barrel Zone 4 | 193-215 °C |
| • Nozzle | 193-215 °C |
| • Hot Runner | 198-221 °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 71 – 87°C for 1-2 hours.

Machine/Shot Information

| | |
|-----------------------------------|---|
| Shot Capacity vs. Barrel Capacity | 2.5 to 4.0 |
| Cushion | 0.32 to 0.65 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