

Processing Guidelines

TPO 4210- (Any Color)

Pressures

Injection	41 - 96 Bar
Holding	10 - 62 Bar
Back	05 - 10 Bar

Injection Speed

1.90 – 6.35 cm/s

Temperatures

- Barrel Zone 1 188-204 °C
- Barrel Zone 2 188-204 °C
- Barrel Zone 3 193-210 °C
- Barrel Zone 4 193-210 °C
- Nozzle 198-215 °C
- Hot Runner 198-215 °C
- Mold 15-54 °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 – 88°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 0.65 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