

# **Processing Guidelines**

UC4R203 (Any Color)

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#### **Pressures**

Injection	600 - 14	100	psi
Holding	150 - 90	00	psi
Back	075 - 15	50	psi

### **Injection Speed** 1.50 - 2.75 in/s

### **Temperatures**

•	Barrel Zone 1	390-425 °F
•	Barrel Zone 2	390-425 °F
•	Barrel Zone 3	400-430 °F
•	Barrel Zone 4	400-430 °F
•	Nozzle	400-430 °F
•	Hot Runner	400-430 °F
•	Mold	60-140 °F
•	Hydraulic Oil Temperature	110-125 °F

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 hour.

## **Machine/Shot Information**

Shot Capacity vs. Barrel Capacity	2.5 to 4.0
Cushion	1/8" to 1/4"
Screw Decompression	0.10" to 0.25"

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

These process conditions are typical processing parameters for injection molding. Use of these operating conditions, however, does not guarantee desired performance for all applications because of potential variability in a variety of factors including, but not limited to, gating, molding equipment, injection mold screw design, dispersion equipment, tooling, tool steel type, cooling capability, and part geometry.

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