

Processing Guidelines

UP1X006- (Any Color)

Pressures

| | |
|-----------|----------------|
| Injection | 600 - 1300 psi |
| Holding | 150 - 900 psi |
| Back | 075 - 125 psi |

Injection Speed

1.0 - 2.5 in/s

Temperatures

| | |
|-----------------------------|------------|
| • Barrel Zone 1 | 415-435 °F |
| • Barrel Zone 2 | 415-435 °F |
| • Barrel Zone 3 | 415-445 °F |
| • Barrel Zone 4 | 415-445 °F |
| • Nozzle | 415-455 °F |
| • Hot Runner | 415-455 °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 1-2 hours.*

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