

Processing Guidelines

UP4F406 (Any Color)

Pressures

Injection	600 - 1400 psi
Holding	150 - 900 psi
Back	075 - 150 psi

Injection Speed

1.50 - 2.75 in/s

Temperatures

• Barrel Zone 1	400-425 °F
• Barrel Zone 2	400-425 °F
• Barrel Zone 3	420-440 °F
• Barrel Zone 4	420-450 °F
• Nozzle	420-460 °F
• Hot Runner	420-460 °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