



**Washington Penn Plastic Co., Inc.**

2080 North Main Street

Washington, PA 15301

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[www.washpenn.com](http://www.washpenn.com)

**• PROCESSING GUIDELINES FOR PPC9TF4 •**  
**(ANY COLOR)**

**Pressures**

Injection	500 - 1000 psi
Holding	250 - 500 psi
Back	100 - 200 psi

**Injection Speed**

1.00 - 3.5 in/s

**Temperatures**

• Barrel Zone 1	395-405 °F
• Barrel Zone 2	400-405 °F
• Barrel Zone 3	410-420 °F
• Barrel Zone 4	410-430 °F
• Nozzle	410-430 °F
• Hot Runner	415-440 °F
• Mold	60-120 °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](mailto:TechService@washpenn.com)