



Washington Penn Plastic Co., Inc.

2080 North Main Street

Washington, PA 15301

724-228-1260

www.washpenn.com

• PROCESSING GUIDELINES FOR PPH3CF4 •
(ANY COLOR)

Pressures

Injection	600 - 1100 psi
Holding	250 - 700 psi
Back	075 - 150 psi

Injection Speed

1.50 - 2.5 in/s

Temperatures

• Barrel Zone 1	430-440 °F
• Barrel Zone 2	430-440 °F
• Barrel Zone 3	435-445 °F
• Barrel Zone 4	445-455 °F
• Nozzle	445-465 °F
• Hot Runner	445-475 °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