



**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 PRC25MG4 •**  
**(ANY COLOR)**

**Pressures**

Injection	600 - 1300 psi
Holding	150 - 600 psi
Back	050 - 150 psi

**Injection Speed**

.50 - 2.0 in/s

**Temperatures**

• Barrel Zone 1	430-440 °F
• Barrel Zone 2	440-450 °F
• Barrel Zone 3	440-450 °F
• Barrel Zone 4	445-460 °F
• Nozzle	430-455 °F
• Hot Runner	430-460 °F
• Mold	80-120 °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 1-3 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](mailto:TechService@washpenn.com)