



Processing Guidelines PPC2TF3¹ - (Any Color)

Pressures

| | | |
|-----------|----------------|------------|
| Injection | 600 - 1400 psi | 41- 97 Bar |
| Holding | 150 - 900 psi | 10-62 Bar |
| Back | 075 - 200 psi | 5-14 Bar |

Injection Speed

| | |
|----------------|------------|
| 1.0 - 2.5 in/s | 19-63 mm/s |
|----------------|------------|

Temperatures

| | | |
|-----------------------------|------------|-----------|
| • Barrel Zone 1 | 430-450 °F | 218-229°C |
| • Barrel Zone 2 | 430-450 °F | 218-229°C |
| • Barrel Zone 3 | 430-460 °F | 218-235°C |
| • Barrel Zone 4 | 430-460 °F | 218-235°C |
| • Nozzle | 430-470 °F | 218-241°C |
| • Hot Runner | 430-470 °F | 218-241°C |
| • Mold | 60-140 °F | 16-60°C |
| • Hydraulic Oil Temperature | 110-125 °F | 43-52°C |

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 | 2.5 to 4.0 |
| Cushion | 1/8" to 1/4" | 3.0-6.0 mm |
| Screw Decompression | 0.10" to 0.25" | 2.5 to 6.3 mm |

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 at wp.techservices@audia.com