



WASHINGTON PENN

An **AUDIA**® Company

washingtonpenn.com

Processing Guidelines

PPC1GF1.0 - (Any Color)

Pressures

Injection	900 - 2400 psi	62-165 Bar
Holding	400 - 1500 psi	28-103 Bar
Back	075 - 125 psi	5-9 Bar

Injection Speed

1.0 - 2.5 in/s	25-63 mm/s
----------------	------------

Temperatures

• Barrel Zone 1	430-470 °F	221-243°C
• Barrel Zone 2	440-480 °F	216-249°C
• Barrel Zone 3	450-490 °F	232-254°C
• Barrel Zone 4	460-500 °F	238-260°C
• Nozzle	460-500 °F	238-260°C
• Hot Runner	460-500 °F	238-260°C
• Mold	60-160 °F	16-71°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