



WASHINGTON PENN

An **AUDIA**® Company

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Processing Guidelines

PPC6TG2.5 - (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 | 25-63 mm/s |
|----------------|------------|

Temperatures

| | | |
|-----------------------------|------------|-----------|
| • Barrel Zone 1 | 405-435 °F | 207-224°C |
| • Barrel Zone 2 | 405-435 °F | 207-224°C |
| • Barrel Zone 3 | 405-435 °F | 207-224°C |
| • Barrel Zone 4 | 415-445 °F | 213-229°C |
| • Nozzle | 415-445 °F | 213-229°C |
| • Hot Runner | 415-445 °F | 213-229°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 (71-88° C) for 1-2 hours.

Machine/Shot Information

| | | |
|---|----------------|---------------|
| Shot Capacity vs. Barrel Capacity | 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