



Processing Guidelines

PPC3MGF3 - (Any Color)

Pressures

| | | |
|-----------|----------------|------------|
| Injection | 600 - 1600 psi | 41-110 Bar |
| Holding | 150 - 900 psi | 10-62 Bar |
| Back | 075 - 125 psi | 5-9 Bar |

Injection Speed

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

Temperatures

| | | |
|-----------------------------|------------|-----------|
| • Barrel Zone 1 | 420-450 °F | 216-232°C |
| • Barrel Zone 2 | 420-450 °F | 216-232°C |
| • Barrel Zone 3 | 430-460 °F | 221-238°C |
| • Barrel Zone 4 | 440-470 °F | 227-243°C |
| • Nozzle | 440-470 °F | 227-243°C |
| • Hot Runner | 440-470 °F | 227-243°C |
| • Mold | 60-170 °F | 16-77°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