



## Processing Guidelines

### PPH4GF2.5<sup>+</sup> - (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             | 415-445 °F | 213-230°C |
| • Barrel Zone 2             | 415-445 °F | 213-230°C |
| • Barrel Zone 3             | 425-455 °F | 218-235°C |
| • Barrel Zone 4             | 435-465 °F | 224-241°C |
| • Nozzle                    | 425-465 °F | 218-241°C |
| • Hot Runner                | 425-465 °F | 218-241°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 (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](mailto:wp.techservices@audia.com)