



## Processing Guidelines (Low Emissions)

### PPH7TF1-LEO - (Any Color)

#### Pressures

Injection	595 -1349 psi	41-93 Bar
Holding	102 - 653 psi	7-45 Bar
Back	073 - 102 psi	5-7 Bar

#### Injection Speed

1.0 - 2.6 in/s	25-65 mm/s
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#### Temperatures

• Barrel Zone 1	369-388 °F	187-198°C
• Barrel Zone 2	369-399 °F	187-204°C
• Barrel Zone 3	379-399 °F	193-204°C
• Barrel Zone 4	379-410 °F	193-210°C
• Nozzle	379-419 °F	193-215°C
• Hot Runner	379-419 °F	193-215°C
• Mold	59-140 °F	15-60°C
• Hydraulic Oil Temperature	109-124 °F	43-51°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	0.08" to 0.24"	2 to 6 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)