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Blow Molding Processing Guidelines

UC2I002 - (Any Color)

Temperatures

• Barrel Zone 1	360 - 400 °F	182 - 204 °C
• Barrel Zone 2	360 - 400 °F	182 - 204 °C
• Barrel Zone 3	370 - 410 °F	188 - 210 °C
• Barrel Zone 4	370 - 410 °F	188 - 210 °C
• Nozzle	370 - 410 °F	188 - 210 °C
• Mandrel	370 - 420 °F	188 - 216 °C
• Die	370 - 420 °F	188 - 216 °C
• Mold Cooling	100 - 190 °F	38 - 88 °C

Standard PP Drying times for PP resins is 160 - 190 °F (71 - 88 °C) for 1-2 hours if drying times is less than 1 hour you can increase temperature to 210 °F (99 °C) to accommodate a short drying cycle. Dryers should be equipped with a desiccant to extract moisture.

Machine/Shot Information

Screens	20 - 100 Mesh
Regrind	20 - 60%

If you have any questions or require further processing information, please e-mail the Technical Service Group at wp.techservices@washpenn.com

These process conditions are typical processing parameters for injection molding. Use of these operating conditions, however, does not guarantee desired performance for all applications because of potential variability in a variety of factors including, but not limited to, gating, molding equipment, injection mold screw design, dispersion equipment, tooling, tool steel type, cooling capability, and part geometry. Washington Penn Plastic Co., Inc. makes no representations or warranties concerning product performance in any application.