



## Processing Guidelines

### PPC3CND2.6 - (Any Color)

#### Pressures

Injection	600 - 2000 psi	41-138 Bar
Holding	150 - 1100 psi	10-76 Bar
Back	075 - 150 psi	5-10 Bar

#### Injection Speed

1.0 - 2.5 in/s	25-63 mm/s
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#### Temperatures

• Barrel Zone 1	425-450 °F	218-232°C
• Barrel Zone 2	435-465 °F	224-241°C
• Barrel Zone 3	435-465 °F	224-241°C
• Barrel Zone 4	440-470 °F	227-243°C
• Nozzle	440-480 °F	227-249°C
• Hot Runner	440-480 °F	227-249°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](mailto:wp.techservices@audia.com)