WASHINGTON PENN
An AUDIA® Company

washingtonpenn.com

Inj. Molding Processing Guidelines

TPO 3965 - (Any Color)

Pressure

Injection	600 - 1400 psi	40 -100 Bar
Holding	150 - 900 psi	10 - 60 Bar
Back	075 - 150 psi	5 - 10 Bar

Injection Speed

	1.0 - 2.5 in/s	25 - 65 mm/s

Temperatures

• Barrel Zone 1	380 - 420 °F	190 - 215 °C
• Barrel Zone 2	380 - 420 °F	190 - 215 °C
• Barrel Zone 3	390 - 430 °F	200 - 220 °C
• Barrel Zone 4	400 - 440 °F	205 - 230 °C
• Nozzle	400 - 440 °F	205 - 230 °C
• Hot Runner	400 - 440 °F	205 - 230 °C
• Mold	60 - 140 °F	16 - 60 °C
• Hydraulic Oil Temperature	110 - 125 °F	43 - 50 °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 - 4.0	2.5 - 4.0
Cushion	1/8" to 1/4"	3 to 6 mm
Screw Decompression	0.10" to 0.25"	3 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@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.