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Processing Guidelines PPH4GF3.5<sup>-</sup> - (Any Color)

<u>Pressures</u>		
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
<b>Temperatures</b>		
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  $160 - 190^{\circ}F(71-88^{\circ}C)$  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** 

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.