

Processing Guidelines

4137 (Permatuf)

Pressures

Injection	600 - 1400 psi
Holding	150 - 900 psi
Back	075 - 200 psi

Injection Speed

1.0 - 2.5 in/s

Temperatures

• Barrel Zone 1	390-430 °F
• Barrel Zone 2	390-430 °F
• Barrel Zone 3	400-430 °F
• Barrel Zone 4	410-450 °F
• Nozzle	410-450 °F
• Hot Runner	410-450 °F
• Mold	60-140 °F
• Hydraulic Oil Temperature	110-125 °F

*Material Drying is typically not required but for some thin walled parts drying may be required.
If needed dry at 160 – 190°F for 1-2 hours.*

Machine/Shot Information

Shot Capacity vs. Barrel Capacity	2.5 to 4.0
Cushion	1/8" to 1/4"
Screw Decompression	0.10" to 0.25"
Clamp Tonnage should be 2.5 to 4.0 Tons per square inch of projected part area.	