



**Washington Penn Plastic Co., Inc.**

2080 North Main Street

Washington, PA 15301

724-228-1260

[www.washpenn.com](http://www.washpenn.com)

**• PROCESSING GUIDELINES FOR PPC2TF1 •**  
**(ANY COLOR)**

**Pressures**

|           |                |
|-----------|----------------|
| Injection | 600 - 1100 psi |
| Holding   | 250 - 700 psi  |
| Back      | 075 - 150 psi  |

**Injection Speed**

1.50 - 2.5 in/s

**Temperatures**

|                             |            |
|-----------------------------|------------|
| • Barrel Zone 1             | 435-445 °F |
| • Barrel Zone 2             | 435-445 °F |
| • Barrel Zone 3             | 440-450 °F |
| • Barrel Zone 4             | 450-460 °F |
| • Nozzle                    | 450-470 °F |
| • Hot Runner                | 450-480 °F |
| • Mold                      | 60-120 °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 hour.*

**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. |                |

If you have any questions or require further processing information, please e-mail the Technical Service Group @ [techservice@washpenn.com](mailto:techservice@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.