



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

2080 North Main Street

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

**• PROCESSING GUIDELINES FOR PPC5UFO •**  
**(ANY COLOR)**

**Pressures**

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

**Injection Speed**

1.50 - 2.5 in/s

**Temperatures**

|                             |            |
|-----------------------------|------------|
| • Barrel Zone 1             | 400-430 °F |
| • Barrel Zone 2             | 420-440 °F |
| • Barrel Zone 3             | 420-440 °F |
| • Barrel Zone 4             | 420-440 °F |
| • Nozzle                    | 430-440 °F |
| • Hot Runner                | 410-450 °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)