

# **Processing Guidelines**

**TPO 4210-** (Any Color)

450 Racetrack Road, P.O. Box 236
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#### **Pressures**

Injection	41 - 96	Bar
Holding	10 - 62	Bar
Back	05 - 10	Bar

### Injection Speed 1.90 – 6.35 cm/s

#### **Temperatures**

•	Barrel Zone 1	188-204 °C
•	Barrel Zone 2	188-204 °C
•	Barrel Zone 3	193-210 °C
•	Barrel Zone 4	193-210 °C
•	Nozzle	198-215 °C
•	Hot Runner	198-215 °C
•	Mold	15-54 °C
•	Hydraulic Oil Temperature	43-52 °C

Material Drying is typically not required but for some thin walled parts drying may be required. If needed dry at 71 - 88°C for 1-2 hours.

## **Machine/Shot Information**

Shot Capacity vs. Barrel Capacity	2.5 to 4.0
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Cushion 0.32 to 0.65 cm Screw Decompression 0.25 to 0.65 cm

Clamp Tonnage should be 1.0 to 1.6 Tons per square cm of projected part area.

If you have any questions or require further processing information, please e-mail the Technical Service Group @ 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.