

Processing Guidelines

UC4X206 (Any Color)

Pressures

Injection	600 - 1400 psi
Holding	150 - 900 psi
Back	100 - 200 psi

Injection Speed

1.50 - 2.75 in/s

Temperatures

• Barrel Zone 1	390-420 °F
• Barrel Zone 2	390-420 °F
• Barrel Zone 3	395-435 °F
• Barrel Zone 4	405-445 °F
• Nozzle	415-455 °F
• Hot Runner	415-455 °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 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.	