

## Processing Guidelines

### UP3F306 (Any Color)

#### Pressures

|           |                |
|-----------|----------------|
| Injection | 600 - 1400 psi |
| Holding   | 150 - 900 psi  |
| Back      | 075 - 175 psi  |

#### Injection Speed

1.50 - 2.75 in/s

#### Temperatures

|                             |            |
|-----------------------------|------------|
| • Barrel Zone 1             | 420-445 °F |
| • Barrel Zone 2             | 430-455 °F |
| • Barrel Zone 3             | 430-455 °F |
| • Barrel Zone 4             | 430-465 °F |
| • Nozzle                    | 440-465 °F |
| • Hot Runner                | 440-470 °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. |                |