

Processing Guidelines

UP6X103 (Any Color)

Pressures

| | |
|-----------|----------------|
| Injection | 800 - 1500 psi |
| Holding | 150 - 900 psi |
| Back | 075 - 125 psi |

Injection Speed

1.00 – 3.00 in/s

Temperatures

| | |
|-----------------------------|------------|
| • Barrel Zone 1 | 400-440 °F |
| • Barrel Zone 2 | 410-450 °F |
| • Barrel Zone 3 | 410-450 °F |
| • Barrel Zone 4 | 420-460 °F |
| • Nozzle | 420-460 °F |
| • Hot Runner | 420-460 °F |
| • Mold | 60-160 °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. | |