



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

2080 North Main Street

Washington, PA 15301

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

**• PROCESSING GUIDELINES FOR PPC4CF1 •**  
**(ANY COLOR)**

**Pressures**

Injection	600 - 1100 psi
Holding	250 - 700 psi
Back	075 - 150 psi

**Injection Speed**

1.50 - 2.5 in/s

**Temperatures**

• Barrel Zone 1	425-435 °F
• Barrel Zone 2	425-435 °F
• Barrel Zone 3	430-440 °F
• Barrel Zone 4	440-450 °F
• Nozzle	440-460 °F
• Hot Runner	440-470 °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)