



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

2080 North Main Street

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**• PROCESSING GUIDELINES FOR PPC6CF2 •**  
**(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             | 415-425 °F |
| • Barrel Zone 2             | 415-425 °F |
| • Barrel Zone 3             | 420-430 °F |
| • Barrel Zone 4             | 430-440 °F |
| • Nozzle                    | 430-450 °F |
| • Hot Runner                | 430-460 °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)