



Washington Penn Plastic Co., Inc.

2080 North Main Street

Washington, PA 15301

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www.washpenn.com

• PROCESSING GUIDELINES FOR PPC8CF2 •
(ANY COLOR)

Pressures

| | |
|-----------|----------------|
| Injection | 500 - 1000 psi |
| Holding | 250 - 500 psi |
| Back | 075 - 150 psi |

Injection Speed

1.00 - 3.5 in/s

Temperatures

| | |
|-----------------------------|------------|
| • Barrel Zone 1 | 400-410 °F |
| • Barrel Zone 2 | 405-410 °F |
| • Barrel Zone 3 | 415-425 °F |
| • Barrel Zone 4 | 415-435 °F |
| • Nozzle | 415-435 °F |
| • Hot Runner | 420-445 °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