

## Processing Guidelines

### PPH2TF1- (Any Color)

#### Pressures

Injection	600 - 1400 psi
Holding	150 - 900 psi
Back	075 - 200 psi

#### Injection Speed

1.0 - 2.5 in/s

#### Temperatures

- Barrel Zone 1 430-450 °F
- Barrel Zone 2 430-450 °F
- Barrel Zone 3 430-460 °F
- Barrel Zone 4 430-460 °F
- Nozzle 430-470 °F
- Hot Runner 430-470 °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 1-2 hours.*

#### 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.