

Processing Guidelines

UC4F302 (Any Color)

Pressures

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

Injection Speed

1.50 - 2.75 in/s

Temperatures

- Barrel Zone 1 430-450 °F
- Barrel Zone 2 430-450 °F
- Barrel Zone 3 435-460 °F
- Barrel Zone 4 445-465 °F
- Nozzle 445-475 °F
- Hot Runner 445-475 °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 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.