

ADX-2020

START-UP RECOMMENDATIONS

Barrel Temperatures

| Nozzle | C4 | C3 | C2 | C1 |
|-----------------|-----------------|-----------------|-----------------|-----------------|
| 400° F / 200° C | 420° F / 210° C | 390° F / 200° C | 355° F / 180° C | 340° F / 170° C |

For harder to fill parts the temperatures may have to be increased. Keep lower temperatures in the rear zones to allow venting through hopper.

Melt Temperature

Maximum temperature with a hand pyrometer should be 365° F to 440° F.

Mold Temperature

Minimum "A" surface steel temperature 120° F to 140° F (49° C to 60° C).

Injection Pressure

The preferred range is 20 to 60% of machine capacity. Pressure should be sufficient to fill the mold without hesitation or flashing.

Holding Pressure

Setting should be lower than boost pressure with a minimum amount of time to prevent over-packing of the part.

Injection speed

Slow to medium speed to prevent excessive shear on the material.

Cushion

Maintain at 5-10mm to provide enough material for consistent parts.

Decompression

Use only when necessary to prevent nozzle drool.

Screw RPM

Screw should stop 1 to 2 seconds before mold open. A lower RPM is preferred for mixing and uniform melt temperature.

Drying

Material should be dried for a minimum of 2 hours and a maximum of 4 hours at 82°C (180°F).

Disclaimer: The user assumes all risk and liability concerning the use of these recommendations.
