

ADX-5028

START-UP RECOMMENDATIONS

Mold-In-Color Seamless Airbag Deployable TPO

Barrel Temperatures

Nozzle	C4	C3	C2	C1
410° F / 215° C	420° F / 220° C	410° F / 210° C	400° F / 205° C	370° F / 190° 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 380° F to 450° F.

Mold Temperature

For non-painted parts, grain side steel should be min. 120°F. Typical water temp settings 80-140°F

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

Medium to fast speed. 2"/sec is mid range.

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 hrs. at 82° C (180° F).