

ATX644

PROCESS/START-UP RECOMMENDATIONS

Scratch Resistant Filled Polypropylene

Barrel Temperatures

Nozzle	C4	C3	C2	C1
420° F (215° C)	425° F (218° C)	425° F (218° C)	425° F (218° C)	400° F (204° C)

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

Melt Temperature

Maximum temperature with a hand pyrometer should be 400° F to 450° F (204° C to 232° C)

Mold Temperature

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

Injection Pressure

Allow 10% over max fill pressure so as not to limit injection speed

Holding Pressure

Normally 50-60% of max fill pressure

Injection speed

1 to 3 inches/second

Cushion

Maintain at 0.25-0.5" 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 212° F (100° C).

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