

# ATX904-20

## PROCESS/START-UP RECOMMENDATIONS

### Filled Polypropylene

#### Barrel Temperatures

| Nozzle          | C4              | C3              | C2              | C1              |
|-----------------|-----------------|-----------------|-----------------|-----------------|
| 410° F / 210° C | 420° F / 215° C | 420° F / 215° C | 410° F / 210° C | 380° F / 193° 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 390° F to 480° F (198° C to 248° C).

#### **Mold Temperature**

Typically 104° F to 122° F (40° C to 50° C).

#### **Injection Pressure**

The preferred range is 50 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 0.25"-0.50" (6-12mm) 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.*

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