

# ATX926

## PROCESS/START-UP RECOMMENDATIONS

### 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**

To promote scratch resistance, 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.*

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