B11B
START-UP RECOMMENDATIONS

**Barrel Temperatures**

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>400° F / 200° C</td>
<td>410° F / 210° C</td>
<td>400° F / 205° C</td>
<td>380° F / 195° C</td>
<td>360° F / 180° C</td>
</tr>
</tbody>
</table>

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 420° F to 470° F.

**Mold Temperature**
Typically 80° to 100° 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**
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.

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