HIP-4948S
START-UP RECOMMENDATIONS

TPO

**Barrel Temperatures**

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<tbody>
<tr>
<td>Nozzle</td>
<td>390° F / 200° C</td>
<td>410° F / 210° C</td>
<td>390° F / 200° C</td>
<td>375° F / 190° C</td>
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<td>355° F / 180° C</td>
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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 370° F to 420° F.

**Mold Temperature**

Typically 80° to 100° F.

**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 10-20mm 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.*