## JHH-791

### START-UP RECOMMENDATIONS

<table>
<thead>
<tr>
<th>Barrel Temperatures</th>
<th>High Modulus Polypropylene</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nozzle</td>
<td>C4</td>
</tr>
<tr>
<td>430° F / 220° C</td>
<td>450° F / 230° C</td>
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</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 400° F to 470° F. (204° C to 243° C)

### Mold Temperature
Typically 80° to 110° F. (27° C to 43° C)

### 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.

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