R150GM-US
START-UP RECOMMENDATIONS

Filled Polypropylene

<table>
<thead>
<tr>
<th>Barrel Temperatures</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nozzle</td>
<td>410º F / 210º C</td>
<td>430º F / 220º C</td>
<td>410º F / 210º C</td>
<td>390º F / 200º 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 380º F to 440º F (193º C to 227º C).

Mold Temperature
Typically 80º to 100º F (27º C to 38º 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 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 212º F (100º C).

Other
Advanced Composites will not be held responsible for the result of the use of any injection molding process enhancers, flow enhancers or regrind used with Advanced Composites compounded PP material.

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