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SEB-300C

START-UP RECOMMENDATIONS

Glass Filled PP

Barrel Temperatures

Nozzle	C4	C3	C2	C1
410º F / 210º C	430º F / 220º C	420º F / 215º C	400º F / 205º C	380º F / 195º C

For hard to fill molds the temperatures may have to be increased. Keep lower temperatures in the rear zones to allow venting through hopper.

Actual Processing Temperature Range
Maximum temperature with a hand pyrometer should be 400º F to 470º F (204º C to 243º C).

Mold Temperature
Typically 110º to 130º F (43º C to 54º C). If mold temperature is too low the surface of the part will be rough and wavy.

Injection Pressure
The preferred range is 40 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.

Drying
Material should be dried for a minimum of 2 hours and a maximum of 4 hours at 212º F (100º C).

Note: Barrel and hot runner needs to be thoroughly purged with a low MFR material.