

# X404C SR

## START-UP RECOMMENDATIONS

Scratch Resistant Mold-In-Color High Modulus Bumper Grade TPO

### Barrel Temperatures

Nozzle	C4	C3	C2	C1
420° F / 215° C	450° F / 230° C	430° F / 220° C	400° F / 205° C	370° F / 190° C

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 390° F to 440° F.

### Mold Temperature

Minimum "A" surface steel temperature 120° F to 140° F (49° C to 60° 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

Medium to fast speed.

### 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 212° F (100° C).

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

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