X404C SR
START-UP RECOMMENDATIONS
Scratch Resistant Mold-In-Color High Modulus Bumper Grade TPO

Barrel Temperatures

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>420°F / 215°C</td>
<td>450°F / 230°C</td>
<td>430°F / 220°C</td>
<td>400°F / 205°C</td>
<td>370°F / 190°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 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.