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ADX-1031

START-UP RECOMMENDATIONS

Rubber Modified Polypropylene

Barrel Temperatures

Nozzle	C4	C3	C2	C1
430° F / 221° C	450° F / 232° C	420° F / 215° C	400° F / 204° C	380° F / 193° C

For hard 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 460° F (204ºC to 238ºC).

Mold Temperature
Minimum "A" surface steel temperature 120º F to 140º F (49º C to 60º 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.

Drying
Material drying is not required. Preheating dryer temperature should be at 158°F (70°C) maximum of 2 hours.