### ADX-2020

**START-UP RECOMMENDATIONS**

#### 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>400°F / 200°C</td>
<td>420°F / 210°C</td>
<td>390°F / 200°C</td>
<td>355°F / 180°C</td>
<td>340°F / 170°C</td>
</tr>
</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 365°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

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 82°C (180°F).

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