ADX-2024
START-UP RECOMMENDATIONS

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>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**

Typically 80°F to 110°F.

**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).

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