**ADX-5001 NYX**

**PROCESS/START-UP RECOMMENDATIONS**

### Filled Polypropylene

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>420º F (215º C)</td>
<td>425º F (218º C)</td>
<td>425º F (218º C)</td>
<td>425º F (218º C)</td>
<td>400º F (204º C)</td>
</tr>
</tbody>
</table>

For harder to fill parts temperatures may have to be increased. Keep lower temperatures in the rear zones to allow venting through the hopper.

### Melt Temperature

Maximum temperature with a hand pyrometer should be 400º F to 450º F (204º C to 232º C)

### Mold Temperature

Minimum “A” surface steel temperature 120º F to 140º F (49º C to 60º C)

### Injection Pressure

Allow 10% over max fill pressure so as not to limit injection speed

### Holding Pressure

Normally 50-60% of max fill pressure

### Injection speed

1 to 3 inches/second

### Cushion

Maintain at 0.25-0.5” 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 hrs. @ 212º F (100º C)

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