ATX644
PROCESS/START-UP RECOMMENDATIONS

Scratch Resistant Filled Polypropylene

<table>
<thead>
<tr>
<th>Barrel Temperatures</th>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>420º F (215º C)</td>
<td>425º F (218º C)</td>
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<td>425º F (218º C)</td>
<td>400º F (204º C)</td>
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</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 hours and a maximum of 4 hours at 212º F (100º C).

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