

ATX646M

PROCESS/START-UP RECOMMENDATIONS

Filled Polypropylene

Barrel Temperatures

Nozzle	C4	C3	C2	C1
410° F / 210° C	420° F / 215° C	420° F / 215° C	410° F / 210° C	380° F / 193° C

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 380° F to 460° F (193° C to 237° C).

Mold Temperature

Typically 100° F to 120° F (37° C to 49° C).

Injection Pressure

The preferred range is 50 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 0.25"-0.50" (6-12mm) 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. @ 180° F (82° C).

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