ATX646M
PROCESS/START-UP RECOMMENDATIONS

Filled Polypropylene

<table>
<thead>
<tr>
<th></th>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nozzle Temperatures</td>
<td>410º F</td>
<td>420º F</td>
<td>420º F</td>
<td>410º F</td>
<td>380º F</td>
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<tr>
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<td>/ 210º C</td>
<td>/ 215º C</td>
<td>/ 215º C</td>
<td>/ 210º C</td>
<td>/ 193º C</td>
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</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 380º F to 460º F (193º C to 237º C).

Mold Temperature
Typically 100º F to 120º F (37º C to 49º 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. @ 180º F (82º C).

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