ATX759

PROCESS/START-UP RECOMMENDATIONS

Filled Polypropylene

<table>
<thead>
<tr>
<th>Barrel Temperatures</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
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</thead>
<tbody>
<tr>
<td>Nozzle</td>
<td>420º F(215º C)</td>
<td>425º F(218º C)</td>
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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
Typically 90º F (core) to 120º F (cavity) (32ºC to 49ºC)

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.