ATX832N
PROCESS/START-UP RECOMMENDATIONS

### Filled Polypropylene

#### Barrel Temperatures

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<tbody>
<tr>
<td>Nozzle</td>
<td>420º F (215º C)</td>
<td>425º F (218º C)</td>
<td>425º F (218º C)</td>
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<td>400º F (204º 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) (32º C to 49º 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 .25-.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.