## ATX904-20

**PROCESS/START-UP RECOMMENDATIONS**

### Filled Polypropylene

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>410º F / 210º C</td>
<td>420º F / 215º C</td>
<td>420º F / 215º C</td>
<td>410º F / 210º C</td>
<td>380º F / 193º C</td>
</tr>
</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 390º F to 480º F (198º C to 248º C).

### Mold Temperature

Typically 104º F to 122º F (40º C to 50º 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 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.*