BJ4H-CS
START-UP RECOMMENDATIONS

Polypropylene for Interior Parts
High Impact

<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>380°F / 200°C</td>
<td>400°F / 210°C</td>
<td>390°F / 200°C</td>
<td>355°F / 180°C</td>
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</table>

For hard to fill parts the temperatures may have to be increased. Keep lower temperatures in the rear zones to allow venting through hopper.

Melt Temperature
Maximum temperature with a hand pyrometer should be 365°F to 440°F (185°C to 227°C).

Mold Temperature
Typically 80°F to 110°F (27°C to 43°C).

Injection Pressure
The preferred range is 20 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 5-10mm 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.

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