**BJ4H-G**

START-UP RECOMMENDATIONS

**Polypropylene for Interior Parts**  
(High Flow - High Impact)

### Barrel Temperatures

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>400º F / 200º C</td>
<td>420º F / 210º C</td>
<td>390º F / 200º C</td>
<td>355º F / 180º C</td>
<td>340º F / 170º C</td>
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</tbody>
</table>

For harder 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 365º F to 440º F. (185º C to 226º C)

### Mold Temperature

Typically 80º to 110º F. (27º C to 43º 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.*