

BJ4H-YA21

START-UP RECOMMENDATIONS

Barrel Temperatures

Nozzle	C4	C3	C2	C1
400° F / 200° C	420° F / 210° C	390° F / 200° C	355 F / 180° C	340° F / 170° C

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 365° F to 440° F. (185° C to 226° C)

Mold Temperature

Typically 80° 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.
