BJHH-2119
START-UP RECOMMENDATIONS

Application: for Auto Interior Parts

<table>
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<th>Barrel Temperatures</th>
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<td><strong>Nozzle</strong></td>
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<td>410°F / 210°C</td>
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For hard to fill molds 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 400°F to 470°F. (204°C to 243°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.*