BJS-809S
START-UP RECOMMENDATIONS

### Barrel Temperatures

<table>
<thead>
<tr>
<th></th>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
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</thead>
<tbody>
<tr>
<td><strong>High Impact Polypropylene</strong></td>
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<tr>
<td><strong>420°F / 215°C</strong></td>
<td>430°F / 220°C</td>
<td>430°F / 220°C</td>
<td>410°F / 210°C</td>
<td>380°F / 195°C</td>
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</tbody>
</table>

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°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.