

# BJS-MF

## START-UP RECOMMENDATIONS

### High Impact Polypropylene

#### Barrel Temperatures

Nozzle	C4	C3	C2	C1
420° F / 215° C	430° F / 220° C	430° F / 220° C	410° F / 210° C	380° F / 195° C

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.