## BJ4H-HC SR
START-UP RECOMMENDATIONS

### Polypropylene

<table>
<thead>
<tr>
<th>Barrel Temperatures</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nozzle</td>
<td>410°F / 210°C</td>
<td>430°F / 220°C</td>
<td>410°F / 210°C</td>
<td>390°F / 200°C</td>
</tr>
</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 365°F to 440°F. (185°C to 226°C)

### Mold Temperature
Minimum “A” surface steel temperature 120°F to 140°F (49°C to 60°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.

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Disclaimer: The user assumes all risk and liability concerning the use of these recommendations.