FH-120M SR
START-UP RECOMMENDATIONS

<table>
<thead>
<tr>
<th>Barrel Temperatures</th>
<th>Metallic High Modulus Bumper Grade TPO</th>
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<tbody>
<tr>
<td>Nozzle</td>
<td>C4</td>
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<tr>
<td>420° F / 215° C</td>
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<tr>
<td>450° F / 230° C</td>
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<tr>
<td>430° F / 220° C</td>
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<tr>
<td>400° F / 205° C</td>
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<tr>
<td>370° F / 190° C</td>
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</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 390° F to 440° F.

**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**
Medium to fast speed.

**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.