

# FIT-500C

## START-UP RECOMMENDATIONS

Interior Grade TPO

### Barrel Temperatures

| Nozzle          | C4              | C3              | C2              | C1              |
|-----------------|-----------------|-----------------|-----------------|-----------------|
| 390° F / 200° C | 410° F / 210° C | 390° F / 200° C | 375° F / 190° C | 355° F / 180° C |

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 370° F to 420° F.

### Mold Temperature

Typically 80° to 100° F.

### Injection Pressure

The preferred range is 50 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 10-20mm 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.

### Drying

Material should be dried for a minimum of 2 hours and a maximum of 4 hours at 212° F (100° C).

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

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