# FSR-139

## START-UP RECOMMENDATIONS

### Rubber Modified High Impact PP

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>390°F / 200°C</td>
<td>410°F / 210°C</td>
<td>390°F / 200°C</td>
<td>375°F / 190°C</td>
<td>355°F / 180°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 370°F to 420°F (188°C to 216°C).

### Mold Temperature

Typically 80°F to 100°F (27°C to 38°C).

### 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.*