J109UB
START-UP RECOMMENDATIONS

**Barrel Temperatures**

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>C4</th>
<th>C3</th>
<th>C2</th>
<th>C1</th>
</tr>
</thead>
<tbody>
<tr>
<td>410°F / 210°C</td>
<td>430°F / 220°C</td>
<td>420°F / 215°C</td>
<td>400°F / 205°C</td>
<td>380°F / 195°C</td>
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</tbody>
</table>

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°F 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.

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