SP580US
START-UP RECOMMENDATIONS

Scratch Resistant High Impact Polypropylene for ATV Applications

### Barrel Temperatures

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<th>C4</th>
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<tbody>
<tr>
<td>Nozzle</td>
<td>420°F / 210°C</td>
<td>390°F / 200°C</td>
<td>355°F / 180°C</td>
<td>340°F / 170°C</td>
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<tr>
<td>400°F / 200°C</td>
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For hard 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.

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