UBE 32
START-UP RECOMMENDATIONS

TPO

| Barrel Temperatures |  
|---------------------|-------------------|
| **Nozzle**          | **C4** | **C3** | **C2** | **C1** |
| 400° F / 205° C     | 420° F / 215° C  | 400° F / 205° C | 390° F / 199° C | 375° F / 190° 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.*