

# X405C

## START-UP RECOMMENDATIONS

### High Modulus Bumper Grade TPO

#### Barrel Temperatures

Nozzle	C4	C3	C2	C1
400° F / 200° C	420° F / 210° C	390° F / 200° C	355° F / 180° C	340° F / 170° 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 365° F to 440° F.

#### Mold Temperature

Typically 80° to 110° F.

#### 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.

#### Drying

Material should be dried for a minimum of 2 hours and a maximum of 4 hours at 82°C (180°F).

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

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