ZS609
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° 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.