

FH-120M

START-UP RECOMMENDATIONS

Metallic High Modulus Bumper Grade TPO

Barrel Temperatures

Nozzle	C4	C3	C2	C1
420° F / 215° C	450° F / 230° C	430° F / 220° C	400° F / 205° C	370° 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 390° 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

Medium to fast speed.

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 180° F (82° C).

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