Advanced Composites, Inc.
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FH-120M SR

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
Minimum "A" surface steel temperature 120º F to 140º F (49º C to 60º 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
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.