Advanced Composites, Inc.
1062 Fourth Avenue Sidney, Ohio 45365 Phone: (937)492-9187 Fax: (937)498-4837

ADX-5007

PROCESS/START-UP RECOMMENDATIONS

Filled Polypropylene

Barrel Temperatures

Nozzle	C4	C3	C2	C1
410º F / 210º C	420º F / 215º C	420º F / 215º C	410º F / 210º C	380º F / 193º C

For harder to fill parts temperatures may have to be increased. Keep lower temperatures in the rear zones to allow venting through the hopper.

Melt Temperature
Maximum temperature with a hand pyrometer should be 390º F to 480º F (198º C to 248º C).

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

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 0.25"-0.50" (6-12mm) 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 212º F (100º C).