

ADX-5034

START-UP RECOMMENDATIONS

Rubber & Talc Modified Polypropylene

Barrel Temperatures

Nozzle	C4	C3	C2	C1
410° F / 210° C	430° F / 220° C	410° F / 210° C	390° F / 200° C	375° 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 380° F to 440° F (193° C to 227° C).

Mold Temperature

Typically 80° to 100° F (27° C to 38° 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 10-20mm 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 212° F (100° C).

Other

Advanced Composites will not be held responsible for the result of the use of any injection molding process enhancers, flow enhancers or regrind used with Advanced Composites compounded PP material.

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