

ATX936

PROCESS/START-UP RECOMMENDATIONS

Filled Polypropylene

Barrel Temperatures

Nozzle	C4	C3	C2	C1
392° F / 200° C	392° F / 200° C	392° F / 200° C	374° F / 190° C	356° F / 180° 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 374° F to 410° F (190° C to 210° C).

Mold Temperature

Typically 104° F to 140° F (40° C to 60° 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).

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