

C-20T

START-UP RECOMMENDATIONS

Glass Filled PP

Barrel Temperatures

Nozzle	C4	C3	C2	C1
410° F / 210° C	430° F / 220° C	420° F / 215° C	400° F / 205° C	380° F / 195° C

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

Actual Processing Temperature Range

Maximum temperature with a hand pyrometer should be 400° F to 470° F (204° C to 243° C).

Mold Temperature

Typically 110° to 130° F (43° C to 54° C). If mold temperature is too low the surface of the part will be rough and wavy.

Injection Pressure

The preferred range is 40 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 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 212° F (100° C).

Note: Barrel and hot runner needs to be thoroughly purged with a low MFR material.

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