

FSR-139

START-UP RECOMMENDATIONS

Rubber Modified High Impact PP

Barrel Temperatures

Nozzle	C4	C3	C2	C1
390° F / 200° C	410° F / 210° C	390° F / 200° C	375° F / 190° C	355° F / 180° 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 370° F to 420° F (188° C to 216° 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).

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