Advanced Composites, Inc.
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X660U

PROCESS/START-UP RECOMMENDATIONS

Bumper Grade TPO

Barrel Temperatures

Nozzle	C4	C3	C2	C1
400° F / 200° C	420° F / 210° C	390° F / 200° C	355° F / 180° C	340° F / 170° 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 365° F to 446° F (185º C to 230º C).

Mold Temperature
Typically 80º F to 120º F (27º C to 49º 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 180° F (82° C).