EBP-15 SRC2
START-UP RECOMMENDATIONS

Polypropylene

<table>
<thead>
<tr>
<th>Barrel Temperatures</th>
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</thead>
<tbody>
<tr>
<td>Nozzle</td>
<td>C4</td>
<td>C3</td>
<td>C2</td>
<td>C1</td>
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<tr>
<td>375°F / 190°C</td>
<td>390°F / 200°C</td>
<td>375°F / 190°C</td>
<td>355°F / 180°C</td>
<td>340°F / 170°C</td>
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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.

Mold Temperature
Typically 80°F to 110°F.

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).

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