EBP-15 SRC3
START-UP RECOMMENDATIONS

Polypropylene

<table>
<thead>
<tr>
<th>Barrel Temperatures</th>
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<td><strong>Nozzle</strong></td>
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<td>375° F / 190° 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° 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.