

Ejector

- Put the operation mode selector switch into position **Setting**
- Open V26
- Activate key **Ejector forward** for about 30 seconds
- Close V26
- Open V25
- Activate key **Ejector return** and move the ejector into the rear rest position
- Close V25
- Repeat procedure.

1**Injection cylinder**

In order to assure a precise regulation of the injection process, the injection cylinder must be vented via the bleeder valves V27 and V28 mounted on the cylinder. For collecting the hydraulic oil which flows from the bleeder valve, a short hose piece must be placed over the bleeder valve and a receptacle must be available.

**Injection cylinder
area**

- Heat the screw cylinder to the operating temperature
- Put operation mode selector switch into position **Manual**
- Open slowly the bleeder valve V27
- Activate the key **Injection**
- Close the bleeder valve V27
- Repeat process until bubble-free oil flows out.

**Screw suck back
area**

- Heat the screw cylinder to the operating temperature
- Put the operation mode selector switch into position **Setting**
- Enter value 1 into line 49.15
- Open slowly the bleeder valve V28
- Activate key **Plasticising** until bubbly-free oil flows out
- Close the bleeder valve V28
- Enter value 0 into line 49.15