**Operational Steps**

1. Power on the machine from the panel and turn the power knob to on position.
2. Observe the condition of the rolls and clean them if necessary.
3. Check the tray beneath the rolls and clean it if required.
4. Check the temperatures on the temperature displays and adjust them to the desired value. For PVC, the temperatures are 110ᵒC on front roll and 90ᵒC on rear roll. For EVA, it is 80ᵒC on front roll and 50ᵒC on the rear roll. The temperatures can be varied slightly according to the requirement.
5. To adjust the temperature, press the mod switch on the controller. It will activate the adjustment mode and right most digit of the display will start to flicker. Use the left arrow to switch between the digits and the up and down arrows to change the selected digit. The adjustment mode is automatically turned off if no key is pressed for a few seconds.
6. Turn the heaters on with the respective switches.
7. Allow the rolls to heat up to the desired temperature.
8. Adjust the nip gap between the rolls to a low setting so that the material does not fall down when added over the rolls.
9. Check that the tray is properly placed below the rolls.
10. Add the pre weighed base material on the rolls.
11. Switch on the rolls with the designated button. They will start to rotate towards each other and begin to press the material into a sheet.
12. If some of the material falls down the rolls into the tray, collect it and add it again on the rolls.
13. Do not let the sheet reach up to the edge of the roll. If sheet is too wide, increase the nip gap slightly and scrap off the excess material with the help of a scrapper. Add the scrapped material at the center of the rolls. Repeat till desired width is attained.
14. Add colorant or any other additive on the sheet in pre-weighted amount. For this, a small portion of sheet may be scrapped off the roll and the material can be weighed on it to avoid wastage of weighted material and thus error in calculation.

Mix the colorant or other additive added thoroughly with the help of a scrapper. Alternately, the sheet can be removed from the roll, folded together and added back to the rolls. However, if this method is applied, the gap size has to be re-adjusted.

**Precautions:**

Do not touch rolls during operation

Clean the machine after it cools down