

ASACLEAN™ MECHANICAL GRADE PURGING INSTRUCTIONS for INJECTION MOLDING

1. Check that all zones are in the proper temperature range for the grade of ASACLEAN being used.
 2. Retract the injection unit. Empty screw and barrel. Clean hopper and feed throat.
 3. Feed 1-2 barrel capacities of ASACLEAN into the feed throat.
 4. With the screw completely forward, increase the backpressure to the maximum level.
 5. After ASACLEAN begins coming from the nozzle, increase the screw speed to the maximum safe level.
 6. Drop the backpressure after the ASACLEAN coming from the nozzle is almost clean.
 7. Retract the screw and perform short, high-velocity injection shots.
 8. Repeat steps 3-7 if contaminants are still visible.
 9. Displace the ASACLEAN remaining in the machine with the next resin, again, at the maximum backpressure and maximum safe screw speed with the screw completely forward.
- **ASACLEAN mechanical grades do not depend on chemical reactions. No soak time is required for an effective purge.**
 - **For maximum performance, ASACLEAN should not be diluted with other materials.**
 - **Do not use EX, PX2, or NF glass-filled grades for hot runner cleaning.**

Temperature Ranges:

<u>Grade</u>	<u>°C</u>	<u>°F</u>	<u>Grade</u>	<u>°C</u>	<u>°F</u>
U	180-330	355-625*	E	160-300	320-570
EX	200-330	390-625*	PF	280-420	535-790
UP	170-300	340-570	PX2	280-420	535-790
HP	170-300	340-570	NC	180-330	355-625
SX	300-370	570-700	NF	180-330	355-625*
NH	180-330	355-625*	NB	180-330	355-625

*If processing between 330°C-360°C(625°F-680°F), local ventilation is required.

Tips to target specific areas of the molding machine

Nozzle or check ring hang-up - Color or carbon

Raise the temperature of the nozzle 20-30°C (35-55°F). If purging a heat sensitive resin, do not exceed the safe processing temperature of the material. Feed a small amount of ASACLEAN (less than half barrel capacity). Repeat short, high-velocity injections shots until clean.

Exercise proper safety precautions and use appropriate PPE.

Technical Questions?

To request detailed technical bulletins or technical support, contact us at Asahi Kasei Asaclean Americas Inc.

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