

ASACLEAN PURGING INSTRUCTIONS
for PRE-MAINTENANCE CLEANING
and SCREW PULL
- INJECTION

1. Purge following the standard ASACLEAN MECHANICAL GRADE PURGING INSTRUCTIONS for INJECTION MOLDING.
2. The screw and barrel should be purged with a melt temperature of 220-300°C (430-570°F). For resins processed below 220°C (430°F) use ASACLEAN U, UP, NF, NH, NB, NC, or E to remove the low temperature resin, then increase temperatures to 240-260°C (465-500°F), and proceed per the following steps.
3. After the Asaclean purgings appear clean, extrude the remaining Asaclean from the machine.
4. Turn off the heaters. If pulling the screw with ASACLEAN EX, it is important to first purge with production resin or an unfilled ASACLEAN grade.
5. Wait until the temperatures in the barrel drop to 220- 240°C, (430-460°F), then purge with ASACLEAN EX. Empty the barrel of ASACLEAN EX and pull the screw. Melt temperatures outside this range will result in more effort being required to pull the screw.
6. For unfilled grades of ASACLEAN the optimum temperature to pull the screw is 195-205°C (380-400°F).
7. Continue following approved breakdown procedure.

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.

Phone: (800) 787-4348 / (973)257-1999
Website: www.Asaclean.com

Fax: (973) 257-1011
E-mail: sales@Asaclean.com