

ASACLEAN™ PF GRADE PURGING INSTRUCTIONS

For Shutdown/Sealing/Start-up of High Heat Resins

(Above 370°C (700°F))

Shutdown & Seal

1. Upon completion of production, purge the machine with ASACLEAN PF Grade following the standard purging procedures.
2. Leave barrel full of ASACLEAN PF Grade and begin dropping the temperatures to below 370°C (700°F) under slow screw speed.

ASACLEAN PF Grade should not be left idle at temperatures above 370°C (700°F) for any period of time.

3. Once below 370°C (700°F), turn off the heats.

Start-up

1. Turn on and set the heaters at 370°C (700°F)
2. Wait until the temperature of ASACLEAN PF Grade is at 370°C (700°F). Allow adequate time for all of the ASACLEAN to plasticize, including material far from the thermocouple at the barrel wall. Extruder amps may spike if material is not completely plasticized.
3. For injection molding: Once at 370°C (700°F), add a fresh barrel capacity of ASACLEAN PF Grade and extrude through the barrel using moderate backpressure (enough to keep the screw forward) for injection molding.
For extrusion: Once at 370°C (700°F), add a fresh barrel capacity of PF and extrude the ASACLEAN PF Grade from the machine, emptying the barrel, as far as possible.
4. Feed the next resin into the hopper and leave barrel full of the next resin.
5. Set the heaters for the resin to be processed.
6. For injection molding: Once at the temperature to be processed, add a fresh barrel capacity of ASACLEAN PF Grade and extrude through the barrel using moderate backpressure (enough to keep the screw forward) for injection molding.
For extrusion: Once at the temperature to be processed, add a fresh barrel capacity of ASACLEAN PF Grade and extrude the ASACLEAN PF Grade from the machine, emptying the barrel, as far as possible.

ASACLEAN PF Grade should not be left idle at temperatures above 370°C (700°F) for any period of time.

7. Purge all of the PF from the extruder. If contaminated, repeat purging procedure with PF.
8. For injection molding: Use low back pressure and screw speed until the next resin starts coming out from the nozzle, then increase to moderate back pressure and moderate screw speed until all of the ASACLEAN PF Grade is displaced.
For extrusion: Use low screw speed until the next resin starts coming out from the die, then increase to moderate level until all of the ASACLEAN PF Grade is displaced. Begin production using the normal processing conditions for the next resin.

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