

# ASACLEAN™ NCT GRADE INJECTION MOLDING PURGING INSTRUCTIONS

**For High Heat Resins 175°C – 360°C (345°F – 680°F)**

**Note: This grade is NOT recommended for hot runner purging.**

1. Retract screw and barrel from the mold. Empty the system of the production resin, and make sure the feed areas are clean.
2. Flush the machine with 1-4-barrel volumes of HMW-HDPE.
3. Empty screw and barrel.
4. Add ASACLEAN NCT at normal screw speed until the purge extrudes from the nozzle.
5. Continue to extrude at minimum controllable RPM for a 10 – 20 minute heat soak. ASACLEAN NCT is heat activated, so expansion will occur during the heat soak (if sealing, turn off all heaters with the system full of ASACLEAN NCT).

**If transitioning to a resin with a lower processing temperature, please stay at initial operating conditions until the system is clean.**

6. Empty screw and barrel at normal screw speed. If contamination is observed as the last of the ASACLEAN NCT exits the machine, repeat steps 4-6.
7. Change temperatures for next resin.
8. When safe, displace the ASACLEAN NCT with the next resin.
9. Begin production under normal processing conditions.

## **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](http://www.asaclean.com)

Fax: (973) 257-1011

E-mail: [sales@asaclean.com](mailto:sales@asaclean.com)