



Don't just purge... *Ultra Purge!*^(TM)

Technical Data Sheet

Ultra Purge CE-E

Concentrated chemical purging compound
Before usage mix at 10% with 90% of unfilled resin

Please read carefully TDS-SDS before using Ultra Purge

Working temp range	Works with	Applications	Designed for
from 140°C / 284°F to 260°C / 500°F	PP, PE, HDPE, LDPE, LLDPE, TPO, TPR, EVA...	Blow Molding with accumulator Blow Molding without accumulator Blow film	Color Changes Material Changes Carbon Build Up Shut-Downs

Produced By

MOULDS PLUS
INTERNATIONAL



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Blow Molding with accumulator

This document is a general description on how to use Ultra Purge. Request your customized instructions by contacting your nearest sales office or local distributor.

- Before starting the purging process, if possible, increase the accumulator temperature of at least 30°C / 50°F. Prepare the Ultra Purge mixture.
- The amount of Ultra Purge mixture required (kg or lb) equals 7 times the accumulator capacity - e.g. 4L (or lb) accu. needs 28kg (or lb) of mixture composed by 1 part Ultra Purge (2.8kg or lb) and 9 parts raw HDPE (25.2kg or lb).
- As soon as Ultra Purge is loaded in the machine, set the temperature of the accumulator back to normal production parameters.

Please notice that on large machines it usually takes more than 1 hour for the temperature to decrease.

- Load Ultra Purge mixture and make shots until Ultra Purge is ejected from the die.
- Reduce the thickness of the parison and adjust accumulator shot size to the maximum allowed settings.
- Let Ultra Purge soak in the barrel and accumulator for 5-10 minutes.
- Add the next production resin directly after Ultra Purge.
- After 4-5 shots with thin parison, increase the parison thickness and make full shots with the production resin to flush away contamination.
- Set all the parameters to production settings. If contamination persists repeat steps.

Special notes:

TDS-Ultra_Purge_CE-E_rev1_ENG

- Do not use higher mixing ratio on concentrated grades than what recommended.
- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
- Do not allow a longer soak time than what suggested.
- Do not use more than recommended quantities of Ultra Purge per cleaning.
- Do not increase temperatures if dealing with thermo sensitive resins or additives.
- Do not mold difficult to eject parts - when molding Ultra Purge you may get a short shot.
- Do not use Ultra Purge outside its working temperature range.



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Blow molding with accumulator - SHUT DOWN/START-UP

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SHUT DOWN

- Prepare and add Ultra Purge mixture. Make shots until Ultra Purge is ejected from the die.
- Reduce the thickness of the parison and adjust accumulator shot size to the maximum allowed settings.
- After 4-5 shots with thin parison, increase the parison thickness and empty the system completely. **DO NOT ADD RESIN AFTER ULTRA PURGE!**
- Turn off the machine completely (do not leave heaters in "Maintenance/Idle" mode).

START-UP (Turn on the machine to production settings)

- Load Ultra Purge mixture until it is ejected from the die. Reduce the thickness of the parison and adjust accumulator shot size to the maximum allowed settings.
- Let Ultra Purge soak in the barrel and accumulator for 5-10 minutes.
- After 4-5 shots with thin parison, increase the parison thickness and make full shots with the production resin to flush away contamination.
- Begin normal production, if contamination persists follow the standard cleaning procedure. It is normal to see contamination being flushed out on startup.

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- Do not use more than recommended quantities of Ultra Purge per cleaning.
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Blow Molding without accumulator

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- We recommend keeping the barrel full of resin when adding Ultra Purge mixture in the machine.

- In case of difficult color changes and black specks removal increase the head temperatures of about 30°C / 50°F. For easy color changes and thermo-sensitive material DO NOT increase the temperatures.

- Add Ultra Purge mixture (roughly 1.5 times the barrel capacity).

- If a screen pack is present, please remove it from the machine.

- If present, open the purging valve located on top of the head to allow the resin to be flushed out during the purging process.

- When Ultra Purge is ejected from the die let it soak in the barrel for 5-10 minutes. Add the next production resin directly after Ultra Purge.

- Increase and decrease alternatively the parison thickness (if possible) to flush away contamination.

- Set all the parameters to production settings. If contamination persists repeat steps.

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 - Do not allow a longer soak time than what suggested.
 - Do not use more than recommended quantities of Ultra Purge per cleaning.
 - Do not increase temperatures if dealing with thermo sensitive resins or additives.
 - Do not mold difficult to eject parts - when molding Ultra Purge you may get a short shot.
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Blow molding without accumulator - SHUT DOWN/START-UP

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SHUT DOWN

- Prepare the Ultra Purge mixture.
- When all production resin has been used up, load 50% barrel volume capacity of Ultra Purge mixture. Extrude at slow screw rotation speed until the barrel is completely empty.
- If a screen pack is present, please remove it from the machine.
- If present open the purging valve located on top of the head to allow the resin to be flushed out during the purging process.
- Turn off the machine completely (do not leave heaters in "Maintenance/Idle" mode).

START-UP (Turn on the machine to production settings)

- Load Ultra Purge mixture, at slow screw rotations speed, until it is ejected from the die. Allow Ultra Purge to pass through the barrel in 5-10 min.
- Add the next production resin directly after Ultra Purge and begin normal production.
- If contamination persists, follow the standard cleaning procedure. It is normal to see contamination being flushed out on startup.

Special notes:

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- Do not allow a longer soak time than what suggested.
- Do not use more than recommended quantities of Ultra Purge per cleaning.
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Extrusion - BLOW FILM (Single layer)

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- Before starting the purging process, increase the die temperature by 30°C / 50°F.

 - Manually remove all contaminations from the feeding area.

 - We recommend keeping the barrel full of resin when adding Ultra Purge mixture in the machine.

 - Prepare and add Ultra Purge mixture, the amount of mixture required for purging equals to 1/4 of the maximum hourly machine throughput.

 - Reduce the screw rotation speed in order to allow Ultra Purge to pass through the barrel in 5-10 minutes. If necessary, in order to keep safe barrel pressure, remove the finest layer from the screen pack.

 - Load the next production resin directly after Ultra Purge.

 - When Ultra Purge starts to be ejected, increase the screw rotation to maximum safe speed to flush out all contaminations.

 - Set all the parameters to production settings and begin normal production.

 - If contamination persists repeat steps.

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Blow Film - SHUT DOWN/START-UP

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SHUT-DOWN

- We recommend keeping the barrel full of resin when adding Ultra Purge mixture in the machine.
- Manually remove all contaminations from the feeding area.
- Prepare and add Ultra Purge mixture. The amount of mixture required for the purging process equals 50% of the system volume capacity (barrel+head).
- Purge out until the barrel is completely empty. **DO NOT ADD RESIN AFTER ULTRA PURGE!**
If necessary, in order to keep safe barrel pressure, remove the finest layer from the screen pack.
- Turn off the machine completely (do not leave heaters in "Maintenance/Idle" mode).

START-UP (Turn on the machine to production settings)

- Prepare and add Ultra Purge mixture, the amount of mixture required for the purging process equals 50% of the system volume capacity (barrel+head). Load the next production resin directly after Ultra Purge.
- Reduce the screw rotation speed. When Ultra Purge starts to be ejected, increase the screw rotation to the maximum safe speed to flush out all contaminations.
- Set all the parameters to production settings and begin normal production.
- If contamination persists follow the standard cleaning procedure. It is normal to see contamination being flushed out on startup. Good parts should be running shortly.

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- Do not use more than recommended quantities of Ultra Purge per cleaning.
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