



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

Technical Data Sheet

Ultra Purge PET-E

Ready-to-use chemical purging compound

Please read carefully TDS-SDS before using Ultra Purge

Working temp range	Works with	Applications	Designed for
from 190°C / 374°F to 320°C / 608°F	PET	Sheet Extrusion Blow Molding without accumulator	Color Changes Material Changes Carbon Build Up Shut-Downs

Produced By

MOULDS PLUS
INTERNATIONAL


 ULTRA
 PURGE

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 PET

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Extrusion - SHEET

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, decrease the temps in the head middle area (-20°C/-40°F) and increase the temps on the sides (+20°C/+40°F).
- Manually remove all contaminations from the feeding area.
- **We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.**
- Add Ultra Purge, the amount required for the purging process equals 1 full system capacity (barrel + head).
- 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 the maximum safe speed to flush out all contaminations.
- Set all the parameters to production settings and begin normal production.
- If contamination persists repeat steps.

Special notes:

TDS-Ultra_Purge_PET-E_rev1_ENG

- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
- 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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Sheet Extrusion - SHUT DOWN/START-UP

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SHUT-DOWN

- We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.
- Manually remove all contaminations from the feeding area.
- Add Ultra Purge. The amount of Ultra Purge 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)

- Add Ultra Purge. The amount of Ultra Purge 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.

Special notes:

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- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
- 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 without accumulator

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

- Add Ultra Purge (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, 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.

Special notes:

TDS-Ultra_Purge_PET-E_rev1_ENG

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- 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 without accumulator - SHUT DOWN/START-UP

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SHUT DOWN

- When all production resin has been used up, load 50% barrel volume capacity of Ultra Purge. 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, at slow screw rotations speed, until it is ejected from the die.
- 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:

TDS-Ultra_Purge_PET-E_rev1_ENG

- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
- 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.