



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

Technical Data Sheet

Ultra Purge PMMA

Ready-to-use chemical purging compound

Please read carefully TDS-SDS before using Ultra Purge

| Working temp range | Works with | Applications | Designed for |
|--|--|--|--|
| from 200°C / 392°F to 280°C / 536°F | When switching from any resin to PMMA | Injection Molding Hot Runners Extrusion Sheet Extrusion | Color Changes Material Changes Carbon Build Up |

Produced By

MOULDS PLUS
INTERNATIONAL



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to 280°C / 536°F

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Injection molding – SCREW-BARREL – Material change/Mold change

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.

- **Move the injection unit to the back position and empty the barrel.**

- Manually remove all possible contaminants in the hopper/mixer/filters...

- Add Ultra Purge (1 barrel capacity).

Do not load Ultra Purge PMMA at a temperature higher than 280°C/536°F.

- Make shots at production shot size until the barrel is completely empty from Ultra Purge.
- If you have to perform a mold change, set the temperature of the barrel to “Maintenance/Idle” at a temp of 120°C/248°F and perform the mold change with barrel empty.
- When ready to start-up, set the barrel temperature to production settings and add 1 barrel capacity of Ultra Purge.
- When the Ultra Purge is ejected from the nozzle, allow for a 3 minutes soak time for best performance.
- Add the next production resin directly after Ultra Purge and make injections until Ultra Purge is completely displaced from the machine.
- Make 4-5 injections with the next resin to complete the purge and begin normal production.
- If contamination persists repeat steps.

Special notes:

TDS-Ultra_Purge_PMMA_rev2_ENG

- 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 use Ultra Purge outside its working temperature range.


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Injection molding – SCREW-BARREL – Color change

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- **Move the injection unit to the back position and empty the barrel.**
 - Manually remove all possible contamination sources in the hopper/mixer/filters...
 - Add Ultra Purge (1 barrel capacity).
 - Make shots until you see Ultra Purge being ejected through the nozzle.
 - Allow for a 3 minutes soak time for best performance.
 - Add the next production resin/color directly after Ultra Purge and make injections until Ultra Purge is completely displaced from the machine.
 - Make 4-5 injections with the next resin to complete the purge and begin normal production.
 - If contamination persists repeat steps.

NOTES - The same procedure can be applied also for START-UP. If during a color change is necessary to change the mold, follow the procedure "Injection molding - SCREW-BARREL - Material change/Mold change".

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Injection molding – Hot runners – MOLD OPEN

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.

- Purge the injection unit using the "Injection Molding - SCREW-BARREL - Color change" procedures.

- Protect the ejection side of the mold with cardboard or a metal cover.

- Add half barrel of Ultra Purge directly after the next production resin and purge through the hot runners with the mold open.

- Once Ultra Purge is been used up, load the next production resin and make shots until all remnants of Ultra Purge have been displaced from the machine.

- Make 4-5 injections of the next resin and set all parameters to production settings.

- Begin normal production.

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Extrusion

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.

- **Empty the barrel before start purging.**
- Add Ultra Purge (approximately 1.5 times the extruder barrel capacity).
- Extrude at low speed until Ultra Purge being ejected from the machine.
- If extruder pressure builds up after loading Ultra Purge, remove the screen pack.
- Add the next production resin directly after Ultra Purge.

(In case of material change with different working temperature, set the temperatures to the next production resin)

- Extrude the next production resin at higher speed to flush out all remnants of Ultra Purge. If possible, replace the screen pack.
- If contamination persists repeat steps.

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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).
- **Empty the barrel before start purging.**
- Add Ultra Purge (approximately 1.5 times the extruder barrel capacity).
- Extrude at low speed until Ultra Purge is ejected from the machine.
- If extruder pressure builds up after loading Ultra Purge, remove the screen pack.
- Add the next production resin directly after Ultra Purge.

(In case of material change with different working temperature, set the temperatures to the next production resin)

- Extrude the next production resin at higher speed to flush out all remnants of Ultra Purge. If possible, replace the screen pack.
- If contamination persists repeat steps.

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