



Don't just purge...*ULTRA PURGE!*<sup>TM</sup>

## Ultra Purge

Ready-to-use chemical purging compound

Please read carefully TDS-SDS before using Ultra Purge. If you don't have this document, you can download it from [ultrapurge.com](http://ultrapurge.com)

### 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.*

- 1 Before starting the purging process, increase the accumulator temperature of at least 40°C (70°F).
- 2 The amount of Ultra Purge required (kg) equals 7 times accumulator capacity (e.g. 4L accu. needs 28kg of Ultra Purge ready to use)
- 3 The amount of Ultra Purge required (lb) equals 7 times accumulator capacity (e.g. 4lb accu. needs 28lb of Ultra Purge ready to use)
- 4 As soon as Ultra Purge is loaded in the machine, set the temperature to normal production parameters.
- 5 Please notice that on large machines it usually takes more than 1 hour for the temperature to decrease.
- 6 Keep the barrel full of resin when adding Ultra Purge to the machine.
- 7 Load Ultra Purge and make shots until you see it being ejected from the machine.
- 8 Reduce the thickness of the parison and adjust accumulator shot size to the maximum value.
- 9 Let Ultra Purge soak in the barrel and accumulator for 5-10 minutes. Add the next production resin directly after Ultra Purge.
- 10 Increase the parison thickness and make full shots with the production resin to flush away contamination.
- 11 Set all the parameters to production settings. If contamination persists repeat steps.

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#### Things to avoid with Ultra Purge :

- Load our product through heated feed line - Ultra Purge starts to melt at 80°C (176°F).
- Allow longer soaking time from what suggested.
- Use more than recommended quantities of Ultra Purge per cleaning.
- Increase temperatures if dealing with thermo sensitive resins or additives.