



Don't just purge...*ULTRA PURGE!*TM

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

Injection molding - High Temp - material change (different temperature)

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 Keep the barrel full of the previous production resin.
- 2 Add Ultra Purge using a quantity equivalent to 2 times the barrel capacity.
- 3 Flush the machine empty and adjust the temps for the next material.
- 4 Once the temps are at your new desired production settings, load 1 barrel capacity of Ultra Purge followed by your production resin.
- 5 If contamination from a high temp material still persists; load 1 barrel capacity of Ultra Purge and make shots till machine is empty.
- 6 Raise temps back up and repeat steps 2, 3, 4.

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.
- Mould items that have a difficult ejection – the piece can be partially formed.

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