



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)

### Injection molding - SHUT DOWN/RESTART

*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 \*\*\* SHUT DOWN \*\*\*
- 2 Keep the barrel full of resin when adding Ultra Purge to the press.
- 3 Add half barrel capacity of Ultra Purge .
- 4 Reduce the shot size and make short shots until the barrel is completely empty. DO NOT ADD RESIN AFTER ULTRA PURGE!
- 5 Turn off the machine completely (do not leave heaters in "maintenance" mode).
- 6 \*\*\* RESTART \*\*\*
- 7 Turn machine on to production settings and load half barrel capacity of Ultra Purge followed by your production resin and begin normal production.
- 8 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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#### 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.