



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

Blow molding without 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 Keep the barrel full of resin when adding Ultra Purge to the machine.
- 2 In case of difficult color changes increase the accumulator/head temperatures of about 40°C (70°F).
- 3 Add Ultra Purge (the amount of ready to use Ultra Purge to add is roughly 1.5 times the barrel capacity).
- 4 If a screen pack is present, please remove it from the machine.
- 5 If present open the purging valve located on top of the head to allow the resin to be flushed out during the purging process.
- 6 When Ultra Purge is ejected from the head let it soak in the barrel for 5-10 minutes. Add the next production resin directly after Ultra Purge.
- 7 Increase and decrease alternatively the parison thickness (if possible) to flush away contamination.
- 8 Set all the parameters to production settings. If contamination persists repeat steps.

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.