



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 - 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.

- 1 Keep the barrel full of resin when adding Ultra Purge to the press.
- 2 Increase hot runner temperatures (tips and manifold) and nozzle by 40°C (70°F).
- 3 Manually remove all possible contamination sources in the hopper/mixer/filters...
- 4 Add Ultra Purge (1 barrel capacity).
- 5 With mold open make shots until you see Ultra Purge being ejected through the hot runners (Ultra Purge will look white and foamy).
- 6 For machines larger than 200 ton reduce the shot size to 10% of the maximum allowed shot size.
- 7 Allow for a 4 minute soak. Add the next production resin directly after Ultra Purge.
- 8 Continue making short shots with Ultra Purge.
- 9 Make 4-5 shots of the next resin to complete the purge. Set all the parameters to production settings.
- 10 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.
- Mould items that have a difficult ejection – the piece can be partially formed.