



Standard Operating Procedure for Injection Moulding

Ultra Purge™ 5150

Ready-To-Use Purging Compound with Ultra-X™

Cleaning of Screw and Barrel - Injection Molding:

1. Move the injection unit to the back position. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
2. Manually remove all possible contamination sources in the hopper/mixer/filters.
3. Add Ultra Purge™ (1-barrel capacity).
4. Make injections until you see Ultra Purge™ being ejected through the nozzle.
5. For machines larger than 500 tons, we recommend reducing the shot size to 20% of the maximum allowed shot size.
6. For best performance, we recommend a 3-minute soak time.
7. Add the next production resin/color directly after Ultra Purge™ and make injections until Ultra Purge™ is displaced from the machine. (In case of material change with different working temperatures, empty the barrel from Ultra Purge™ before adding the next production resin and set the temperatures to the next production settings)
8. Make 4-5 injections with the next resin to completely displace Ultra Purge™.
9. If contamination persists, repeat steps.

Cleaning of Hot-Runner System - Mold Open - Injection Molding:

1. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
2. We recommend increasing hot-runner temperatures (tips and manifold), if possible, and nozzle by 30°C/54°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 injections until you see Ultra Purge™ being ejected through the hot-runners.
6. For machines larger than 500 tons, we recommend reducing the shot size to 20% of the maximum allowed shot size.
7. For best performance, we recommend a 3-minute soak time. Add the next production resin directly after Ultra Purge™.
8. Continue making injections with Ultra Purge™.

9. Make 4-5 injections with the next resin to completely displace Ultra Purge™. Set all the parameters to the next production settings.
10. If contamination persists, repeat steps.

Cleaning of Hot-Runner System - Mold Closed – Injection Molding:

1. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
2. If possible, we recommend increasing hot-runner temperatures (tips and manifold) by 30°C/54°F.
3. Manually remove all possible contamination sources in the hopper/mixer/filters.
4. Add Ultra Purge™ (1-barrel capacity) and mold parts until 100% Ultra Purge™ is molded into parts.
5. Add the next production resin directly after Ultra Purge™.
6. Continue molding parts out of the Ultra Purge™.
7. Make 4-5 cycles with the next resin to completely displace Ultra Purge™. Set all the parameters to the next production settings.
8. If contamination persists, repeat steps.

Cleaning for Shut-Down and Start-Up – Injection Molding:

SHUT DOWN

1. Move the injection unit to the back position. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
2. Add half barrel capacity of Ultra Purge™.
3. Reduce the shot size and make injections until the barrel is completely empty. **DO NOT ADD RESIN AFTER ULTRA PURGE™!**
4. Turn off the machine completely (do not leave heaters in “Maintenance/Idle” mode).

START-UP

1. Turn on the machines to production settings, load half barrel capacity of Ultra Purge™ followed by your production resin and begin normal production.
2. If contamination persists, follow the standard cleaning procedure. It is normal to see contamination being flushed out on start-up.