



Don't just purge... *Ultra Purge!*<sup>(TM)</sup>

## Technical Data Sheet

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# Ultra Purge HIGH-E

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Ready-to-use chemical purging compound

**Please read carefully TDS-SDS before using Ultra Purge**

Working temp range	Works with	Applications	Designed for
from 190°C / 374°F  to 320°C / 608°F	<b>ABS, ASA, PA, GPPS, HIPS, PC, SAN, PBT, PET...</b>	Injection Molding  Hot Runners  Extrusion  Sheet Extrusion	Color Changes  Material Changes  Carbon Build Up  Shut-Downs

Produced By

**MOULDS PLUS**  
INTERNATIONAL


 ULTRA  
 PURGE

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## Ultra Purge HIGH-E

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Working temp range

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### Injection molding - SCREW-BARREL

*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.*

- **Move the injection unit to the back position. We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.**
- Manually remove all possible contamination sources in the hopper/mixer/filters...
- Add Ultra Purge (1 barrel capacity).
- Make shots until you see Ultra Purge being ejected through the nozzle (Ultra Purge will look white and foamy).
- For machines larger than 500 ton we recommend reducing the shot size to 20% of the maximum allowed shot size.
- 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 temperature, empty the barrel from the Ultra Purge before adding the next production resin and set the temperatures to production settings).*

- Make 4-5 shots with the next resin to complete the purge.
- If contamination persists repeat steps.

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#### Special notes:

TDS-Ultra\_Purge\_HIGH-E\_rev1\_ENG

- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
- Do not use more than recommended quantities of Ultra Purge per cleaning.
- Do not increase temperatures if dealing with thermo sensitive resins or additives.
- Do not mold difficult to eject parts - when molding Ultra Purge you may get a short shot.
- Do not use Ultra Purge outside its working temperature range.


 ULTRA  
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### Injection molding - Hot runners - MOLD OPEN

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- **We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.**
  
- We recommend increasing hot runner temperatures (tips and manifold), if possible, and nozzle by 30°C / 50°F.
  
- Manually remove all possible contamination sources in the hopper/mixer/filters...
  
- Add Ultra Purge (1 barrel capacity).
  
- With mold open make shots until you see Ultra Purge being ejected through the hot runners (Ultra Purge will look white and foamy).
  
- For machines larger than 500 ton we recommend reducing the shot size to 20% of the maximum allowed shot size.
  
- Add the next production resin directly after Ultra Purge.
  
- Continue making shots with Ultra Purge.
  
- Make 4-5 shots of the next resin to complete the purge. Set all the parameters to production settings.
  
- If contamination persists repeat steps.

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**Special notes:**

TDS-Ultra\_Purge\_HIGH-E\_rev1\_ENG

- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
  - Do not use more than recommended quantities of Ultra Purge per cleaning.
  - Do not increase temperatures if dealing with thermo sensitive resins or additives.
  - Do not mold difficult to eject parts - when molding Ultra Purge you may get a short shot.
  - Do not use Ultra Purge outside its working temperature range.
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### Injection molding - Hot runners - MOLD CLOSED

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- **We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.**
  
- If possible, we recommend increasing hot runner temperatures (tips and manifold) by 30°C / 50°F.
  
- Manually remove all possible contamination sources in the hopper/mixer/filters...
  
- Add Ultra Purge (1 barrel capacity) and mold parts until Ultra Purge 100% molded in to part.
  
- Add the next production resin directly after Ultra Purge.
  
- Continue molding parts out of the Ultra Purge.
  
- Make 4-5 cycles with the next resin to complete the purge. Set all the parameters to production settings.
  
- If contamination persists repeat steps.

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#### Special notes:

TDS-Ultra\_Purge\_HIGH-E\_rev1\_ENG

- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
- Do not use more than recommended quantities of Ultra Purge per cleaning.
- Do not increase temperatures if dealing with thermo sensitive resins or additives.
- Do not mold difficult to eject parts - when molding Ultra Purge you may get a short shot.
- Do not use Ultra Purge outside its working temperature range.


 ULTRA  
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### Injection molding - SHUT DOWN/START-UP

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#### SHUT DOWN

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

#### START-UP

- Turn on the machines to production settings, load half barrel capacity of Ultra Purge followed by your production resin and begin normal production.
- 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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#### **Special notes:**

TDS-Ultra\_Purge\_HIGH-E\_rev1\_ENG

- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
- Do not use more than recommended quantities of Ultra Purge per cleaning.
- Do not increase temperatures if dealing with thermo sensitive resins or additives.
- Do not mold difficult to eject parts - when molding Ultra Purge you may get a short shot.
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### Extrusion

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- **We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.**
  
- Add Ultra Purge (approximately 1.5 times the extruder barrel capacity)
  
- Extrude at low speed until Ultra Purge being ejected from the machine.
  
- If extruder pressure builds up after loading Ultra Purge, remove the screen pack.
  
- Add the next production resin directly after Ultra Purge.

*(In case of material change with different working temperature, empty the barrel from the Ultra Purge before adding the next production resin and set the temperatures to production settings).*

- Extrude the next production resin at higher speed to flush away contamination. If possible, replace the screen pack.
  
- If contamination persists repeat steps.

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#### Special notes:

TDS-Ultra\_Purge\_HIGH-E\_rev1\_ENG

- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80°C / 176°F.
- Do not use more than recommended quantities of Ultra Purge per cleaning.
- Do not increase temperatures if dealing with thermo sensitive resins or additives.
- Do not mold difficult to eject parts - when molding Ultra Purge you may get a short shot.
- Do not use Ultra Purge outside its working temperature range.




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### Extrusion - SHUT DOWN/START-UP

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#### SHUT DOWN

- We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.
- Add Ultra Purge (1 barrel capacity).
- If extruder pressure builds up after loading Ultra Purge, remove the screen pack.
- Purge out until the barrel is completely empty. **DO NOT ADD RESIN AFTER ULTRA PURGE!**
- Turn off the machine completely (do not leave heaters in "Maintenance/Idle" mode).

#### START-UP

- Turn on the machines to production settings, load half barrel capacity of Ultra Purge followed by your production resin and begin normal production.
- If possible, replace the screenpack.
- 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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#### **Special notes:**

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### Extrusion - SHEET

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- Before starting the purging process, decrease the temps in the head middle area (-20°C/-40°F) and increase the temps on the sides (+20°C/+40°F).
- Manually remove all contaminations from the feeding area.
- **We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.**
- Add Ultra Purge, the amount required for the purging process equals 1 full system capacity (barrel + head).
- If necessary, in order to keep safe barrel pressure, remove the finest layer from the screen pack.
- Load the next production resin directly after Ultra Purge.
- When Ultra Purge starts to be ejected, increase the screw rotation to the maximum safe speed to flush out all contaminations.
- Set all the parameters to production settings and begin normal production.
- If contamination persists repeat steps.

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#### Special notes:

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### Sheet Extrusion - SHUT DOWN/START-UP

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#### **SHUT-DOWN**

- We recommend keeping the barrel full of resin when adding Ultra Purge in the machine.
- Manually remove all contaminations from the feeding area.
- Add Ultra Purge. The amount of Ultra Purge required for the purging process equals 50% of the system volume capacity (barrel+head).
- Purge out until the barrel is completely empty. **DO NOT ADD RESIN AFTER ULTRA PURGE!**  
If necessary, in order to keep safe barrel pressure, remove the finest layer from the screen pack.
- Turn off the machine completely (do not leave heaters in "Maintenance/Idle" mode).

#### **START-UP (Turn on the machine to production settings)**

- Add Ultra Purge. The amount of Ultra Purge required for the purging process equals 50% of the system volume capacity (barrel+head). Load the next production resin directly after Ultra Purge.
- Reduce the screw rotation speed. When Ultra Purge starts to be ejected, increase the screw rotation to the maximum safe speed to flush out all contaminations.
- Set all the parameters to production settings and begin normal production.
- If contamination persists follow the standard cleaning procedure. It is normal to see contamination being flushed out on startup.

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#### **Special notes:**

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