



Don't just purge... *Ultra Purge!*^(TM)

Technical Data Sheet

Ultra Purge HT

Ready-to-use glass filled purging compound

Please read carefully TDS-SDS before using Ultra Purge

Working temp range	Works with	Applications	Designed for
from 200°C / 392°F to 380°C / 716°F	PPS, PSU, PPO, GRIVORY HT...	Injection Molding Extrusion	Color Changes Material Changes Carbon Build Up Shut-Downs

Produced By

MOULDS PLUS
INTERNATIONAL


 ULTRA
 PURGE

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 Working temp range from 200°C / 392°F to 380°C / 716°F
 PPS, PSU, PPO, GRIVORY HT...

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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.
- Allow for a 3 minutes soak time if the temperature is lower than 290°C/554°F.
- 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.

Special notes:

TDS-Ultra_Purge_HT_rev2_ENG

- Do not use on mirror polished surfaces.
- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80 C / 176 F.
- Do not allow a longer soak time than what suggested.
- 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 - SHUT DOWN/START-UP (if the temperature is lower than 350°C/662°F)

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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.

Special notes:

TDS-Ultra_Purge_HT_rev2_ENG

- Do not use on mirror polished surfaces.
- 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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High Temp Injection molding - MATERIAL CHANGE (SAME temperature)

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 the previous production resin.**
- Add Ultra Purge using a quantity equivalent to 2 times the barrel capacity.
- Load next material directly behind Ultra Purge.
- Make shots until Ultra Purge is cleared from machine.
- Begin normal production.

Special notes:

TDS-Ultra_Purge_HT_rev2_ENG

- Do not use on mirror polished surfaces.
- 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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Working temp range

from 200°C / 392°F

to 380°C / 716°F

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High Temp Injection molding - MATERIAL CHANGE (DIFFERENT temperature)

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- **Move the injection unit to the back position. We recommend keeping the barrel full of the previous production resin.**
- Add Ultra Purge using a quantity equivalent to 2 times the barrel capacity.
- Flush the machine empty from the Ultra Purge and adjust the temps/settings to the NEXT PRODUCTION MATERIAL.
- Once the temperatures are at your new desired production settings, load 1 barrel capacity of Ultra Purge followed by your production resin.
- If contamination still persists; load 1 barrel capacity of Ultra Purge followed by production resin and start production.

Special notes:

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- Do not use on mirror polished surfaces.
- 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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High Temp Injection molding - SHUT DOWN/START-UP

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.

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 1 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 1 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.

Special notes:

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- Do not use on mirror polished surfaces.
- Do not load Ultra Purge through heated feeding line - Ultra Purge starts to melt at 80 C / 176 F.
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Extrusion

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.

- **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 production 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.

Special notes:

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- Do not use more than recommended quantities of Ultra Purge per cleaning.
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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.

Special notes:

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