



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

Technical Data Sheet

Ultra Purge LOW-E

Ready-to-use chemical purging compound

Please read carefully TDS-SDS before using Ultra Purge

Working temp range	Works with	Applications	Designed for
from 140°C / 284°F to 260°C / 500°F	PVC, EVA, TPE, POM, TPR, TPU...	Injection Molding Hot Runners Extrusion	Color Changes Material Changes Carbon Build Up Shut-Downs

Produced By

MOULDS PLUS
INTERNATIONAL


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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 for best performance.
- 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_LOW-E_rev1_ENG

- 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 - 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.

- **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.
- Allow for a 3 minutes soak time for best performance. 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.

Special notes:

TDS-Ultra_Purge_LOW-E_rev1_ENG

- 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 - 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.
- Let Ultra Purge soak for 3 minutes in hot runners and barrel for best performance. 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.

Special notes:

TDS-Ultra_Purge_LOW-E_rev1_ENG

- 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

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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:

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- 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.
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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 low speed until Ultra Purge being ejected from the machine.
- We recommend to let Ultra Purge soak in the barrel for 5 minutes. Allow for a 10 minutes soak time for difficult applications. 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 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.
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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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- 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.