

## Notes and Tips

### Changing from high temperature materials to lower

It is important to realise that when purging, molten material is always easier to remove than solid. For this reason when changing to a lower temperature polymer you should always purge the higher temperature material at the higher temperature first with Barrel Blitz Universal (BBU). If the higher temperature polymers processing temperature is above  $340^{\circ}\text{C}$  reduce the barrel temperatures to  $340^{\circ}\text{C}$  and then purge with BBU. You should then empty the barrel completely and reduce heats to the processing temperature of the lower following material. Then purge again with BBU at the lower temperature to clear any “sticky” BBU and ensure the equipment is fully clean.

### Causes of poor cleaning performance

#### Degraded material in the feed section of the screw

BBU is a mechanical cleaning purging compound, for this reason it will not clean the feed section of screws and barrels very effectively. The state of your feed section can be checked by looking down a cleaned hopper throat whilst doing suck back or decompression of the screw. To the full back position.

#### Worn screw or barrel




This is likely to have various effects on the moulding process; increased shear heat, increased screw back time, increased degradation and slower cycle time. It will also affect the performance of BBU which will no longer be self-emptying and may require additional quantity to clean due to poor compression (leakage) in the worn section.

#### Large nozzle orifice or mismatched endcap and screw tip geometry

As mentioned above, BBU cleans mechanically therefore a large nozzle or mismatch of the angles between the endcap and screw tip effectively reduces compression. This results in poor scrubbing efficiency. Also BBU then becomes more difficult to remove on certain materials such as PC, ABS, Amorphous Nylon etc.

All further details from the company.

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