

Injection Moulding Instructions Moulding through a Hot Runner (Basic Moulding Version)

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Grade Selection

Product	Instructions	Materials
Poly Clear Prime 100	<ul style="list-style-type: none"> - Basic - Comprehensive (M) - Comprehensive (O) - Decarbonisation 	<ul style="list-style-type: none"> - Polyolefins, TPU's*, TPE's* - Polyolefins, TPU's*, TPE's* - POM, PA's*, PBT*, PPO* - Polyolefins, TPU's*, TPE's*, POM*, PA's*
Poly Clear Prime HMEX	<ul style="list-style-type: none"> - Comprehensive (M) - Comprehensive (O) - Decarbonisation 	<ul style="list-style-type: none"> - Antistatic (ESD) Polyolefins, PE100, PE80 - POM, PA's*, low mfi Polyolefins - Polyolefins, POM, PA's*, PBT*, PPO*
Poly Clear Prime CFT	<ul style="list-style-type: none"> - Basic - Comprehensive (M) 	<ul style="list-style-type: none"> - Styrenics, Polyolefins - Styrenics, Polyolefins

*May require re-flushing with commodity polymer due to hydrolysis nature of next material.

Aquapurge products are not intended to be incorporated in finished plastic goods. In the view of the many factors that may affect processing and application, users should make their own independent determination that the products are suitable for their intended use and can be used safely and legally.

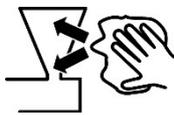


Basic Hot Runner Colour Change Instructions

Poly Clear Prime's Basic Instructions are designed to ensure the product is as easy to use as possible and with the smallest number of adjustments. It is designed to achieve your productivity improvement goals whilst freeing up technical staff to move onto more important projects.

If the fantastic results require improvement, please refer to the "Moulding Through a Hot Runner" comprehensive instructions.

Instructions:



A) Finish the last run and clean hoppers and material equipment in the normal fashion.

Blender status

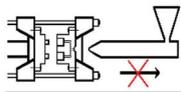
50.00	0.00	Recipe	16	0.00	50.00
Nat	1			2	Nat

B) Add **Poly Clear Prime** to your next material at a 50/50 ratio (adding **Poly Clear Prime** as the regrind constituent in your material blender is a great solution).

0.00	0.00	-4611	0.00	0.00
Nat	4	g	3	Nat

C) Use your normal colour change procedure with the new mix.

Items which may require adjustment:



Do not use sprue break (carriage retraction)

Increase maximum Peak Injection Pressure (PIP) limit to allow requested injection speed and therefore semi-full to full shots to be achieved.



If excessive drool is occurring through the open tips reduce the **Poly Clear Prime** constituent in the mix ratio (A good rule of thumb is to attain an increase of 30% in Peak Injection Pressure during the injection phase)

Set all sequential gates to open & close together



Safety Precautions



Do not use Poly Clear Prime for material with processing temperatures below 160° C



Do not use Poly Clear Prime for material with processing temperatures above 290° C



Wear suitable protective clothing when cleaning down equipment, using, handling or viewing the hot or cold **Poly Clear Prime**



If contact with skin occurs, wash with cool water



In case of eye contact, irrigate with plenty of cool water



Do not swallow product



In situations of excessive shear heat place purgings in cool water to eliminate fumes

