

Injection Moulding Instructions Purging through an Open Hot Runner (Comprehensive (O) 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.

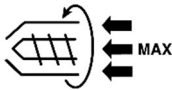


Colour Change Instructions through an Open HR

Cleaning Screw and Barrel (A - D)



A) Empty Machine of last material



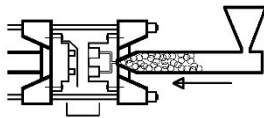
B) Increase Back Pressure to Maximum



C) Dose 1 kg per 100 Tonne of Machine
(i.e. 500 Tonne = 5 kg)

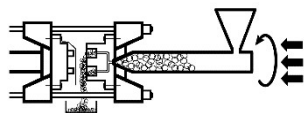
D) Once all colour has been removed from the purge,
decrease back pressure to running conditions and
screw back and inject until purge is white

Cleaning Hot Runner (E – I)



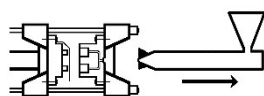
E) Move the carriage up to the sprue bush and place
protection on the moving platen

F) Ensure valve gates are open before purging



G) Increase back pressure to maximum and rotate the
screw to extrude through the open tool

H) Continue extruding until all evidence of previous
material is removed



I) Retract carriage, clean around the nozzle and sprue
bush and empty screw

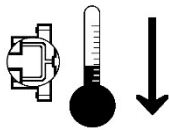


Colour Change Instructions through an Open HR

Remove carbon in the Hot Runner (J – N)

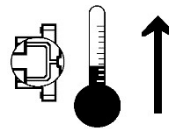
To complete just colour removal, go to (O)

J) For materials such as Nylon, PBT or POM let the machine sit for 20 minutes to remove carbon build-up.



OR

K) Turn the Hot Runner temps OFF and leave the cooling water ON until the tool temperature reaches 80°C



L) Turn on the Hot Runner and increase to running temps

M) Re-dose and flush the screw and barrel with **Poly Clear Prime**

N) Repeat Steps E - I



Clearing Screw & Barrel (O - Q)



- O) Decrease back pressure to running conditions, stop feeding **Poly Clear Prime** and screw back and inject till completely empty.
- P) STARVE-FEED the next material and colour 5X's (fill the hopper throat and empty the hopper throat 5 times) and empty the screw completely.
- Q) Continue with the next material until all evidence of the **Poly Clear Prime** is clear from the purge.

Clearing Hot Runner (R - S)

- R) Repeat steps E to I with the NEXT MATERIAL until all purge is cleared from the Hot Runner



- S) Expel air and reseal bag



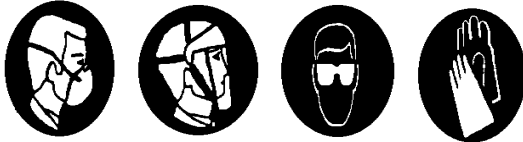
Safety Precautions



Do not use Poly Clear Prime for material with processing temperatures below 160⁰ C



Do not use Poly Clear Prime for material with processing temperatures above 290⁰ 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

