

HOW TO USE

1. Increase the temperature of barrel and nozzle 10°- 20°C.
2. No lower speed of the screw and no application time is required.
3. Increase back pressure to prevent screw from moving backwards.
Eject the old material completely.
4. Carefully inspect for old material at throat hole, hopper loader and dosing unit.
5. Purge out with Virgin (advice MFI <1) until most of the old material/colour has disappeared.
6. Purge out with the amount of **4cleanmix** as indicated ⁽¹⁾.
7. Purge out with Virgin material, until no more contaminants are visible.
8. If old material/contaminants are still visible repeat steps 6 and 7.

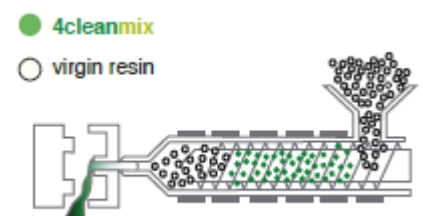


⁽¹⁾ Indication required amount of **4cleanmix** (see table below):

Machine size TON	Amount of 4cleanmix (cleaning of barrel, screw and nozzle)	Amount of 4cleanmix (cleaning of hot runners)
	4cleanmix	4cleanmix
50	0,4 kg	0,2 kg
100	0,8 kg	0,4 kg
150	1,5 kg	0,8 kg
200	2 kg	1 kg
250	2,5 kg	1,2 kg
300	3 kg	1,5 kg
350	3,5 kg	1,8 kg
400	4 kg	2 kg
800	8 kg	4 kg
1000	10 kg	5 kg
1500	15 kg	8 kg

HOW TO CLEAN HOT RUNNERS (After cleaning barrel, screw and nozzle):

1. Increase the temperature of the hot runners 10°- 20°C.
2. With open mould* load and purge out with Virgin material until most of the old material/ colour has disappeared.
3. Purge out with required amount ⁽¹⁾ of **4cleanmix****.
4. Purge out with Virgin material, until no more contaminants are visible.
5. Resume production.

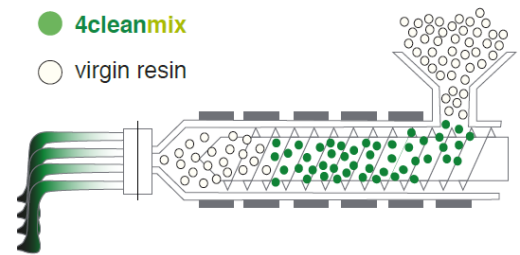


* It is very important to add the Virgin immediately after the **4cleanmix** in order to maintain an adequate back pressure

** It is also possible to clean by injection moulding products with **4clean** but be aware of discharge and possible clogging of the moulding gates due to the low MFI. Better use **4cleanpure** together with own high MFI Virgin.

HOW TO USE

- Increase the temperature of the extrusion head 10°- 20°C.
 - No lower speed of the screw and no application time is required.
 - 1 part = 1x maximum volume inside the extruder plasticizing unit ⁽¹⁾.
1. Purge out the old material completely.
 2. Carefully inspect for old material at throat hole, hopper loader, dosing unit(s) and vent.
 3. Purge out with Virgin (advice MFI <1) until most of the old material/ colour has disappeared.
 4. Purge out with one part **4cleanmix**.
 5. Purge out with one part Virgin material
 6. Start production.



⁽¹⁾ Indication required amount of **4cleanmix** (see table below):

Ø	LD20	TWIN SCREW	LD25	TWIN SCREW
	KG	KG	KG	KG
20	0,100	0,200	0,120	0,250
30	0,300	0,800	0,400	0,800
40	0,700	1,400	0,900	1,800
50	1,500	3	1,800	3,600
60	2,500	5	2	6
70	4	8	4,800	9,600
80	6	12	7,200	14,500
90	8	16	10,200	20,500
100	11	2	14	28
120	20	40	24	48