

4cleanpure

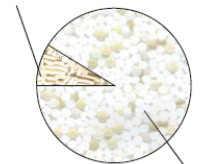
(INJECTION MOULDING)



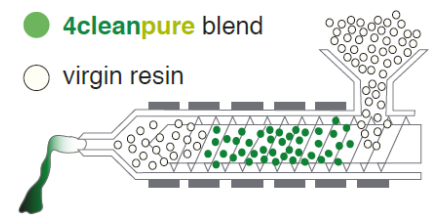
HOW TO USE

1. Create a blend with 15% **4cleanpure** and 85% Virgin ⁽¹⁾.
2. Increase the temperature of barrel and nozzle 10°- 20°C.
3. No lower speed of the screw and no application time is required.
4. Increase back pressure to prevent screw from moving backwards.
Eject the old material completely.
5. Carefully inspect for old material at throat hole, hopper loader and dosing unit.
6. Purge out with Virgin (advice MFI <1) until most of the old material/colour has disappeared.
7. Purge out with the amount blend as indicated ⁽¹⁾.
8. Purge out with Virgin material, until no more contaminants are visible.
9. If old material/contaminants are still visible repeat steps 7 and 8.

15% **4cleanpure**



85%
virgin resin

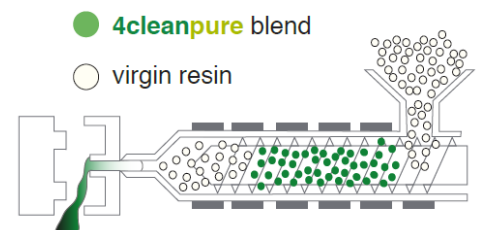


⁽¹⁾ Indication required amount of blend of **4cleanpure**/Virgin (see table below):

Machine size TON	Amount of blend (cleaning of barrel, screw and nozzle)			Amount of blend (cleaning of hot runners)		
	Blend	4cleanpure	Virgin	Blend	4cleanpure	Virgin**
50	0,4 kg	0,060 kg	0,340 kg	0,2 kg	0,030 kg	0,170 kg
100	0,8 kg	0,120 kg	0,680 kg	0,4 kg	0,060 kg	0,340 kg
150	1,5 kg	0,230 kg	1,270 kg	0,8 kg	0,120 kg	0,680 kg
200	2 kg	0,300 kg	1,700 kg	1 kg	0,150 kg	0,850 kg
250	2,5 kg	0,400 kg	2,500 kg	1,2 kg	0,180 kg	1,020 kg
300	3 kg	0,450 kg	2,550 kg	1,5 kg	0,230 kg	1,270 kg
350	3,5 kg	0,530 kg	2,970 kg	1,8 kg	0,270 kg	1,530 kg
400	4 kg	0,600 kg	3,400 kg	2 kg	0,300 kg	1,700 kg
800	8 kg	1,200 kg	6,800 kg	4 kg	0,600 kg	3,400 kg
1000	10 kg	1,500 kg	8,500 kg	5 kg	0,750 kg	4,250 kg
1500	15 kg	2,250 kg	12,750 kg	8 kg	1,200 kg	6,800 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 blend of **4cleanpure**/Virgin**.
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 blend in order to maintain an adequate back pressure
- ** Use high MFI Virgin when cleaning hot runners.

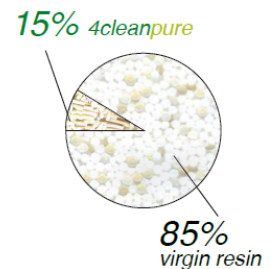
4cleanpure



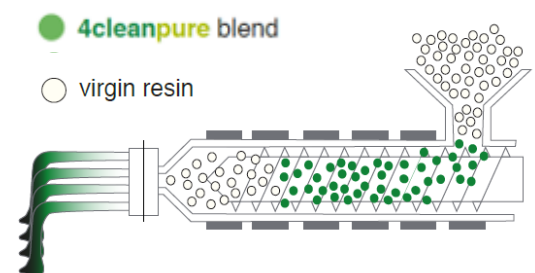
(EXTRUSION)

HOW TO USE

- Create a blend with 15% **4cleanpure** and 85% Virgin.
- 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 blend of **4cleanpure**/virgin resin.
5. Purge out with one part Virgin material.
6. Start production.



⁽¹⁾ Indication required amount of blend of **4cleanpure**/Virgin (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

USE 150 GRAMS OF 4CLEANPURE AND 850 GRAMS OF VIRGIN PER KILO BLEND