

## PEKUTHERM<sup>®</sup> TI2

### PURGING DIRECTIONS

248°F to 626°F (140°C to 330°C)

- 1 . Calculate the amount of material needed to turn over at least 110% of the entire volume of the mold, including the Hot Runner System.
- 2 . Add this amount of Pekutherm<sup>®</sup> TI2 directly behind the undesired (outgoing) material.
- 3 . Follow-up with desired (incoming) material.
- 4 . Quality control the next 3 - 5 shots for desired purity.
- 5 . If desired color purity is not achieved, repeat steps 1 through 3.

#### IMPORTANT NOTE:

It is advised by the manufacturers of Pekutherm<sup>®</sup> TI2 to remove all hardened residues or laminar build-up from the machinery prior to purging out the mold. Failure to remove these residues could result in a restriction of the proper flow of plastic material into the mold. Use of Pekutherm<sup>®</sup> N, SM, SK, EX or HLT, a physical action purging compound or screw pull (hand cleaning), is recommended.

For further assistance, please contact us at UniTemp, Inc. or our sales representative.