

PEKUTHERM® ULT, ULT Fine

INJECTION PURGING DIRECTIONS

175°F to 625°F (79°C to 330°C)

1. Leave the barrel full of the out-going polymer.
2. Move the barrel back from the tool. (do not run Pekutherm® through the tool or any other restrictions -manifold, dispersion disc, etc. Min. nozzle opening - 3mm.)
3. Put a receptacle, carton or box in front of the machine nozzle to catch the purged material.
4. Set the screw in the forward position and leave it there. Turn up the back pressure enough to keep the screw forward.
5. Purge at approximately 50% of injection-molding speed.
6. Rotate the screw until the hopper throat is empty of out-going material.
7. Introduce a small amount of Pekutherm®, about 20-30% of the total barrel capacity (add it in small amounts. Too much at one time could block the barrel.)
8. Move the Pekutherm® down the barrel and introduce some in-coming material at this time. (If more cleaning is needed, add another small amount of Pekutherm® at this time.)
9. Put in enough in-coming material to fill the barrel and run it through the machine.
10. At this point the change should be complete.

NOTE: Additional amounts of Pekutherm® should be run on extremely dirty or worn machines.

Also, add 10-15% more Pekutherm® when purging a vented barrel machine or a worn machine.

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