



Don't just purge... *Ultra Purge!*^(TM)

Technical data sheet

Ultra Purge 5060 (PET)

Ready-to-use glass reinforced purging compound

Please read carefully TDS-SDS before using Ultra Purge. If you don't have this document, you can download it from ultrapurge.com

| Working temp range | Resins | Applications | Designed for |
|--|--|---|--|
| From 190°C to 320°C From 374°F to 608°F | ABS, PA, PS (crystal), GPPS, HIPS, PC, PMMA, SAN, PBT, PET... | Injection Molding Hot Runners Extrusion | Color Changes Shut-Downs Material Changes Carbon Build Up |

Produced by

MOULDS PLUS
INTERNATIONAL



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Please see attached table for quantities.

ULTRA PURGE is an especially designed purging compound in pellet form. Ultra Purge PET-E and 5060 come in premixed ready-to use pellet form, while Ultra Purge PET-C is a concentrated pellet compound that has to be mixed before usage. Ultra Purge cleans color deposits and black specks from screw, shooting pot, nozzle and hot runners. It is effective on all kinds of PET types. Superior results are obtained when doing periodic cleaning or color changes with: PET

HOW ULTRA PURGE WORKS:

- ULTRA PURGE works through a chemical reaction. Color, incrustation, black specks and rust are softened, removed and ejected from the press through an innovative chemical process.
- Expanding agents are added to the new formula, which allows the compound to be more efficient - even in difficult to clean situations.
- ULTRA PURGE cleans at the same processing temperature of the previous production material.
- ULTRA PURGE is recommended for injection molding machines, extruders and hot runners.

WHEN TO USE ULTRA PURGE:

- **Use Ultra Purge during ALL color changes to minimize down time and to drastically reduce the presence of black specks during the production.**

In the most instances, black specks come from degraded colorant. The quantity of Ultra Purge recommended in the attached table is referring to hard to clean situations such as white, opaque colorant and very dark colorant. The quantity of Ultra Purge may be reduced when cleaning lighter colorants.

- **To prevent black speck problems rising from degraded colorant, additives or scavengers:**

We recommend using Ultra Purge as a preventive maintenance before the problem occurs once every two weeks by using the Ultra Purge quantity shown in the attached table. Based on the entity of the problem, the frequency of the cleaning process may be changed.

- **To eliminate the “slip screw” problem:**

Liquid colorants tend to build up in the screw with the consequent loss of plasticizing efficiency. Using Ultra Purge in the quantity shown in the attached table will help to completely solve the problem.

Husky machines - quantities and mixing ratio

| Screw diameter (mm) | 85 | 100 | 120 | 140 |
|---|-----|-----|-----|-----|
| Screw diameter (in) | 3.3 | 3.9 | 4.7 | 5.5 |
| Color/material change | | | | |
| Ultra Purge 5060 (kg) | 4 | 5 | 7 | 10 |
| Ultra Purge 5060 (lbs) | 9 | 11 | 15 | 22 |
| Black specks | | | | |
| Ultra Purge 5060 (kg) | 2 | 2.5 | 3.5 | 5 |
| Ultra Purge 5060 (lbs) | 4 | 6 | 8 | 11 |
| *Molding preforms - Ultra Purge blending ratio 50% | | | | |
| Ultra Purge 5060 (kg) | 2 | 2.5 | 3.5 | 5 |
| PET (kg) | 2 | 2.5 | 3.5 | 5 |
| Ultra Purge 5060 (lbs) | 4.4 | 5.5 | 7.7 | 11 |
| PET (lbs) | 4.4 | 5.5 | 7.7 | 11 |

*** Mix Ultra Purge ONLY with cold and undried PET.**



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HUSKY - Extruder and shooting pot

This document is a general description on how to use Ultra Purge. Request your customized instructions by contacting your nearest sales office or local distributor.

- 1 Load and run machine with clear PET until the molded preforms appear visibly cleaner/lighter (approximately 10/15 shots).
- 2 Adjust the back-pressure from 8 to 10 bars.
- 3 Manually clean color mixer with a clean fabric rag to remove all remnants of color.
- 4 Without running the barrel empty, load Ultra Purge 5060 in the feeding hopper using the quantity indicated in the attached table.
- 5 Do not load Ultra Purge in the solid color mixer.
- 6 Run screw at 50% of the screw rotation speed without changing the extruder temperature and start to make injection.
- 7 With hard-to-clean colorant a 3 minute soak time might be required once the barrel will be entirely fill-up with Ultra Purge.
- 8 Do not let Ultra Purge soak inside the machine for more than 3 minutes; it will not improve the process.
- 9 It is important not to run the barrel empty to improve Ultra Purge's performance.
- 10 Begin normal production.

Things to avoid with Ultra Purge 5060:

TDS-Ultra_Purge_5060_v0_ENG

- Use on mirror polished surfaces.
 - Load Ultra Purge through heated feed line - Ultra Purge starts to melt at 80°C (176°F).
 - Allow longer soaking time from what suggested.
 - Use more than recommended quantities of Ultra Purge per cleaning.
 - Increase temperatures if dealing with thermo sensitive resins or additives.
 - Mold difficult to eject parts - when molding Ultra Purge you may get a short shot.
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HUSKY - PREFORMS Mold open

This document is a general description on how to use Ultra Purge. Request your customized instructions by contacting your nearest sales office or local distributor.

- 1 Stop the color dosing unit and perform five injection shots with the injection unit detached from the mold.
- 2 After five shots, stop the machine, open the color mixer and clean it with a clean fabric rag.
- 3 Load the quantity of Ultra Purge 5060 shown in the attached table and perform injections until Ultra Purge is ejected from the nozzle. (The injection has to be in the back position detached from the mold.)
- 4 Move the injection unit in the forward position, attaching it to the mold and perform three injections shots through the hot runners.
- 5 Let Ultra Purge soak for 2-3 minutes inside the hot runners for each shot and repeat this procedure during every shot. It is recommended to place a cardboard foil under the mold to collect the purging material.
- 6 While the last shot of Ultra Purge soaks in the mold, detach the injection unit from the mold and removed the rest of the purging compound within the barrel using clear PET.
- 7 After Ultra Purge is completely removed from the barrel, attach the injection unit to the mold and perform three shots with clear PET to remove Ultra Purge from the hot runner.
- 8 After the third shot with clear PET through the hot runners, proceed to manually clean the mold cavity removing the purged PET.
- 9 Start the production in semi-automatic mode for 3-4 cycles and then switch to automatic mode.

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