

# Purging procedures

## Purging procedures

We recommend "screw rotation purge" as basic purging method. This method can clean the both of screw and barrel by screw rotation.

### ■ Main points of cleaning procedures

Back pressure	High (enough so that the screw does not move back)
Screw position	Furthest forward position
Screw rotation speed	Same rotation speed as molding operation
Temperature	Same operating temperature as previous resin.

### ■ Purging procedures

1. Discharge previous resin entirely.	The purging effect will decrease if previous resin remains. Confirm that nothing is left in the hopper and feeding line.
2. Clean the hopper before feeding ASACLEAN.	Refer to the table below and estimate the quantity of ASACLEAN to use.
3. Purge by screw rotation method.	Back pressure : High Screw position : Furthest forward position Screw rotation speed : Same speed as molding operation Temperature : Same temperature as previous resin
4. Visually check the discharge of previous color.	If you stop the machine, please apply sealing procedures.
5. Set temperatures for next resin to be processed.	Change the temperature here if necessary.
6. Clean the hopper before feeding next resin.	Confirm that nothing is left in the hopper and feeding line.
7. Discharge ASACLEAN by screw rotation purge.	Perform in the same way as the purging operation.
8. Visually check the displacement of ASACLEAN.	Confirm that ASACLEAN has been displaced entirely.
9. Check the molded products.	Check the quality of molded products.

## Purging procedures

### ■ Normal quantity of use

By machine capacity 【Test condition】 Purging temperature : 240°C / Resin purged : ABS		By operating temperatures 【Test condition】 Clamping force : 125 tons		
Clamping force (tons)	Quantity of ASACLEAN U (kg)	Molding temperature (°C)	Quantity of ASACLEAN U (kg)	Resins (Example)
80	0.4	180~230	0.4	PS, PP, PMMA, POM etc.
125	0.6	230~250	0.6	ABS, SAN(AS) etc.
550	2.5	250~310	0,8	PA, PPE, PC, PBT etc.
800	5.0			
1,250	7.0			
3,000	16.0			

#### - Automatic purge -

Automatic purge mode of injection molding machines is generally programmed to repeat injection operations at intermediate back pressure and at higher than usual speed.

In case of using automatic purging, resins stuck on the screw might not be removed sufficiently, though there is no need of manual operation by operators. It is efficient to purge by screw-rotation method at high back pressure for removal of resins especially in the middle zones of barrel and screw.

\*Please try screw-rotation purge if deposits cannot be removed effectively by automatic purge.

\* If this cleaning method is not effective for your machines, please contact us or our distributors for technical assistance.