

PURGiNGiT

P & P CREAM in SACHET

Processing temperature: 70°C - 420°C

Dosing: P&P CREAM™ SACHET 2% of the barrel capacity (see table below)

SACHET: 20 gr

Injection moulding machine	Barrel capacity	Nr Sachets
50 Tonn	0,2 Kg	1
100 Tonn	0,5 Kg	1
200 Tonn	1,0 Kg	1
400 Tonn	2,0 Kg	2
600 Tonn	3,0 Kg	3
800 Tonn	4,0 Kg	4
1000 Tonn	5,0 Kg	5
1500 Tonn	7,5 Kg	7
2000 Tonn	10,0 Kg	10

How to use **P&P CREAM™ SACHET**

When cleaning keep the same parameters (such as temperature, screw speed etc.) as the last material to be processed

BARRELS , SCREWS, NOZZLES and HOT RUNNERS

1. Upload and purge material (Natural or next production) in an amount to eliminate most of the residue of dirty.
2. Empty the plasticizing group (**HOPPER AND BARREL**)
3. While the screw is turning put the sachets into the throat load (**WITHOUT OPENING**) (see **table above**) in line upload and purge with virgin material until **P&P CREAM™ SACHET** out of the nozzle
4. Stop the group units allow the **P&P CREAM™** for few minute.
5. Load and purge with Natural material to eliminate all residue removed by **P&P CREAM™**
6. If the system is not completely cleaned repeat Phase 2 to phase 5
7. Then start the new production .

HOT RUNNERS:

- After the cleaning of the cylinder,screw and nozzle,
- Increase the Temperature of the hot runners as much as is allowed by the Material inside.
- At the mould open or moulding repeat: phase 1 to phase 6