



# Ultra Purge™ PET-E HF

## Ready-to-Use Chemical Purging Compound

### Benefits

- High efficiency
- Rapid cleaning effect
- Easy to use
- Operator and equipment safe
- Wide application range

### Description

Ultra Purge™ PET-E HF is a ready-to-use chemical purging compound. Ultra-Purge™ PET-E HF is a high flow product. It can be used for cleaning in injection molding and hot-runner applications. Ultra Purge™ PET-E HF can also be used for the cleaning of screw, barrel, nozzle, hot-runner and gate of injection molding machines processing thermoplastic resins. The purging concentrate consists of highly efficient cleaning additives and does not contain abrasives.

**Ultra Purge™ PET-E HF can be used at processing temperatures from 190 °C (374 °F) to 320 °C (608 °F).**

The purging compound is especially recommended for color and material change as well as for the removal of black spots, carbon residues and shut-downs.

Ultra Purge™ PET-E HF is suitable for following thermoplastic resins:

Resin	Suitable
Amorphous resins	+
Crystalline resins	
PA, POM	
PET	++
Polyolefins	
PS	
TPE-TPR	
High-temperature engineering resins	
PVC	
TPU	
Transparent polyamides, CA, CAB, when switching from any resin to PMMA	
When switching from any resin to PC	
When switching from any resin to PMMA	

### Typical Properties

Appearance

White granules mixed with grayish-brown tablets

### Special Notes

- Do not load Ultra Purge™ through heated feeding line - Ultra Purge™ starts to melt at 80 °C / 176 °F.
- Do not use more than recommended quantities of Ultra Purge™ per cleaning.
- Do not increase temperatures when dealing with thermo-sensitive resins or additives.
- Do not mold difficult-to-eject parts - when molding Ultra Purge™ you may get a short shot.
- Do not use Ultra Purge™ outside its working temperature range.

### Application

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.

Please read carefully the SDS before using Ultra Purge™.

We recommend the following cleaning procedures.





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### Cleaning of Screw and Barrel - Injection Molding:

1. Load and run machine with clear PET until the molded preforms appear visibly cleaner/lighter (approximately 10/15 injections).
2. Adjust the back pressure in order to allow the screw to safely load and inject.
3. Move the injection unit to the back position. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
4. Manually clean color mixer with a clean fabric to remove all remnants of color.
5. Add Ultra Purge™ (1 barrel capacity).
6. Do not load Ultra Purge™ in the solid color mixer or through heated elements.
7. Make injections until you see Ultra Purge™ being ejected through the nozzle.
8. A 3 minute soak time may be required with hard-to-clean colorants only. Do not let Ultra Purge™ soak inside the machine for more than 3 minutes; it will not improve the performance.
9. Add the next production resin/color directly after Ultra Purge™ and make injections until Ultra Purge™ is displaced from the machine.
10. Make 4-5 injections with the next resin to completely displace Ultra Purge™.
11. If contamination persists, repeat steps.

### Cleaning of Hot-Runner System - Mold Open - Injection Molding:

1. Load and run machine with clear PET until the molded preforms appear visibly cleaner/lighter (approximately 10/15 injections).
2. Adjust the back pressure in order to allow the screw to safely load and inject.
3. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
4. Manually clean color mixer with a clean fabric to remove all remnants of color.
5. Add Ultra Purge™ (1 barrel capacity).
6. Do not load Ultra Purge™ in the solid color mixer or through heated elements.
7. With mold open, make injections until you see Ultra Purge™ being ejected through the hot-runners.
8. Only with hard-to-clean colorants, a 3 minute soak time may be required. Do not let Ultra Purge™ soak inside the machine for more than 3 minutes; it will not improve the performance.
9. Add the next production resin/color directly after Ultra Purge™ and make injections until Ultra Purge™ is displaced from the machine.
10. Make 4-5 injections with the next resin to completely displace Ultra Purge™.
11. If contamination persists, repeat steps.





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### Cleaning of Hot-Runner System - Mold Closed - Injection Molding:

1. Load and run machine with clear PET until the molded preforms appear visibly cleaner/lighter (approximately 10/15 injections).
2. Adjust the back pressure in order to allow the screw to safely load and inject.
3. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
4. Manually clean color mixer with a clean fabric to remove all remnants of color.
5. Add Ultra Purge™ (1 barrel capacity) and mold parts until 100% Ultra Purge™ is molded into parts.
6. Do not load Ultra Purge™ in the solid color mixer or through heated elements.
7. Add the next production resin directly after Ultra Purge™.
8. Continue molding parts out of the Ultra Purge™.
9. Make 4-5 cycles with the next resin to completely displace Ultra Purge™. Set all the parameters to the next production settings.
10. If contamination persists repeat steps.

### Dosage

Please refer to specific cleaning process.

### Storage/Handling

Ultra Purge™ PET-E HF should be stored in a dry indoor area at room temperature. For further information on storage, handling, hazards, etc. please refer to safety data sheet.

### Shelf Life

18 months

### Packaging

Ultra Purge™ PET-E HF is available in a variety of package sizes. Please contact Chem-Trend customer service for details.

### Further Information

Please request information on our complete range of materials for this industry.

*While the technical information and suggestions for use contained herein are believed to be accurate and reliable, nothing stated in this bulletin is to be taken as a warranty either expressed or implied.*

