



# Ultra Purge™ HT+

## Ready-to-Use Glass-Filled Purging Compound

### Benefits

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

### Description

Ultra Purge™ HT+ is a ready-to-use glass-filled purging compound. It can be used for cleaning in injection molding, and extrusion applications. Ultra Purge™ HT+ can also be used for the cleaning of screw, barrel and nozzle, of injection molding machines processing thermoplastic resins. The purging concentrate consists of highly efficient cleaning additives.

**Ultra Purge™ HT+ can be used at processing temperatures from 250 °C (482 °F) to 400 °C (752 °F).**

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

Ultra Purge™ HT+ 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      Translucent yellow granules

### Special Notes

- Do not use on mirror polished surfaces.
- 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 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.





# Ultra Purge™ HT+

## Ready-to-Use Glass-Filled Purging Compound

### Cleaning of Screw and Barrel – Injection Molding – Material Change- DIFFERENT Temperatures:

1. Move the injection unit to the back position and manually remove all possible contaminants in the hopper/mixer/filters.
2. Make sure the barrel is empty when adding Ultra Purge™ HT+ in the machine.
3. Set screw rotation to maximum allowed speed.
4. Set shot size to 80% of maximum shot size.
5. Add Ultra Purge™ HT+ (at least 1 barrel capacity). Keep purging with Ultra Purge™ HT+ until previous resin is removed and empty the barrel from Ultra Purge™ HT+.
6. Set the machine to the working temperature of the resin you are going to proceed (see next steps).  
*If the cooling/heating time is greater than 5 minutes, add half barrel capacity of Ultra Purge™ HT+ every 5 minutes and make sure to purge the barrel empty every time you purge.*  
Do not use Ultra Purge™ HT+ at a temperature lower than 250 °C/482 °F.
7. Add the next production resin when at desired temperature and begin normal production.
8. If contamination persists repeat steps.  
\* Please note, Ultra Purge™ HT+ may turn reddish in color after being processed. This is normal part of the cleaning process.

### Cleaning of Screw and Barrel – Injection Molding- Material Change- SAME Temperature:

1. Move the injection unit to the back position and manually remove all possible contaminants in the hopper/mixer/filters.
2. Make sure the barrel is empty when adding Ultra Purge™ HT+ in the machine.
3. Set screw rotation to maximum allowed speed.
4. Set shot size to 80% of maximum shot size.
5. Add Ultra Purge™ HT+ (at least 1 barrel capacity).
6. Make injections until Ultra Purge™ HT+ is used up and load the next production resin directly after.
7. Keep making injections until all remnants of Ultra Purge™ HT+ have been displaced from the machine.
8. Begin normal production.
9. If contamination persists repeat steps.  
\* Please note, Ultra Purge™ HT+ may turn reddish in color after being processed. This is normal part of the cleaning process.

### Cleaning Screw and Barrel – Extruder – Material Change – DIFFERENT Temperatures:

1. Make sure the barrel is empty when adding Ultra Purge™ HT+ in the machine.
2. We recommend removing the finest layer of the screen pack. Make sure that the pressure or torque force remains within safety limits when running Ultra Purge™.
3. Add Ultra Purge™ HT+ (at least 1.5 times the extruder barrel capacity).
4. Extrude at high speed until the Ultra Purge™ HT+ is used up and empty the barrel.
5. Set the machine to the working temperature of the resin you are going to proceed (see next steps).  
*If the cooling/heating time is greater than 5 minutes, add half barrel capacity of Ultra Purge™ HT+ every 5 minutes and make sure to purge the barrel empty every time you purge.*  
Do not use Ultra Purge™ HT+ at a temperature lower than 250 °C/482 °F.
6. When temperatures are at set point, add the next production resin and extrude it at higher screw rotation speed to completely displace the Ultra Purge™ HT+.
7. If possible, replace the screen pack during this phase.
8. If contamination persists repeat steps.  
\* Please note, Ultra Purge™ HT+ may turn reddish in color after being processed. This is normal part of the cleaning process.



Don't just purge...ULTRA PURGE™



# Ultra Purge™ HT+

## Ready-to-Use Glass-Filled Purging Compound

### Cleaning Screw and Barrel - Extruder – Material Change - SAME Temperature:

1. Make sure the barrel is empty when adding Ultra Purge™ HT+ in the machine.
2. We recommend removing the finest layer of the screen pack. Make sure that the pressure or torque force remains within safety limits when running Ultra Purge™.
3. Add Ultra Purge™ HT+ (at least 1.5 times the extruder barrel capacity).
4. Extrude at high speed until Ultra Purge™ HT+ is ejected from the machine.
5. Add the next production resin and extrude it at higher screw rotation speed to completely displace the Ultra Purge™ HT+.
6. If possible, replace the screen pack during this phase to speed up the purging process.
7. If contamination persists repeat steps.

### Dosage

Please refer to specific cleaning process.

### Storage/Handling

Ultra Purge™ HT+ 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™ HT+ 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.*



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