

4cleanmix

extrusion

4Cleanmix is a cleaning compound, “ready-to-use”, especially studied to clean barrel, screw and head of extrusion from carbon residuals, deposits, incrustations in changing colour and material.

TEMPERATURE RANGE: **4Cleanmix** cleans from 120°C up to 320°C. It works efficiently with all thermoplastic within the indicated range temperature.

4Cleanmix is odourless, non-toxic; it doesn't contain solvents and it isn't abrasive.

All components of **4Cleanmix** are qualified as Generally Recognized as Safe (GRAS) by FDA.

4Cleanmix is environmentally safe.

HOW TO USE **4Cleanmix**:

1. Find out the capacity of the barrel of your machine from the throat to the die head in Kgs.
2. Once found out this capacity, take this amount of **4Cleanmix** and the same amount of virgin resin (e.g.: if the capacity is 1 Kg, prepare 1 Kg of **4Cleanmix** and 1 Kg of virgin resin such as HDPE).
3. Split the amount calculated into 2 equal amounts and do the same with the virgin resin chosen for the cleaning.
4. Eject the prior polymer completely
5. Increase of 10°-20° C the temperature of the head of extrusion
6. Feed the barrel starting with virgin resin, followed by **4Cleanmix**. Use ½ of the prepared **4Cleanmix** and add immediately virgin resin. Purge out the material as fast as possible, without any soaking time.
7. Repeat step 6 for 2 times until the purging with virgin resin is totally cleaned (it depends by the contamination of your machine).

NOTE: the last step must be done with virgin resin or the following material, adjusting the temperature for the following polymer and start with the next production.

INDICATION REQUIRED AMOUNT OF **4Cleanmix**

Ø	LD20 KG	TWIN SCREW KG	LD25 KG	TWIN SCREW KG
20	0.10	0.20	0.12	0.25
30	0.30	0.60	0.40	0.80
40	0.70	1.40	0.90	1.80
50	1.50	3	1.80	3.60
60	2.50	5	3	6
70	4	8	4.80	9.60
80	6	12	7.20	14.50
90	8	16	10.20	20.50
100	11	22	14	28
120	20	40	24	48

