

4cleanmix

injection moulding

4Cleanmix is a cleaning compound, “ready-to-use”, especially studied to clean barrel, screw, nozzle and hot runners 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 nozzle in Kgs.

* Injection Capacity - If the total volume (weight) of the barrel of the injection molding machine could be molded into a part, it would be defined as the injection capacity.

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 screw and nozzle.
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.

HOW TO CLEAN HOT RUNNERS (after cleaning barrel, screw and nozzle):

1. Increase the temperature of the hot runners as much as allowed by the material inside.
2. With open mould, load and purge with virgin material.
3. Purge with ½ of the prepared blend. Immediately add virgin resin*: purge out the material as fast as possible.
4. Repeat step 3 until the purging with virgin resin is totally cleaned.
5. Begin new production.

* It is very important to add the resin immediately after the blend in order to maintain an adequate back pressure.

