

# 4cleanpure

## extrusion

**4Cleanpure** is a cleaning compound in pellets, concentrate, which has to be mixed at 10% with every thermoplastic, especially studied to clean barrel, screw and head of extrusion from carbon residuals, deposits, incrustations in changing colour and material.

**TEMPERATURE RANGE:** **4Cleanpure** works efficiently from 80°C up to 420°C.

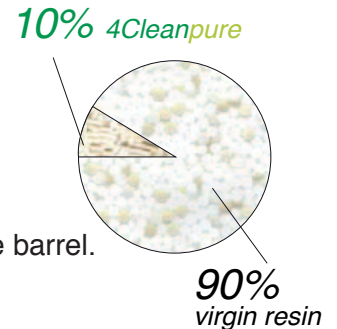
It is enough to prepare the blend with your own thermoplastic which can resist at the temperature of the machine and of the material to be cleaned.

**4Cleanpure** is odourless, non-toxic; it doesn't contain solvents and it isn't abrasive. All components of **4Cleanpure** are qualified as Generally Recognized as Safe (GRAS) by FDA.

**4Cleanpure** is environmentally safe.

**HOW TO USE IT:** **4Cleanpure** is in pellets form. Before to use it, it is needed to prepare the blend.

1. Find out the capacity of the barrel of your machine from the throat to the die head in Kgs (amount of resin needed to fill the entire barrel from the hopper to the head included).
2. Once found out this capacity, prepare the blend with 10% of **4Cleanpure** and 90% of your thermoplastic (the resin MFI has to be equal or lower than the material that has to be removed), in an amount equal 1/1,5 times the capacity of the barrel.
3. Split this amount 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 the blend prepared with **4Cleanpure**. Use ½ of the prepared blend and add immediately virgin resin. Purge the blend of 4Cleanpure continuously from the head.
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, setting up the next temperature production.**

INDICATION REQUIRED AMOUNT OF 4Cleanpure blend

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

