

Instruction to ver~rus®, sol~pur®, per~tas®

Cleaning of cylinders, screws, hot runners, extrusion dice, ... proceed as followed:

Cleaning of plastification unit (injection moulding + extrusion)

1. Spray plastification unit until it is "empty"
2. Prepare cleaning mixture or provide cleaning agent pellets.
- 2.1 Steps of preparing cleaning mixture:
Depending on the application mix 0,5% - 3% of the cleaning concentrate (ver~rus, sol~pur, per~tas) with **cold** pellets.
Extrusion max. 3%, Injection moulding max. 2%, POM / PC max. 1%
Mix 3 to 5 times the quantity of the maximum dosing weight
3. Units with degassing zone close the opening by an end connector
4. Fill in the cleaning mixture or cleaning agent pellets into the hopper (do not use the suction conveyor). Stop the screw at the nozzle (injection moulding) and plastify till plastic is discharging the nozzle.
5. Stop the machine for 5 minutes. The cleaning mixture foams and reaches / cleans the dead zones.
6. Now dose up to the maximum metering stroke (injection moulding) and spray the cleaning material.
7. Repeat the process as long as the cleaning result is satisfied (usually 1 to 3 passes).

Cleaning of injection mould

1. Produce articles with the cleaning material until the cleaning material is visible
2. If possible leave the mould 5 minutes close.
(as the cleaning material is foaming up, it cleans the dead zones of the hot runner for example)
3. In case the mould could not be kept closed, inject through the open mould and keep the cleaning material 5 minutes within the hot runner. Then continue production.
4. Repeat the process as long as the cleaning result is satisfied (usually 1 to 3 passes).

Cleaning of the extrusion die

1. The same procedure as with the cleaning of the plastification unit. Note that the cleaning material must go through the extrusion tool. Keep the cleaning material 5 minutes within the extrusion tool before continuing the process.
2. Repeat the process as long as the cleaning result is satisfied.

Please note the safety instructions

Do not store lower than + 10°C or higher than +25°C

Close the container of the cleaning agent **ver~rus®**, **sol~pur®**, **per~tas®** tightly