

Type	Injection	Resin	Operating temperature	Replaceability
ECOPURGE V	Injection	ABS·PC·PS·AS· PC-ABS	200°C to 320°C	○
ECOPURGE D	Injection	PP·ABS· PC-ABS·POM	180°C to 280°C	○
ECOPURGE H	Injection	HDPE·LDPE·	150°C to 260°C	○

To improve work efficiency when changing color or resin from screw through hot runner. Further, measures against poor carbide that have not been performed yet are implemented.

ECOPURGE®

Precautions

- As working conditions depend on the customer, consult us for details prior to use.
- When the product is applied to a hot-runner, consult us for technical information prior to use.
- Refer to the attached Safety Data Sheet, or the precautions described on the product.
- The product complies with the Food Sanitation Law, and Standards for Foods, Food Additives and Other Related Products (Ministry of Health and Welfare Announcement No.370 in 1959).
- We do not take responsibility for any damage or loss caused by improper use of the product.

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Package Packed in bag of 20kg

YAMAICHI

Features

ECOPURGE shows excellent properties in a time-consuming color change process, and when cleaning persistent carbonized residues left in a conventional way.

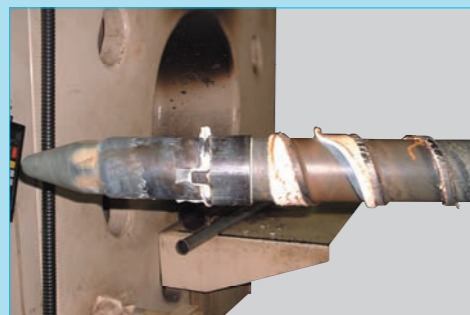
Resin/Color Change	The required quantity of purging agent is reduced by about 30% for resin/color change.	▶ Reduction of industrial wastes
Residue Formation	Low residue formation	▶ Improvement of productivity
Carbonized Material	Retention softens and removes carbonized material.	▶ Reduction of foreign material defects
Hot Runner	Retention and replacement is possible in hot-runner molds	▶ Reduction of mold maintenance and foreign material defects

Example

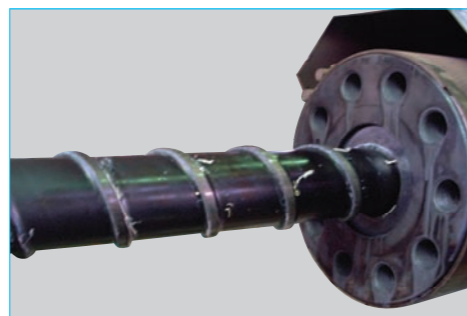
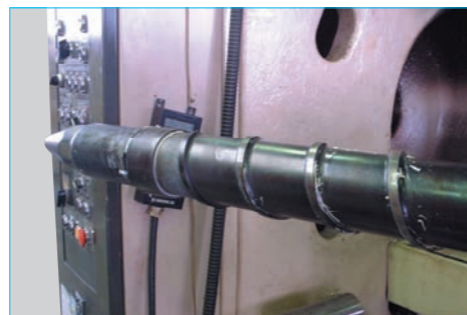
Intended use: Removing carbonized residue in screw
 Purging compound: ECOPURGE D
 Molding machine: 850 t

Resin: ABS, POLYCA ABS
 Purging method: Retention with ECOPURGE D for 20 minutes

Before cleaning



After cleaning



Standard quantity of ECOPURGE: About three times ordinary metering.

1 Normal operation

Preparations

Select the appropriate type of ECOPURGE according to operating temperature and resin.

Discharge previous resin to empty barrel.

Operation: After feeding ECOPURGE, purge manually or automatically. The color-change of the purging compound visually indicates completion of cleaning.

2 Effective operation for removing carbonized material etc

Discharge previous resin

▶ Empty the barrel.

Feed ECOPURGE

▶ Hold the temperature at the same level as previous resin (within the range of the compound's operating temperature)

Discharge ECOPURGE (Drawing)

▶ Hold the screw forward, applying back pressure, so that the screw is in place.
 ▶ Change the preresin to EcoPurge completely up to the tip of the nozzle.

Retention ECOPURGE (1.5 times ordinary metering)

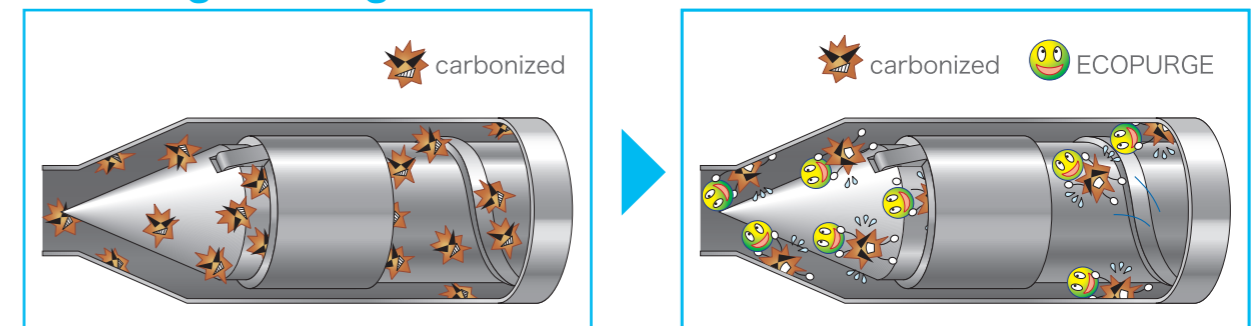
▶ If you intend to remove carbide, the recommended time is 20 minutes or more. Retention is also effective for color/resin change.

During holidays?

Replacement with ECOPURGE on a holiday is recommended. Switch off the barrel heater after replacement. (Turn power off)

Discharge ECOPURGE (Inching injection)

Drawing showing removal of carbide.



Caution: If the screw is heavily contaminated, it should be disassembled and cleaned before feeding ECOPURGE.