

# PURGINGiT

## P & P CREAM in SACHET

Processing temperature: 70°C - 420°C

**P&P CREAM™** is a **Purging and Polishing Cream** especially designed to clean screws, nozzles, hot runners, moulds and dies from Black Spots, deposits, incrustations, in color changes or material changes for all thermoplastics.

**“”suitable for all material”” – “”reusable””.**

**ABS, PA, PET, PS, PMMA, PC, SAN, PVC, EVA, PU, TR, PBT, PPO, PPS, PPA, PP, PE, SBR, EPDM, BMS, FPM, SILICONE etc**

- It dissolves , incrustations, deposits and colour from screws, Barrels, nozzles, hot runners, dies and all metallic surfaces at production temperature of the previous material,
- During the cleaning, the Cream doesn't damage the plasticizing units because the product is odourless and no-toxic It doesn't contain solvents or abrasive substances.
- All components of **P&P CREAM™** are qualified (**GRAS**) by FDA and food contact certified.

**P&P CREAM™** is ecological and safe for the environment

**ONLY ONE PRODUCT FOR  
ALL YOUR PURGING NEEDS**

Contact us for samples and technical support:

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## P & P CREAM in SACHET

Processing temperature: 70°C - 420°C

Dosing: **P&P CREAM™ SACHET** 2% of the barrel capacity (see table below)

**SACHET: 20 gr**

Injection moulding machine	Barrel capacity	Nr Sachets
50 Tonn	0,2 Kg	1
100 Tonn	0,5 Kg	1
200 Tonn	1,0 Kg	1
400 Tonn	2,0 Kg	2
600 Tonn	3,0 Kg	3
800 Tonn	4,0 Kg	4
1000 Tonn	5,0 Kg	5
1500 Tonn	7,5 Kg	7
2000 Tonn	10,0 Kg	10

How to use **P&P CREAM™ SACHET**

When cleaning keep the same parameters (such as temperature, screw speed etc.) as the last material to be processed

### BARRELS , SCREWS, NOZZLES and HOT RUNNERS

1. Upload and purge material (Natural or next production) in an amount to eliminate most of the residue of dirty.
2. Empty the plasticizing group (**HOPPER AND BARREL**)
3. While the screw is turning put the sachets into the throat load (**WITHOUT OPENING**) (see **table above**) in line upload and purge with virgin material until **P&P CREAM™ SACHET** out of the nozzle
4. Stop the group units allow the **P&P CREAM™** for few minute.
5. Load and purge with Natural material to eliminate all residue removed by **P&P CREAM™**
6. If the system is not completely cleaned repeat Phase 2 to phase 5
7. Then start the new production .

### HOT RUNNERS:

- After the cleaning of the cylinder,screw and nozzle,
- Increase the Temperature of the hot runners as much as is allowed by the Material inside.
- At the mould open or moulding repeat: phase 1 to phase 6

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## P & P CREAM in SACHET

### EXTRUSION LINES

Processing temperature: 70°C - 420°C

Dosing: **P&P CREAM™ TABS** 2% of the barrel capacity (see table below)

**TABS: 20 gr**

Single screw extruder, L/D 30				Twin screw extruder, L/D 40			
Screw	mm	Barrel capacity	Nr Tabs	Screw	in mm	Barrel capacity	Nr Tabs
40		1,0 kg	1	30		1,0 kg	1
50		2,0 kg	2	40		2,0 kg	2
60		3,0 kg	3	50		4,0 kg	4
70		5,0 kg	5	60		7,5 kg	7
80		7,5 kg	7	70		10,0 kg	10
90		10,0 kg	10	80		20,0 kg	20
100		12,5 kg	12	90		30,0 kg	30
120		22,5 kg	22	100		37,5 kg	37
150		47,5 kg	47	120		52,5 kg	57
200		82,5 kg	82	130		77,5 kg	77
				150		100,0 kg	100

How to use **P&P CREAM™ TABS**

When cleaning keep the same parameters ( such as temperature, screw speed etc.) as the last material to be processed

### BARRELS , SCREWS AND DIES SYSTEMS

1. Upload and purge material (NATURAL or next production) in an amount to eliminate most the residue.
2. Empty the plasticizing group (**HOPPER AND BARREL** )
3. While the screws turning put the sachets into the throat of load (**WITHOUT OPENING** ) ( see **table above**) in line upload and purge with virgin material until **P&P CREAM™ TABS** out from the die
4. Stop the group units allow **P&P CREAM™** for few minute.
5. Load and purge with virgin material to eliminate all residue removed by **P&P CREAM™**
6. If the system is not completely cleaned repeat Phase 2 to phase 5
7. Then start the new production.

# PURGiNGiT

## P & P CREAM in SACHET

### TITLE: EXTRUDER SCREW, NOZZLE & MOLD CLEANING BY PURGINGIT

#### Procedure description for screw, barrel, and nozzle :

Extruder cleaning for different issues in the preforms:

- Color change, black spot, contamination, etc....

Extruder XFORM configuration :

E140 PET capacity 25kg, number sachets need for cleaning = 25

E120 PET capacity 15kg, number sachets need for cleaning = 15

When cleaning keep the same parameters (such as temperature, screw speed etc.) as the last process used

Activities:

- 1) Close the PET inlet to extruder
- 2) Purge extruder and shooting pot, in order to empty the plasticizing group
- 3) If used master batch switch off, and finish to purge with clear PET
- 4) Remove the feeding PET pipe connect to extruder
- 5) Insert to the screw the sachets 15 or 25 depend of the screw diameter
- 6) Attention that the sachets pass through the inlet extruder grid (see photo below)



- 7) Rotate the screw in order to move forward the sachets
- 8) Restore the feeding PET pipe connect to extruder
- 9) Open the feeding PET from the dryer
- 10) Start to plasticizing and purge until the PET out of the shooting pot nozzle and wait few minutes
- 11) Start extruder purge with clear PET until all the cream from sachets finish and comes clear PET
- 12) Finish and start production

#### **Procedure description for hot runner:**

Hot runner channel cleaning for different issues in the preforms:

- Color change, black spot, contamination, ecc....

After cleaning the screw as report in the procedure above.

Activities:

- 1) Close the PET inlet to extruder
- 2) Purge extruder and shooting pot, in order to empty the plasticizing group
- 3) If used master batch switch off, and finish to purge with clear PET
- 4) Remove the feeding PET pipe connect to extruder
- 5) Insert to the screw the sachets n° 10 from 72 to 144 cavities
- 6) Attention that the sachets pass through the inlet extruder grid
- 7) Rotate the screw in order to move forward the sachets
- 8) Restore the feeding PET pipe connect to extruder
- 9) Open the feeding PET from the dryer
- 10) Start to plasticizing and purge until the PET out of the shooting pot nozzle
- 11) Move forward the carriage in contact of mold inlet
- 12) Maintain the same work temperature in the manifold, and increase only nozzle temperature 10°C or 5 %  
(example from 280°C to 290°C)
- 13) Open the mold at the max stroke and put a cover protection in the cores side
- 14) Start to purge the mold in open mode
- 15) Continues to purge by open mold until out the cream with PET (see the photo below).
- 16) Wait 5 minutes in this conditions.
- 17) Continuous to purge until came out the clear PET
- 18) Go back to work temperature or % in the nozzle
- 19) Start preforms production



See also the movie : <https://youtu.be/px6mQQmMhPU>



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## P & P CREAM in SACHET

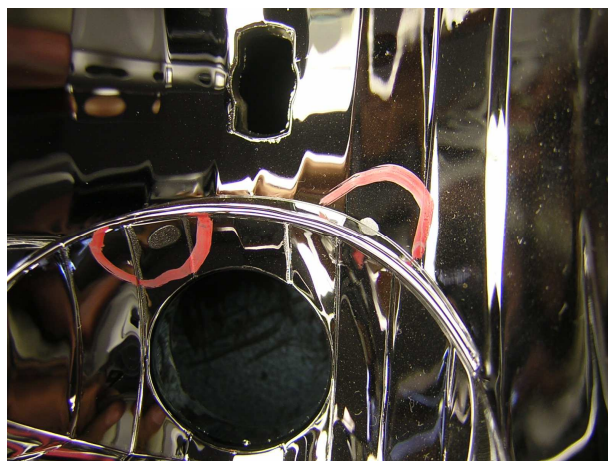
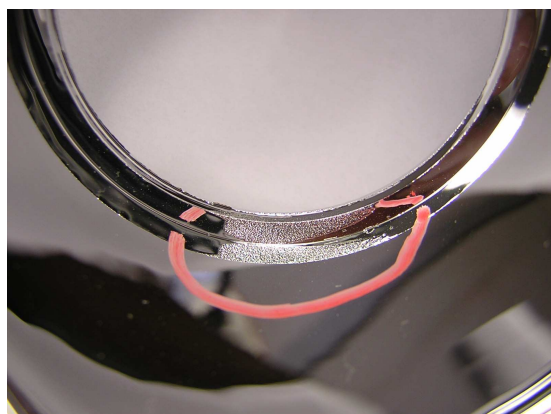
Cleaner in Cream , specific for cleaning and polishing moulds from residues, deposits, incrustations, etc. for all thermoplastics and thermosets. It is solvent-free, non-abrasive, nontoxic and odorless. All its components are (GRAS) Generally Recognised as Safe by the FDA

**User instructions: Temperature of use: min. 70°C max. 380°**

1. Put an amount of **P&P CREAM™** on a cloth and wipe it on the hot mould surface
2. If needs to repeat phase 1 until the surface will be perfectly polished and cleaned..

The test was made by a leading company in Automotive, on a mould for BMC (thermoset) – surface temperature of the mould: 160°C. The subsequent chroming phase reflects for automobiles the resin residues present on the reflectors plates, as can be seen in the photos encircled in red.

After cleaning the mould, with **P&P CREAM™** (time used: 10 sec. see instructions above), the production of headlight plates resumed with perfectly clean pieces, free of resin residues, absent after the chroming phase



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