

Basic procedure for changeover of materials / color

Set backpressure low, repeat metering and injection.

[After finishing the preceding molding]

01 Discharge the remaining material.

- Clean the hopper.
- Cylinder temperature remains the same

02 Add Celpurge into the hopper, repeat metering and injection.

- Set the metering position ca.30 mm and set backpressure to about 2 ~ 10%.
- After the cleaning is finished, allow one shot of Celpurge to remain in cylinder, and start preparation for the next molding. (Change temperature settings, mold, etc.)

03 Discharge Celpurge.

- Clean the hopper.
- Change the molding conditions for the next material.

04 Add the next material into the hopper and discharge Celpurge completely.

- Start molding with the next material.

Start molding with the next material.

In procedure02 , set the screw rotation speed / injection speed as high as possible, set the cushion as small as possible.

Example of changeover procedure

Material	Cylinder Temp	Metering Position	Screw rotation	Back pressure	Injection speed
01 Preceding material (PC resin)	280°C	50mm	40rpm	20%	40%
02 NX-VN2	Same as above	30mm	100rpm	2%	Same as above
04 Next material (ABS resin)	230°C	55mm	35rpm	15%	35%

◆Notes for usage

- Read SDS through before usage.
- Do not blend with other materials.
- Purged materials can cause smoke or fire, do not leave around combustible materials.
- For your safety, use protective equipments (gloves, goggles, etc.).
- Use Celpurge within operational temp. range.
- Use under well-ventilated conditions.