

### 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
<b>01</b> Preceding material (PC resin)	280°C	50mm	40rpm	20%	40%
<b>02</b> NX-VN2	Same as above	<b>30mm</b>	100rpm	2%	Same as above
<b>04</b> Next material (ABS resin)	<b>230°C</b>	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.