

Hot runner compatible grade cleaning inside the hot runner is possible

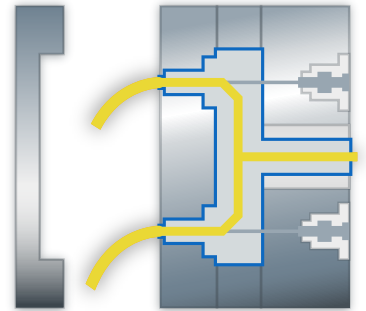
Ensure use of suitable grade for specific resin cleaning.

There are two methods, but the amount of Celpurge used is almost the same.

01 Air shot the Celpurge with the mold open

After molding the preceding resin, set the molding conditions as shown in the table below and repeat the measurement and injection. For valve gate type hot runners, open and close the gate during injection.

It is more effective to shorten the metering position and to open and close the gate.



Metering	Cylinder temperature	Screw rotation speed	Back pressure
10 - 15mm	Same as preceding material	50 - 70%	2 - 10%

* The injection pressure and injection speed have almost no effect on cleaning.

02 Mold Celpurge

After molding of the preceding resin, load and mold the Celpurge until the previous material is completely removed. Pay attention to the molding conditions so that the Celpurge will not be over molded.

Also, NX-A2 is more brittle than general molding materials, so take care when using molding dies with many bosses and ribs.

