

ASACLEAN BLOWN FILM PURGING INSTRUCTIONS

Notes before purging:

- Keep the barrel full of ASACLEAN at all times to prevent oxygen from entering the barrel – excess oxygen will accelerate material decomposition and carbon formation.
- Screens and dies may be left in place for purging with the ASACLEAN. In most cases the restricted flow can aid in the mechanical cleaning process.
- A bubble can normally be held while purging.

Purging Instructions:

1. Upon completion of the production run, continue running at production temperatures.
2. Feed 2 system capacities (barrel + die) of the ASACLEAN into the hopper.
3. Run the ASACLEAN through the system under normal processing conditions.
4. Immediately follow the ASACLEAN with the next production material.
5. Continue running until no traces of ASACLEAN can be observed in the bubble.
6. Start production.

Tips:

- If the purge is known to be particularly difficult, increase the temperatures in all zones downstream from the extruder to 230°C – 260°C (445°F - 500°F) and/or pre-flush with a natural, heat stable resin that is at least as stiff as the production resin.
- If heavy contamination is present, try ASACLEAN NCF.

Technical Questions?

To request detailed technical bulletins or technical support, contact us at Asahi Kasei Asaclean Americas Inc.

Phone: (800) 787-4348 / (973)257-1999

Website: www.asaclean.com

Fax: (973) 257-1011

E-mail: sales@asaclean.com