INSTRUCTIONS HOW TO USE "OK FAST CLEAN 10N250EA"

1. When you have finished with the first molding and want to go to the next mold using a different resin or color, make sure inside the cylinder is empty using the maximum safe back pressure.

2. Then feed 10N250EA into the cylinder within the temperature of 180 $^\circ$C to 240° C. (356°F ~ 464°F.), then hold 10N250EA inside the cylinder for about 3 minutes.

   (We recommend to hold 10N250EA inside the cylinder for about 3 minutes to have more time for 10N250EA to absorb the remaining color in the cylinder but it is your choice to do this or not.)

3. The amount of 10N250EA you feed into the cylinder should be 1 or 2 times of cylinder capacity. You can try with amount of 1 time barrel capacity first.

   Guideline of usage amount is as follows for Injection Molding machine:

   Clamp Force 100 tons machine   → 1 ~ 2 kg
   Clamp Force 500 tons machine   → 2 ~ 5 kg
   Clamp Force 1300 tons machine   → 5 ~ 10kg

4. Then, repeat   purge → full suck back → purge with maximum safe back pressure to purge out the remaining material and 10N250EA completely from the cylinder.   (You can do this using "auto purge" if your machine has an "auto purge" function).

5. After 10N250EA begins coming out of the nozzle, increase the screw speed to the maximum safe level.   Then, drop the back pressure after the 10N250EA coming out of the nozzle becomes almost clean.

6. Start feeding the next molding resin into the barrel to purge out the remaining 10N250EA completely from the cylinder, with maximum safe back pressure and screw speed with the screw completely forward.

CAUTION : 10N250EA is not suitable to remain inside the barrel for a long time (it will become solid and hard). Purge out 10N250EA completely from the barrel. When you shut down the machine, make sure to purge out 10N250EA completely from the barrel.