

INSTRUCTIONS HOW TO USE “OK FAST CLEAN INJ#004A”

1. When you finished the first molding and want to go to the next molding using the different resin or color, first please make inside the cylinder empty using the maximum safe back pressure.
2. Then please feed INJ#004A into the cylinder within the temperature of 150 °C to 300° C. (300°F ~ 570°F). You can keep INJ#004A in the cylinder as long as you need.
3. The amount of INJ#004A 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, please repeat purge → full suck back → purge with maximum safe back pressure to purge out the remaining material and INJ#004A completely from the cylinder. (You can do this using “auto purge” if your machine has “auto purge” function).
5. After INJ#004A begins coming out from the nozzle, increase the screw speed to the maximum safe level. Then, drop the back pressure after INJ#004A coming out from the nozzle becomes almost clean.
6. Start feeding the next molding resin into the barrel to purge out the remaining INJ#004A completely from the cylinder with maximum safe back pressure and screw speed with the screw completely forward.
7. You can use INJ#004A with Hot Runner Mold.

CAUTION : INJ#004A is not suitable to remain inside the barrel for a long time (it will become solid and hard). Please purge out INJ#004A completely from the barrel. When you shut down the machine, please make sure to purge out INJ#004A completely from the barrel before shutting down.