

PLASTRONCLEAN R+EF

Application:

Ready to use MB for cleaning purposes and protecting the extrusion chamber against oxygen by a freezing compound. Especially recommended for: PS, SAN, ABS, PVC, PMMA, POM and polyamides. For cleaning up polyolefin PLASTRONCLEAN PO is recommended. As freezing compound it can be used for all thermoplastic resins. Suitable for extrusion lines, injection moulding machines and blow moulding lines as well. Deposits of polymers and additives will be removed and dispersed in the melt, therefore shut-off nozzles, melt filters etc. do not have to build out for the cleaning step. Also gear pumps in extrusion lines and hot runner in injection moulding machines do not have to be removed during cleaning.

Active Ingredients:

Cleaning additives and inorganic matters with very small particle size

Carrier:

PP with very high viscosity

Physiology:

the components comply with the European Regulations

Supplied as:

greyish granules

Processing indication:***Cleaning:***

- 1) Empty the extruder and the feed hopper
- 2) Increase the temperature profile around 15 °C
- 3) Plasticise about 50% of the recommended amount of PLASTRONCLEAN R+EF at reduced screw speed
- 4) Stop the line and let react the PLASTRONCLEAN R+EF for 10 to 15 minutes
- 5) Fill in the rest of the PLASTRONCLEAN R+EF in the hopper and empty the line without further stop
- 6) Fill the wished polymer in the hopper, readjust the temperature profile to the standard values.
- 7) Purge the line with your material to remove the small remaining amount of the PLASTRONCLEAN R+EF

Freezing:

- 1) Fill in the total amount of recommended master batch in the hopper before it has been emptied of your material.
(Avoiding admission of oxygen into the line)
- 2) Do not increase the temperature profile!
- 3) Plasticise the PLASTRONCLEAN R+EF at reduced screw speed.
- 4) Stop the line before emptying the hopper
- 5) Stop the heating
- 6) Starting production: start the line as soon as the temperature profile reaches his settings. Purge with your chosen material the rest of the PLASTRONCLEAN R+EF out of the line.

Processing temp.:

300 °C; 330°C for 20 minutes possible

Dosage:**Cleaning:**

screw diameter [mm] injection or blow moulding machine	Recommended Quantity [kg]
15	0.3
22	0.4
30	1.0
35	1.4
40	2.0
50	3.9
60	6.9
70	11.0
80	15.0
90	26.0
100	32.0
120	54.0

The information given in this data sheet is based on many years of practical experience. Nevertheless can it only be a recommendation and a basis for practical testing, where the optimum dosage has to be determined individually.

Freezing:

The required quantity depends not just from the screw diameter but also from the screw length and the whole melt contacted equipment. Therefore no values can be given.

The quantity will be determined by filling a weigh out quantity of PLASTRONCLEAN R+EF in a container. During running line PLASTRONCLEAN R+EF is filled in the hopper until the material is leaving the nozzle. Now the used amount of PLASTRONCLEAN R+EF can be calculated by reweighing the container.

All information given herein is only a recommendation. Its use shall remain the sole responsibility of the customer. No patent guarantee whatsoever shall be implied.