

RAMCLEAN 204

User Instructions - Injection molding

Safety: When performing these procedures, it is the machine operators responsibility to know their company's safety policy, machine safety operating parameters, and wear appropriate protective safety equipment.

For cleaning cylinder, screw, die and mold

1. Stop feeding the extruder with the material in use.
2. Clean the Hopper and around it very carefully.
3. Clean the color dispenser (if exists). If possible, shut it down and remove it.
4. Empty the extruder.
5. Raise working temperatures by 10°C.
 - For heat sensitive materials, do not raise temperatures more than those recommended by the resin manufacture.
6. Raise the Back pressure to the highest safe level.
7. Start filling **RAMCLEAN 204** until it flows out from the mold, using 30-40% the regular RPM.
8. Stop the screw and let **RAMCLEAN 204** sit for 5-15 minutes.
 - For heat sensitive materials, don't stop for more than 5 minutes.
9. Dismantle and clean the "die" if necessary (dirty, not smooth, not original, with contamination).
10. Start purging out **RAMCLEAN 204**: **a)** By injecting it through the opened mold at a low injection pressure.

Or b) By closing the mold and injecting products at half the weight.
11. If contaminants are still visible after most of **RAMCLEAN 204** is flushed out, add more and repeat steps 4 to 9.
12. Add the next material to use and continue injecting half weight parts until all **RAMCLEAN 204** is out.
13. Resume production using normal production settings.

Quantities recommended:

Machine capacity (Clamping force) - TON	Quantity of Ramclean - KG
75 t	0.5
150 t	1.0
400 t	3.0
650 t	5.0
800 t	8.0
1300 t	12.0
2300 t	20.0

These instructions are general guidelines. Purging of different materials/technology may require slight adjustments of quantity and process to achieve maximum efficiency.

RAMCLEAN 204

User Instructions - Extrusion molding

Safety: When performing these procedures, it is the machine operators responsibility to know their company's safety policy, machine safety operating parameters, and wear appropriate protective safety equipment.

1. Stop feeding the extruder with the material in use.
2. Clean the hopper and around it very carefully, it is essential for the success of the whole cleaning procedure.
3. Empty the extruder.
4. Raise working temperatures by 10°C.
 - For heat sensitive materials, do not raise temperatures more than those recommended by the resin manufacture.
 - For flat die, raise the temperatures at the sides of the die 10°C higher than at the center.
5. Remove screen pack.
6. Start adding **RAMCLEAN 204** until it flows out from the die.
7. Stop the screw and let **RAMCLEAN 204** sit for 5-10 minutes.
 - For heat sensitive materials, don't stop for more than 5 minutes.
8. Resume screw rotation and start flushing out **RAMCLEAN 204** at low screw speed, after 2 minutes- increase the screw speed.
9. If contaminants are still visible after most of **RAMCLEAN 204** is flushed out, add more **RAMCLEAN 204** or repeat steps 4 to 7.
10. Add the next production resin and flush out the remaining of **RAMCLEAN 204**.
11. Install the screen pack, adjust temperature and screw settings for the production resin and continue with production.

Quantities recommended:

Machine capacity (Screw diameter) -mm Ø	Quantity of Ramclean - Kg SINGLE SCREW L/D 30	Quantity of Ramclean - Kg DOUBLE SCREW L/D 40
40 mm	2.0	4.0
60 mm	4.0	8.0
80 mm	8.0	20.0
100 mm	16.0	45.0
120 mm	25.0	70.0
160 mm	45.0	130.0

These instructions are general guidelines. Purging of different materials/technology may require slight adjustments of quantity and process to achieve maximum efficiency.