

# RAMCLEAN 600

## User Instructions

**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 10C.
  - 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 600** until it flows out from the die.
7. Stop the screw and let **RAMCLEAN 600** sit for 5-10 minutes.
  - For heat sensitive materials, don't stop for more then 5 minutes.
8. Resume screw rotation and start flushing out **RAMCLEAN 600** at low screw speed, after 2 minutes- increase the screw speed.
9. If contaminants are still visible after most **RAMCLEAN 600** is flushed out, add more **RAMCLEAN 600** or repeat steps 4 to 7.
10. Add the next production resin and flush out the remaining of **RAMCLEAN 600** .
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.**