hales®
Tooling Components & Industrial Supplies

MOULDING SUPPLIES
PURGE

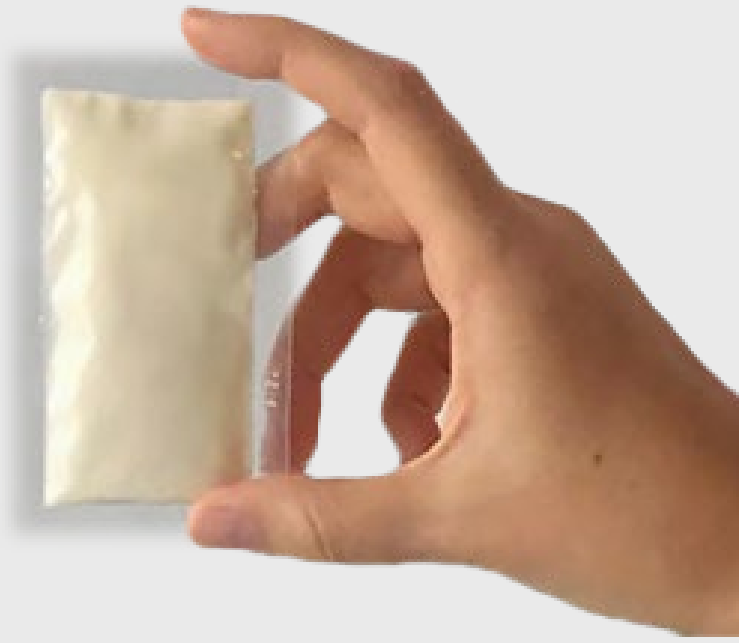
HALES PURGE

USAGE INSTRUCTIONS

Hales Purge – The new era of purging and polishing!

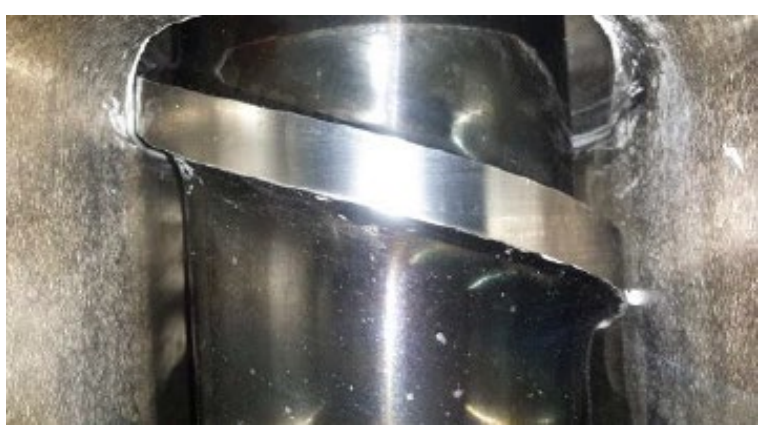
With a working temperature between 70 ° C and 420 ° C, Purge is specifically for cleaning screws, cylinders,
nozzles, hot runners, extrusion dies, moulds and any metal surface, enabling the removal of charred residue, black spots, colored pigments and all left over material deposits. For all thermoplastic , thermosetting and rubber.
Purge cleans instantaneously unlike other products that take longer and leave material traces.
Purge is smokeless, odourless and doesn't contain solvents or abrasives. All components of Hales Purge (P&P CREAM™) are " GRAS
" (Generally Recognized as Safe) by FDA and Food Contact Certified.
Purge is the only one that can purge ABS, PA, PET, PS, PMMA, PC, SAN, PVC, EVA, PU, TR, PBT, PPO,PPS, PPA, PP, PE,
SBR , EPDM, BMS, FPM and SILICONE

- Mould Cleaning
- Plastic Injection Moulding
- Extrusion Lines



BEFORE

AFTER



How to use - Mould Cleaning

P&P Clean is specific for cleaning and polishing moulds from residues, deposits, incrustations, etc.
For all thermoplastics and thermosets. It is solvent-free, non-abrasive, nontoxic and odourless.
All its components are (GRAS) Generally Recognised as Safe by the FDA
Temperature of use: min. 70°c - max. 380°c
1. Put an amount of P&P Cream™ on a cloth and wipe it on the hot mould surface
2. If needed, repeat phase 1 until the surface is perfectly polished and cleaned.

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MOULDING SUPPLIES

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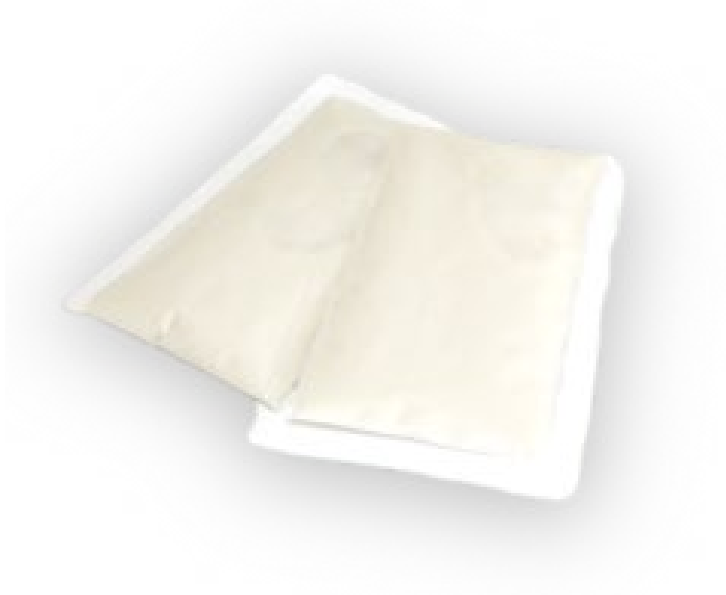
How to use - Plastic Injection Moulding

Processing temperature: 70°c – 420°c
When cleaning keep the same parameters (such as temperature, screw speed etc.) as the last material to be processed and empty and clean of old material.
BARREL , SCREW, NOZZLE and HOT RUNNERS
1. Purge with virgin or next production material.
2. Empty the hopper and barrel
3. Whilst the screw turns put into the throat the required unopened P&P Cream Sachets as per the chart and purge with virgin material until the Purge comes out of the nozzle.
4. Stop the machine for a few minutes
5. Continue to purge with the virgin material to eliminate all residue that has been removed by P&P Cream
6. If the system needs, repeat Phase 2 to phase 5
7. Start production.

HOT RUNNERS:
After the cleaning of the cylinder, screw and nozzle, increase the temperature of the hot runners as much as allowed by the material inside.
At the mould open or moulding repeat: phase 1 to phase 6



Injection Moulding Machine	Barrel Capacity	Sachets Required
50 Tonn	0.2 Kg	1
100 Tonn	0.5 Kg	1
200 Tonn	1 Kg	1
400 Tonn	2 Kg	2
600 Tonn	3 Kg	3
800 Tonn	4 Kg	4
1000 Tonn	5 Kg	5
1500 Tonn	7.5 Kg	7
2000 Tonn	10 Kg	10

How to use - Extrusion Lines

Processing temperature: 70°C – 420°C
When cleaning keep the same parameters (such as temperature, screw speed etc.) as the last material to be processed and emptying and clean from old material.
BARREL, SCREW and DIE SYSTEMS
1. Purge enough material (virgin or next production material) to eliminate previous material
2. Empty the hopper and barrel
3. Whilst the screw turns put the unopened P&P Cream sachets, as per the chart, into the throat and purge with virgin material until the P&P Cream comes from the nozzle
4. Stop the machine and leave for few minutes
5. Purge it with the virgin material to eliminate all residue removed by the P&P Cream
6. If the system needs it, repeat Phase 2 to phase 5
7. Then start the new production

SINGLE SCREW EXTRUSION, LD 30		
Screw (mm)	Barrel Capacity	Sachets Required
40	1.0 Kg	1
50	2.0 Kg	2
60	3.0 Kg	3
70	5.0 Kg	5
80	7.5 Kg	7
90	10.0 Kg	10
100	12.5 Kg	12
120	22.5 Kg	22
150	47.5 Kg	47
200	82.5 Kg	82

DOUBLE SCREW EXTRUSION, LD 30		
Screw (mm)	Barrel Capacity	Sachets Required
30	1 Kg	1
40	2 Kg	2
50	4 Kg	4
60	7.5 Kg	7
70	10 Kg	10
80	20 Kg	20
90	30 Kg	30
100	37.5 Kg	37
120	52.5 Kg	57
130	77.5 Kg	77
150	100 Kg	100