

Instruction manual for hot runners

Operating instructions for cleaning for cleaning hot runners

1. All hot runners (valve gates, open nozzles, ...) can be cleaned with the cleaning concentrates from ver-rus.
2. Raise the nozzle temperatures to maximum depending on the material. This allows the chemical, swelling cleaning mixture to penetrate deep into the insulating area at the nozzle tip and dissolve the previous material/paint and purge it out during restart.
3. Depending on the difficulty of the application, mix 0.5%–3% of the cleaning concentrate into the cold granulate, regrind or recycle. Use 3% in difficult cases and 1.5%–2% in normal applications.
4. Fill the cleaning mixture into the hopper (do not draw in via the conveyor).
5. Inject the cleaning mixture into the hot runner with open mold until it comes out of the nozzles. This can be recognized by the foamy material structure. If this is not possible, parts can also be produced with it.
6. Stop the machine for 5–15 minutes. In this time the cleaning mixture will foam up, reach clean all flow dead zones of the hot runner.
7. Dose the cleaning mixture again, inject it into the hot runner and assess the injected material/parts.
8. If the result is not satisfied, repeat the process again.