

## Instruction manual for Injection molding

Operating instructions for cleaning the plastification unit Injection molding

1. Interrupt the material supply
2. Empty the barrel
3. Prepare the cleaning mixture as follows and fill it into the hopper (do not draw in via the conveyor):
4. Depending on the difficulty of the application, mix 0.5%–3% of the cleaning concentrate into the cold granulate, regrind or recyclat. In difficult cases use 3% and in normal applications use 1.5%–2%
5. Set the back pressure to max. so that the screw tip stops at the machine nozzle.  
(metering stroke = 0)
6. Let the screw rotate until the cleaning mixture emerges from the machine nozzle. This can be recognized by the foamy material structure
7. Stop the machine for 5–15 minutes. In this time the cleaning mixture will foam up, reach and clean all death zones
8. Let the screw rotate again and evaluate the extruded material
9. If the result is not satisfied, repeat the process again
10. To clean the rear barrel area, dose up to the maximum metering stroke and stop the machine for 5–15 minutes
11. Inject the cleaning mixture and evaluate the material
12. If the result is not satisfied, repeat the process again