

Z CLEAN® A1

Excellent results for General Purpose Resins

Technical Bulletin

NISSHO Corporation, Inc.

1. Product Features

- Just a small amount of **Z Clean** is all that is required to perform a **Time Saving** cleaning procedure.
- **Pellet form** for ease of handling and Z Clean creates **No odor or Smoke** under use temperatures.
- **Z Clean** contains **No Abrasives**; that could damage or wear the Screw, Barrel or Die.

2. Applicable Machine Types

- Injection Molding Machines
- Extruders (for compounds, for cleaning with a screw removed)

3. Applicable Resins

- Polyethylene (**PE**), Polypropylene (**PP**)
- Acrylonitrile-Butadiene-Styrene Copolymer (**ABS**), and other General Purpose Plastics

4. Working Temperature Range: 180°C - 300°C (356°F - 572°F)

5. Application - Injection Molding Machine

Size of Molding Machine and Standard Amount of **Z CLEAN A1** to use:

Clamping Pres. (tons)	50	100	200	650	1,300
Amount Z Clean (lbs)	0.6	1.5	3	6	10

Procedure

Precautions

Discharge all proceeding Resin

- No need to change the cylinder temperature setting.
- Cut off the vacuum if a vent type applies.



Feed "Z CLEAN A1" into the hopper
(Amount: 5 – 10 Shots)

- Clean the hopper and feedthroat when dry color is used.

- Since the amount of **Z CLEAN** is variable by the machine condition and the color applied, use a rather large portion of it when a Flame Retardant resin is molded.



Purge by Rotating the Screw

- Remove the nozzle from the mold and advance the screw.
- Purge with the screw rotating at maximum back pressure until **Z CLEAN** comes out.



Measuring and Purging

- Purge at a High Speed (5 – 10 Shots)



Charge of Succeeding Resin



Measuring and Purging

- Purge at a High Speed, until the color of the succeeding resin comes out.



Pulsing

- Purge controlling the stroke at 20-30 mm with the back-pressure off.



Confirmation

- Confirm the cleaning by molding with the nozzle attached to the mold.



Completion of Cleaning

6. Precautions for Use

- When a high-flow succeeding resin with MFR of 20 or more is used, mix **Z CLEAN A1** with the succeeding resin for quicker replacement.
- When purging hard to remove pigments, such as copper phthalocyanine blue or yellow organic pigments, increase the temperature to **270 °C (518°F)** or above for improved purging.
- When the molding machine is severely stained or if using Z Clean for the first time, use more purging agent than usual (10 – 15 shots).

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