

# **Z CLEAN® E1500 & E1600**

**High Flow Type of Purging Compound  
Excellent for Running Changes**

**Technical Bulletin**

**NISSHO Corporation, Inc.**

## 1. Introduction

**Nissho Corporation** has developed **two unique, new grades** of **Z Clean** for **High flow, High cycle** type injection molding or fiber extrusion applications, when it is desirable to perform running color or material changes efficiently and effectively.

**Z Clean E1500 & E1600** grades are **Moldable** types of purge, which are safe for “Hot Runner” systems, for **through-mold purging** and can be **extruded without removing the screen pack**.

**Z CLEAN E1500 & E1600** are non-filler, non-foaming types of purging agents and the purging **scraps can be recycled** as a raw material.

## 2. Features of “Z Clean E1500 & E1600”:

- Non- Filler, Non-Foaming type purging agent with a **HDPE** base carrier resin.
- Purging can be carried out without stopping the machine while the product is being taken up continuously.
- **Z CLEAN E1500 & E1600** will not cause packing or clogging of the screen pack.
- Burnt and foreign matters stuck on the screw and a die can effectively be removed.
- Working temperatures: **180°- 250° C (356° - 480° F)** for **L-LDPE**  
**150°- 180° C (302° - 356° F)** for **PVC**.

**MFR: E1500 = 27.0    E1600 = 37.0**

- All the components are registered with the Conference for Japan Hygienic Olefin and Styrene Plastics Association (**JHOSPA**).

## 3. Applications:

- **High flow, High cycle type purge for injection machines with Hot Runner systems**
- **Fiber Extrusion**

## 4. Applicable Resins:

- **PP, LDPE, L-LDPE, HDPE, HARD-PVC**

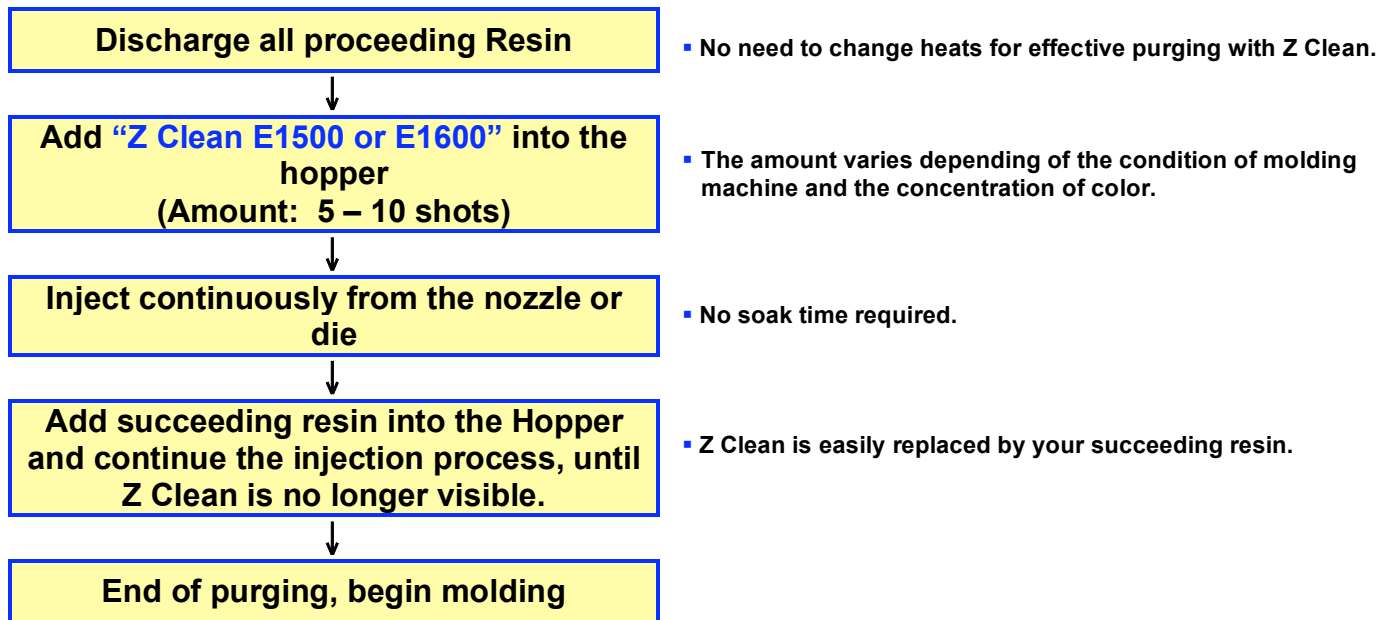
## 5. Precautions for Use:

- When purging **PVC** do not exceed a temperature of **180° C / 356° F**
- For extrusion purging, begin at 2/3 of your normal screw speed; then, gradually raise the screw rotation making sure that the increases in motor amperage and resin pressure are **within safe operating levels**.

## 6. General Operating Procedure:

### Injection Molding Machine

Use “Z Clean E1500 or E1600” according to the procedure shown below.



### Note: Relationship between machine size and amount to be added

Clamping Pressure (ton)	80	200	650
Amount to be added (kg)	0.8 – 1.5	2.0 – 4.0	5.0 – 10.0
Amount to be added (lb)	1.5 – 3.5	4.0 – 8.0	11.0 – 22.0

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