

ND CLEANING AGENT 01121

Compound in granules, **not abrasive and activated by heat**, that carries out a complete cleaning action (colour and polymer change, elimination of carbon build-ups and other impurities in the cylinder, dies and hot runners). It works by breaking down the polymers' macromolecules, thus reducing viscosity and making the removal of the melted mass easier.

Thanks to the use of the VIBATAN PURGE, your equipment will always be perfectly clean.

VIBATAN CLEANING AGENTS are supplied in kg 25 bags.

VIBATAN CLEANING AGENTS

VIBATAN	LDPE	LLDPE	EVA	HDPE	PP	PVC	PS	ABS	SAN	PC	PA	PMMA	PET
ND CLEANING AGENT 01121	✓	✓	✓	✓	✓	✓							
ND CLEANING AGENT 01102							✓	✓	✓	✓	✓	✓	✓
ND/PE CLEANING AGENT 01113	✓	✓	✓										

IN CASE OF OTHER APPLICATION THAN THE ONES HEREIN SUGGESTED, IT IS HIGHLY RECOMMENDED TO CONTACT VIBA CUSTOMER ASSISTANCE BEFORE USING THE PRODUCT. VIBA WILL NOT BE HELD RESPONSIBLE FOR PRODUCTION PROBLEMS DUE TO USE OF THE PRODUCT OTHER THAN THOSE MENTIONED ABOVE.

INSTRUCTIONS

SHEETS/COMPOUND EXTRUSION AND CO-EXSTRUSION	SECTION A
FILM EXTRUSION AND CO-EXSTRUSION	SECTION B
INJECTION MOULDING AND HOT RUNNER MOULD	SECTION C

ND CLEANING AGENT 01121

Section A

SHEET AND COMPOUND EXTRUSION

1. Increase temperature by 40° - 50° C if compared to normal processing conditions only in the extruder die or head (all the group after the screw).
2. If the gas relief pump is available on the equipment, it has to be disconnected and the cylinder vented barrels have to be capped. **Moreover, remove eventual filters.**
3. When changing colour, run some natural polymer to dilute the concentration of pigments in the cylinder.
4. Feed VIBATAN PURGE at normal screw revolution speed with the shovel directly on the screw (move the hopper aside or use another feeding area).
5. When VIBATAN PURGE is observed coming out of the head, **reduce screw speed to the lowest number of revolutions** and keep feeding the cleaning agent manually for:
 - a) colour or polymer change 20 minutes
 - b) elimination of carbon built-ups or other impurities 30 minutes
6. After that, **increase screw speed as during the production cycle** and drain completely the equipment.
7. Stop the equipment for 5 minutes.
8. Run new material until all traces of VIBATAN PURGE have been completely removed.
9. Set the equipment at normal temperature and start production.

ND CLEANING AGENT 01121

Section A

SHEET AND COMPOUND CO-EXTRUSION

All the systems have to run with the VIBATAN PURGE during the soak cycle.

If you desired to eliminate carbon build-ups or other impurities in only one layer of the co-extrusion heads or in only one cylinder, the above mentioned operations must be carried out only on the chosen production line.

During purge procedure, run natural material slowly through extruders not being purged.

Important When purging a temperature sensitive material like ABS, PVC, POM, cellulose acetate, etc. at least two soaks are necessary.
The first soak must be done accordingly to the usual instructions at operating temperature and the second by increasing head's temperature by 40 - 50° C.

ND CLEANING AGENT 01121

Section B

FILM EXTRUSION

1. Increase temperature by 40° - 50° C if compared to normal processing conditions only in the extruder die or head (all the group after the screw).
2. When changing colour, run some natural polymer to dilute the concentration of pigments in the cylinder.
3. Feed VIBATAN PURGE at normal screw revolution speed with the shovel directly on the screw (move the hopper aside or use another feeding area).
4. When VIBATAN PURGE comes out of the head, **reduce screw speed to the lowest number of revolutions** and keep feeding the cleaning agent manually for:
 - a) colour or polymer change 20 minutes
 - b) elimination of carbon built-ups or other impurities 30 minutes
5. After that, **increase screw speed as during the producing cycle** and drain completely the equipment.
6. Stop the equipment for 5 minutes.
7. Run new material until all traces of VIBATAN PURGE have been completely removed.
8. Set the equipment at normal temperature and start production.

ND CLEANING AGENT 01121

Section B

FILM CO-EXTRUSION

All the systems have to run with the VIBATAN PURGE during the soak cycle.

If you desired to eliminate carbon build-ups or other impurities in only one layer of the co-extrusion heads or in only one cylinder, the above mentioned operations must be carried out only on the chosen production line.

During purge procedure, run natural material slowly through extruders not being purged.

Important When purging a temperature sensitive material like ABS, PVC, POM, cellulose acetate, etc. at least two soaks are necessary.
The first soak must be done accordingly to the usual instructions at operating temperature and the second by increasing head's temperature by 40 - 50° C.

ND CLEANING AGENT 01121

Section C

INJECTION MOULDING

1. Increase temperature by 40° - 50° C if compared to normal processing conditions **only at the end of the cylinder and nozzle.**
2. When changing colour, run some natural polymer to dilute the concentration of pigments in the cylinder.
3. Move the hopper-bottom car aside and feed VIBATAN PURGE from the hopper with a shovel, drawing it at the normal screw revolution speed during production cycle.
4. When VIBATAN PURGE comes out of the head, **stop the press for 15-20 minutes.**
5. Every minute inject and replace VIBATAN PURGE coming out always with the new rapid VIBATAN PURGE, from the hopper with a shovel.
6. After 15-20 minutes empty the screw and keep the equipment stopped for 5 minutes.
7. Set the normal temperature and run natural polymer until all traces of VIBATAN PURGE have been removed.
8. Start new production.

ND CLEANING AGENT 01121

Section C

CLEANING OF HOT RUNNER MOULD

VIBATAN PURGE enables to clean also the runners in the multi-track moulds.

In this case, when cleaning the screw, increase the temperature in mould to the melt temperature of the polymer processed before.

Then, inject VIBATAN PURGE in the mould and wait for 10 minutes keeping the mould closed.

Repeat this operation twice and this part of the system will be perfectly clean.