



aquapurge

purging with the
professionals



plastribution
let's make it work.

Barrel Blitz Universal P Instructions

	Page
Start Up Instructions Removal of Loosened Carbon through a Screw and Barrel	2
Material Change Instructions Standard material/colour change instructions	3
Strip-Down Instructions Standard screw and barrel Strip-Down instructions	4
Clear Material Changes Special instructions for high temperatures	5
Safety Information General Safety Information, refer to Health and Safety Document for full information	7

**DO NOT USE THROUGH FILTER NOZZLES OR
HOT RUNNERS**

Special Instruction for very small Screws



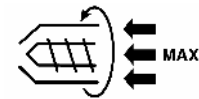
Plastribution Limited,
CEVA House,
5 Ashby Park,
Ashby-de-la-Zouch,
Leicestershire LE65 1NG

Barrel Blitz Universal P Start-up Instructions

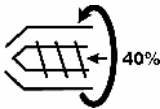
Explanation: Barrel Blitz Universal P is an aggressive, stiff carbon removal system. It is designed to mechanically scrape carbon off screws, barrels and nozzles at normal processing temperatures. Ensure Health & Safety Precautions are read and understood before use.



Ensure Machine is empty of last material

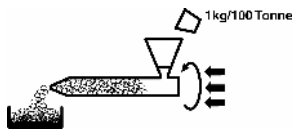


Increase Back Pressure to Maximum



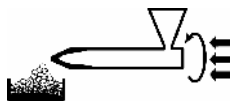
Run Screw Speed at 40% of Maximum

For very small screws add Barrel Blitz Universal P to your next material at 50/50 mix rate



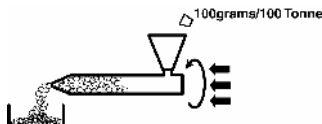
Initially dose 1 kg per 100 Tonne of Machine
(i.e. 500 Tonne = 5 kg)

Inspect the purge (it should be brilliant white), if carbon choked, repeat above procedure until clear.



(STARVE)

Run Screw empty



(FEED)

Fill Hopper Throat with 100g/100Tonne of **next** material

Repeat STARVE-FEED three times

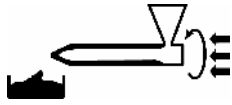


Fill Hopper with next material and purge till clear

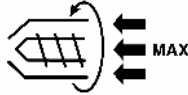


Clean Hopper and Screw Throat thoroughly

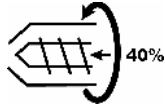
Barrel Blitz Universal P Changing Instructions



Ensure Machine is empty of last material

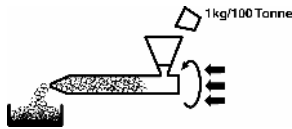


Increase Back Pressure to Maximum



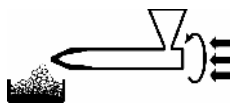
Run Screw Speed at 40% of Maximum

For very small screws add Barrel Blitz Universal P to your next material at 50/50 mix rate

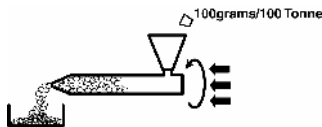


Initially dose 1 kg per 100 Tonne of Machine
(i.e. 500 Tonne = 5 kg)

Inspect the purge (it should be brilliant white), if carbon choked, repeat above procedure until clear.



(STARVE)
Run Screw empty



(FEED)
Fill Hopper Throat with 100g/100Tonne of **next** material

Repeat STARVE-FEED three times



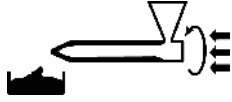
Fill Hopper with next material and purge till clear



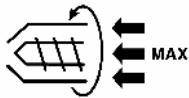
Clean Hopper and Screw Throat thoroughly

Barrel Blitz Universal P Strip-Down Instructions

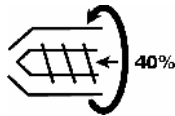
Explanation: Barrel Blitz Universal P is an aggressive, stiff carbon/material removal system. It is designed to mechanically scrape carbon and material off screws, barrels and nozzles at normal processing temperatures (Upto 370°C). **It is imperative that after purging with Barrel Blitz Universal P the temperatures are reduced to a maximum of 220°C and another barrel full of Barrel Blitz Universal P is purged before disassembly.**



Empty Machine of last material

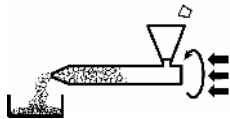


Increase Back Pressure to Maximum

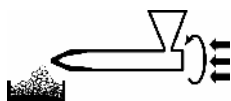


Run Screw Speed at 40% of Maximum

For very small screws add Barrel Blitz Universal P to your next material at 50/50 mix rate



Dose **Barrel Blitz** until clear



(STARVE)

Run Screw **COMPLETELY** empty

Return back pressure and screw speed to standard settings

Reduce temperature to 220°C and purge one shot of Barrel Blitz Universal P



Clean Hopper and Screw Throat thoroughly

Strip equipment and ensure all Barrel Blitz Universal P has been removed **HOT** before reassembly. If hot, Barrel Blitz Universal P normally only requires rubbing with a rag to remove.

Barrel Blitz Universal P Clear Material Change Instructions

Explanation: Barrel Blitz Universal can be used on almost all types of high temperature and clear materials, but having a PP carrier certain procedures need to be followed; one of which is to ensure that the last purge is carried out at “Non-Sticky” processing temperatures (220⁰C/428⁰F) and another is to ensure there is adequate ventilation.

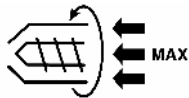


Ensure heats are running at less than 370⁰C (698⁰F) and no more than the current processing temperatures

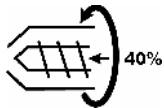
Place card or other suitable receptacle in the purge tray to catch the very sticky purge



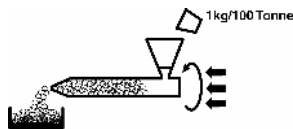
Ensure machine is empty of last material



Increase back pressure to maximum

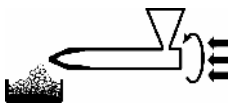


Run screw speed at 40% of maximum



Initially dose 1 kg (2.2lb) per 100 Tonne of Machine
(i.e. 500 Tonne = 5 kg (11lb))

Inspect the purge (*it should be brilliant white*), if evidence of previous colour or material, repeat above procedure until clear.



(STARVE)

Run Screw empty

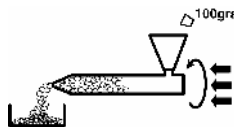
Reduce heats to 220⁰C (428⁰F) and repeat the previous procedure (**“Non Sticky” Temperature**)

This will ensure the screw is both clean and as empty as possible



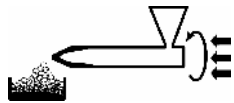
Barrel Blitz Universal P Clear Material Change Instructions Continued

You can now change the temperature profile to the next materials processing set up



(FEED)

Fill Hopper Throat with 100g (3.5oz)/100 Tonne of **next** material



(STARVE)

Run Screw empty

Repeat STARVE-FEED three times



Fill Hopper with next material and purge till clear



Clean Hopper and Screw Throat thoroughly

Read and understand Health and Safety before use

Safety Precautions

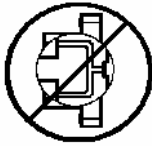


Do not use Barrel Blitz Universal P for materials with processing temperatures below 160⁰ C



Do not use Barrel Blitz Universal P at temperatures above 370⁰ C

Not suitable for machines with nozzle filters, mixers, screens or diameters smaller than 2.5 mm



It is NOT recommended that Barrel Blitz Universal P is used through tools (hot runners, manifolds etc.)

For very small screws add Barrel Blitz Universal P to your next material at 50/50 mix

Always purge behind a purge guard

Ensure adequate ventilation especially at elevated temperatures



Wear suitable protective clothing when cleaning down equipment, using, handling or viewing the purging agent



If contact with skin occurs, wash with cool water



In case of eye contact, irrigate with plenty of cool water



Do not swallow product



In situations of excessive sheer heat place purgings in cool water to eliminate fumes