PURGING AGENT (CLEANING AGENT FOR PLASTIC MOLDING MACHINES)

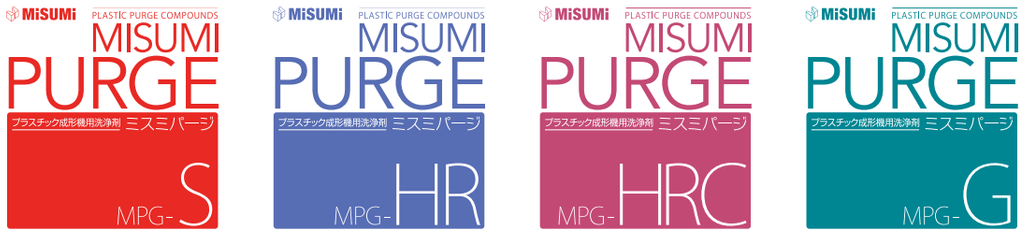
■ MISUMI Purge

MPG—S
For normal resin

MPG—HR
For engineering plastic and super engineering plastic

MPG—HRC
For engineering plastic and super engineering plastic
(With fragrance)

MPG—G
For engineering plastic and super engineering plastic
(With glass filler)



Part Number	Quantity (per 1 bag)	Operating temperature	Filler	Characteristics	Applicable resin	1 bag	2~9 bags	10 bags or more
MPG—S	20kg * The order unit is per 1 bag	170~320℃	None	For normal resin. As it does not contain any filler, it does not damage screws and cylinders.	PE, PP, PS, ABS, AS, PMMA, PVC(P), POM(P)	Quotation		
MPG—HR		180~370℃	Inorganic filler (Non-glass)	For engineering plastic and super engineering plastic resin. As glass filler is not used, it reduces wear on screws and cylinders.	PA6, PA66, PC, PET, PBT, m-PPE, PPS, PSF, PPO, LCP			
MPG—HRC				A purging agent with soap fragrance for people who are sensitive to smells. For engineering plastics and super engineering plastics, with the same detergency and resin as MPG-HR.				
MPG—G		200~380℃	Glass filler	As it contains glass filler, it is suitable for washing persistent dirt such as carbides adhered to screws and cylinders. For engineering plastic and super engineering plastic resin.				

(P)PVC generally has a molding temperature of under 170°C, but increase the purge temperature to around 170°C.
(P)Although POM is an engineering plastic, it has a low molding temperature as a rule, so we recommend the use of MPG-S.

Order | Part Number: MPG—HR | Days to Ship: Quotation

(P)Package is 20 kg/bag. The order unit is per bag.
For example, to order 200 kg, set the quantity to 10.

■ Instructions

1. **Discharge previous resin** — Discharge all the resin molded inside the cylinder.
2. **Clean hopper** — Check firmly whether there is any resin still left inside the hopper or not.
3. **Pour MISUMI PURGE** — Pour the purge as needed. The purge temperature is the same as the molding temperature of the resin being molded. (Refer to the "Usage amount guidelines" below)
4. **Remove MISUMI PURGE** — Check whether the MISUMI PURGE is discharged from the nozzle tip or not. Repeat the injection and measurement steps as needed.
5. **Complete purge** — Check and confirm whether the color of previous resin has come out.
6. **Clean hopper** — Check firmly whether there is MISUMI PURGE still left inside the hopper or not.
7. **Set temperature** — Set the temperature to the same as post-resin if the temperature of post-resin is difference.
8. **Replace post-resin** — Use post-resin to discharge all the MISUMI PURGE inside the cylinder out.

■ Usage amount guidelines

Molding machine (mold clamping force)	Usage amount guidelines
50~90 tons	0.2~0.5 kg
100~150 tons	1.0~1.5kg
200~600 tons	2.0~4.0kg
700~1,500 tons	5.0~10kg

■ Selection examples by purpose of use

Part Number	MPG—S	MPG—HR MPG—HRC	MPG—G
Retention	◎	○	Prohibited
Holiday seal (Filled for long hours)	◎	○	Prohibited
Removing persistent carbides, etc.	△	○	◎
Cleaning hot runners	◎	○	Prohibited

◎: Recommended ○: Usable △: Unsuitable

(P)"Retention" means that the molding machine does not discharge the purging agent from the heating cylinder during operation and instead keeps it at the molding temperature for several minutes (3~5 minutes) in the heating cylinder.
(P)"Holiday seal (filled for long hours)" refers to displacing and filling the interior of the heating cylinder with a purging agent and retaining the agent with the heater power supply off or at low temperature for 24 hours or more.
(P)MPG-G cannot be used for retention, holiday seal (filled for long hours) or cleaning hot runners.

■ More effective usage

- The purge temperature is the same as the molding temperature of the resin being molded but it will be more effective to set the nozzle and the front of the heating cylinder 5~10°C higher.
- For stubborn dirt on the nozzle and screw head, it is recommended to retain the purging agent for several minutes (3~5 minutes) before performing a short purge. This usage method is prohibited with "MISUMI PURGE MPG-G".
- If the previous resin remains in the vicinity of the nozzle and check valve, fill with purging agent while applying back pressure by touching the nozzle (covering the nozzle hole), then retract the injection table and inject 2 to 3 times in order to purge.
- After removing with "MISUMI PURGE", if the resin to be molded next is highly fluid, some "MISUMI PURGE" may remain. When this happens, it is recommended to perform auxiliary purging with the same kind of resin with low fluidity before molding.

■ Precautions for usage and handling

- Be sure to read the SDS (MSDS) before use.
  http://jp.misumi-ec.com/maker/misumi/tech/sds/
- The purge temperature must be within the operating temperature range of "MISUMI PURGE".
- Do not keep "MISUMI PURGE MPG-G" in the cylinder for a long time.
- Do not consume or swallow "MISUMI PURGE" or inhale the gas generated during use.
- "MISUMI PURGE" is combustible. Handle and store it away from ignition sources.
- Be sure to dispose of "MISUMI PURGE" and its waste as general industrial waste.
- If pellets spill, collect them and take appropriate measures.