

Processing instructions for using purging compound

TORO-clean ASA / ASA-M

TORO-clean ASA / ASA-M is an ready mixed purging compound.

Temperature range for TORO-clean HT-G: 180°C – 300°C.

For using TORO-clean the same safety instructions are valid as for processing a normal polymer

cleaning of a processing machine

1. Emptying the cylinder
2. Put the necessary amount of TORO-clean inside the hopper
3. rotate the screw with back pressure until TORO-clean comes out natural (sometimes the screw must be brought back in the front position)
Attention: TORO-clean ASA produces a gas and therefore the polymer can shoot out of the nozzle – all safety items must be in place to prevent contact with melted polymer!
4. change the temperature setting for the new material and before starting bring out TORO-clean completely out of the cylinder

Attention:

- the minimum cylinder temperature is 180 °C
- for better results the cylinder temperature can be increased 10 or 20 °C
- TORO-clean is highly effective (do not put too much TORO-clean at the hopper)
- using TORO-clean on a regular basis will save a lot of time and money when changing the processing material
- to reduce the amount of smoke the melted purging compound can be cooled down in a water bin

cleaning of hot runner systems with TORO-clean ASA-M (not ASA)

Using TORO-clean ASA-M for hot runner systems you must observe following instructions!

Attention: TORO-clean ASA-M has a very low MFI.

Before using TORO-clean to purge a hot runner system the cylinder must be cleaned and you have to evaluate the flow ability of TORO-clean at your processing temperatures and your specific hot runner system (some hot runner systems are only for materials with a high MFI usable!).

We suggest to clean the hot runner system using high back pressure and open mould (TORO-clean will have a different shrinkage and therefore not usable to make parts!)