Injection molding

**TURN OFF**

1. Run the machine at a low/medium speed with the screw in the front position.
2. Feed the machine with a dose of cleaning material.
3. Once the material starts exiting the nozzle, shut off the machine.
4. Machine should be cooled to ambient room temperature.

**REBOOT**

1. Put heating units on and wait until the machine reaches the operational temperature.
2. Wait another 30 minutes after the desired temperature has been reached.
3. Feed a small amount of cleaning material through the feed inlet. The additional cleaning material will help push out the old cleaning material.
4. Run the machine at a low speed while monitoring the engine load (AMP). If the load is too high, wait longer for the plastic to reach working temperatures.
5. Visually inspect the cleaning material for any kind of contamination.
6. If the cleaning material is contaminated, repeat the regular cleaning procedure.
7. If the purge material exits the machine clean put the next resin in for production.

Extrusion – blown film, flat/profile die, blow molding

**TURN OFF**

1. It is recommended that you first perform the normal purging procedure described above (with suitable purge).

* If you decide to skip this preliminary step, remove the screen and go to the next section.

1. Feed the designated purge at slow to moderate rotation of screw.

* Remove screen
* Make sure that the purge fills the cylinder cavity (you can look through the machine's feed neck).
* Fill the die head & half the cylinder this way you avoid bridging in the feeding zone.

1. Turn off the machine and heating elements so that the machine reaches room temperature.

* If there is a risk of damage to the machine during operation, it is possible to leave the heating elements on at the minimum possible temperature and in accordance with the experience and the instructions of the plant technical staf.

**REBOOT**

1. Turn on the heating controls and wait until the machine reaches the working

temperature.

1. Wait another 30 minutes after reaching the working temperature.
2. The additional cleaning material will help push out the old cleaning material.

4.Operate the machine at a slow rotating screw speed with an emphasis on the load generated on the motor (Amps). If the load is too high, allow an additional period of time for the plastic to reach the correct temperature.

1. Visually inspect the purging material for the presence of contaminants.
2. If it contains contamination, purge and clean again from step 3.
3. Insert a new screen, adjust the required temperatures and continue production.