

Ramclean 206

Smart Purging Agents

Specialty: Clear materials, PC, Acrylic
Extrusion and injection

RAMCLEAN 206 is a new product - a **Smart purging agent; Non-Corrosive, Non-Abrasive and Non-Toxic** is designed to clean **transparent materials** with working temperatures **280°C – 320°C**. PC, PP, PE, Acrylic, Clear PS.

Only prime materials are used in a unique and highly effective mix of physical agents (push, scrub & pressure) & chemical (react with the resin) to clean hard-to-reach negative flow areas.

Easy to use - "AS IS" - no mixing or any further preparation is required. It is **safe to use and handle** and doesn't damage machinery after years of use providing continuous positive results.

Our specialists: preventive purging is highly recommended in keeping equipment clean. Frequently scheduled and shorter purges will be more effective than purging only when problems are observed.



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Ramclean 206

User Instructions - Injection molding

Safety: When performing these procedures, it is the machine operators responsibility to know their company's safety policy, machine safety operating parameters, and wear appropriate protective safety equipment.

For cleaning cylinder, screw, die and mold

1. Stop feeding the extruder with the material in use.
2. Clean the Hopper and around it very carefully.
3. Clean the color dispenser (if exists). If possible, shut it down and remove it.
4. Empty the extruder.
5. Raise working temperatures by 10°C.
- For heat sensitive materials, do not raise temperatures more than those recommended by the resin manufacture.
6. Raise the Back pressure to the highest safe level.
7. Start filling **RAMCLEAN 206** until its flows out from the mold, using 30-40% the regular RPM.
8. There's no need to stop.
9. Dismantle and clean the "die" if necessary (dirty, not smooth, not original, with contamination).
10. Start purging out **RAMCLEAN 206**: **a)** By injecting it through the opened mold at a low injection pressure.
Or b) By closing the mold and injecting products at half the weight.
11. If contaminants are still visible after most of **RAMCLEAN 206** is flushed out, add more and repeat steps 4 to 9.
12. Add the next material to use and continue injecting half weight parts until all **RAMCLEAN 206** is out.
13. Resume production using normal production settings.

Quantities recommended:

Machine capacity (Clamping force) - TON	Quantity of Ramclean - KG
75 t	0.5
150 t	1.0
400 t	3.0
650 t	5.0
800 t	8.0
1300 t	12.0
2300 t	20.0

These instructions are general guidelines. Purging of different materials/technology may require slight adjustments of quantity and process to achieve maximum efficiency.



Ramclean 206

User Instructions - Extrusion

Safety: When performing these procedures, it is the machine operators responsibility to know their company's safety policy, machine safety operating parameters, and wear appropriate protective safety equipment.

1. Stop feeding the extruder with the material in use.
2. Clean the hopper and around it very carefully, it is essential for the success of the whole cleaning procedure.
3. Empty the extruder.
4. Raise working temperatures by 10°C.
- For heat sensitive materials, do not raise temperatures more than those recommended by the resin manufacture.
- For flat die, raise the temperatures at the sides of the die 10°C higher than at the center.
5. Remove screen pack.
6. Start adding **RAMCLEAN 206** until it flows out from the die.
7. Resume screw rotation and start flushing out **RAMCLEAN 206** at low screw speed, after 2 minutes- increase the screw speed.
8. If contaminants are still visible after most of **RAMCLEAN 206** is flushed out, add more **RAMCLEAN 206** or repeat steps 4 to 7.
9. Add the next production resin and flush out the remaining of **RAMCLEAN 206**.
10. Install the screen pack, adjust temperature and screw settings for the production resin and continue with production.

Quantities recommended:

Machine capacity (Screw diameter) -mm Ø	Quantity of Ramclean - Kg SINGLE SCREW L/D 30	Quantity of Ramclean - Kg DOUBLE SCREW L/D 40
40 mm	2.0	4.0
60 mm	4.0	8.0
80 mm	8.0	20.0
100 mm	16.0	45.0
120 mm	25.0	70.0
160 mm	45.0	130.0

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