

Ramclean 801

Smart Purging Agents

Specialty: Very high temperatures 300°C- 400°C
PPO, PEEK, PPS, PES, PSU, LCP, PPP, PEI

RAMCLEAN 801 is a new products - a **Smart purging agent; Non-Corrosive, Non-Abrasive and Non-Toxic** is designed to clean materials with very high working temperatures **300°C – 400°C**: PPO, PEEK, PPS, PES, PSU, LCP, PPP, PEI and more.

Based on a proprietary formulation using ingredients that are **REACH and RoHS2** compliant.

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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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 801** until its flows out from the mold, using 30-40% the regular RPM.
8. Stop the screw and let **RAMCLEAN 801** sit for 1-2 minutes. For sensitive applications there no need to stop.
9. Dismantle and clean the "die" if necessary (dirty, not smooth, not original, with contamination)
10. Start purging out **RAMCLEAN 801**: **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 801** 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 801** 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.

