

# ASACLEAN™ PURGING COMPOUND

## TECHNICAL DATA SHEET

### HP GRADE

Mechanical Purging Compound for Injection Molding & Extrusion

#### Packaging



HP Grade is available in:

- 250 lb. poly-bags (pictured above)
- 1,500 lb. gaylords



PICTURED: Close-up of HP Grade

#### Description & Benefits

- Higher melt flow purge
- Color & material changes for larger parts
- Moldable - suitable for high-cavitation hot runner cleaning
- Effective at cleaning with closed molds
- Recommended for injection molding machines over 450 tons
- Polypropylene-based
- No chemical reaction
- No soak time required

#### Usage Information

<b>Temperature Range:</b>	170°C to 300°C (340°F to 570°F)
<b>Minimum Clearance:</b>	0.5 mm (.020") clearance for hot runner gates and extrusion dies; performs best with removed screen packs. If screen pack removal is not possible, use the max 100 mesh size.
<b>Amount of Purge:</b>	Typically 1-2 system capacities (actual amount depends on degree of contamination)
<b>Applications:</b>	<b>Injection Molding</b> - including hot runners and high-cavitation molds <b>Extrusion</b> - profile, sheet, cast film & compounding
<b>Types of Resin:</b>	Purging to and from polypropylene-based resins within the processing temperature range

#### Physical & Chemical Properties

<b>Physical Form:</b>	Solid
<b>Shape:</b>	Pellets
<b>Color:</b>	Milky white - light yellow
<b>Water Solubility:</b>	Insoluble
<b>Other Solvent Solubility:</b>	Insoluble for organic solvent under normal temperature
<b>Stability:</b>	Stable under normal temperatures
<b>Reactivity:</b>	Non-reactive under normal handling and storage conditions
<b>Conditions to Avoid:</b>	Do not exceed recommended temperature range. Do not allow ASACLEAN HP Grade to reside in barrel for more than 30 minutes at temperatures higher than 280°C (535°F).

#### Product Safety

Refer to Safety Data Sheets for more information

**Have a Question?** Visit [asaclean.com](http://asaclean.com) or call 800.787.4348 to speak with a purging expert.

Form #: TDS-HP  
Revised: 2/1/19

#### Key Measurements

#### Value

<b>Specific Gravity:</b>	1.09 at 23°C (73°F)
<b>Softening Point:</b>	154°C to 164°C (309°F to 327°F)
<b>Flashpoint:</b>	330°C (626°F)
<b>Autoignition Temp:</b>	390°C (734°F)

Please Note: The above data should be used for reference only.