

TABLE QUANTITY

Screw diameter (mm)	L/D									
	10	20	30	35	40	45	50	55	60	
20	70	75	100	150	200	250	300	300	350	
30	200	300	500	550	600	600	700	800	900	
40	400	600	800	900	1000	1100	1200	1400	1500	
50	1600	1800	2000	2200	2300	2500	2600	2800	3000	
60	2000	2500	3000	3500	4000	5000	6000	6500	7000	
70	3500	5000	6000	7000	7500	8000	8500	9500	10000	
80	5000	6000	7000	8000	9000	10000	12000	13000	15000	
90	7000	9000	11000	14000	15000	16000	17000	17000	18000	
100	10000	12000	15000	16000	17000	18000	19000	19000	20000	
110	12000	14000	16000	18000	20000	21000	22000	22000	23000	
120	15000	17000	20000	21000	22000	23000	24000	24000	25000	
140	18000	20000	23000	24000	25000	26000	27000	28000	30000	

For the cleaning of the **HOTRUNNER**, the exact quantity depends on the HOTRUNNER type, the number of cavities and the weight of the item produced.
 Generally we advise to use the same quantity as for the cleaning of the screw/barrel.
 The HOTRUNNER can be cleaned either by injecting into the mold or through open mold.
 The necessary quantity is generally the same.

For cleaning **Blow molding**, **blow film** and **cast film** machines you have to add the quantity necessary for the head (die) and eventually for the accumulator, which can change according to the type.
 Generally you have to calculate half of the quantity needed for the screw/barrel.

These are *indicative* values depending on colour, material and machine conditions.
 The quantities of purging compound are indicated in **grams**.
 All quantity values are for a single-screw machine; for a double-screw machine multiply the value by 1,6.

For the very first cleaning operation the indicated quantities must be **doubled** (it will be necessary to make **two** cleaning operations depending on the machine condition)