

TABLE QUANTITY

		L/D								
Screw diameter (mm)		10	20	30	35	40	45	50	55	60
	20	70 g	75 g	100 g	150 g	200 g	250 g	300 g	300 g	350 g
	30	200 g	300 g	500 g	550 g	600 g	600 g	700 g	800 g	900 g
	40	400 g	600 g	800 g	900 g	1 kg	1,1 kg	1,2 kg	1,4 kg	1,5 kg
	50	1,6 kg	1,8 kg	2 kg	2,2 kg	2,3 kg	2,5 kg	2,6 kg	2,8 kg	3 kg
	60	2 kg	2,5 kg	3 kg	3,5 kg	4 kg	5 kg	6 kg	6,5 kg	7 kg
	70	3,5 kg	5 kg	6 kg	7 kg	7,5 kg	8 kg	8,5 kg	9,5 kg	10 kg
	80	5 kg	6 kg	7 kg	8 kg	9 kg	10 kg	12 kg	13 kg	15 kg
	90	7 kg	9 kg	11 kg	14 kg	15 kg	16 kg	17 kg	17 kg	18 kg
	100	10 kg	12 kg	15 kg	16 kg	17 kg	18 kg	19 kg	19 kg	20 kg
	110	12 kg	14 kg	16 kg	18 kg	20 kg	21 kg	22 kg	22 kg	23 kg
	120	15 kg	17 kg	20 kg	21 kg	22 kg	23 kg	24 kg	24 kg	25 kg
	140	18 kg	20 kg	23 kg	24 kg	25 kg	26 kg	28 kg	29 kg	30 kg
	150	20 kg	22 kg	24 kg	26 kg	27 kg	30 kg	31 kg	35 kg	34 kg
	160	22 kg	24 kg	26 kg	27 kg	28 kg	31 kg	33 kg	35 kg	38 kg
	170	25 kg	28 kg	30 kg	32 kg	34 kg	36 kg	38 kg	40 kg	42 kg
	180	28 kg	32 kg	34 kg	36 kg	38 kg	41 kg	43 kg	45 kg	46 kg
	190	31 kg	36 kg	38 kg	40 kg	43 kg	45 kg	47 kg	50 kg	52 kg
	200	35 kg	40 kg	44 kg	48 kg	51 kg	54 kg	56 kg	58 kg	60 kg

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 to one time the quantity needed for the screw/barrel.

These are **indicative** values depending on colour, material and machine conditions.

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).