



“Speed, Quality, Economy...”

Recommendations for Usage

Purging Compounds

1. Start at 4.0% **AccelMax**[™] SP blend with the resin of your choice or meter, as you would color concentrate. **AccelMax** SP is compatible with all resin systems, except polycarbonate (PC).
2. **AccelMax** SP can be molded as you would a natural resin and will also clean manifolds and hot runner systems.
3. Parts molded from **AccelMax** SP and resin can be re-used as regrind material and added back to the appropriate colors or black, but it is important that complete activation occur during the first pass through your machine. This is accomplished by achieving and maintaining the stock temperature as follows:

AccelMax SP-GP	400 F
AccelMax SP-LT	360 F
AccelMax SP-HT	425 F

4. We suggest that for best results, you use maximum backpressure and screw speed to generate shear and increase the scrubbing effects of **AccelMax** SP.
5. If parts are to be molded, remember that the viscosity of the resin/purge blend is dramatically changed, so reduce the original shot size by at least 20% to eliminate severe flash in your tools.
6. After purging your machine clean, run several shots of natural resin through the system to remove any residue, which may have been left during the purging cycle.
7. Your machine is clean and ready for the next color when gas splay from **AccelMax** SP is no longer visible in the natural parts.