

Cleaning / Purging Procedure

Once a rise in injection pressure is observed during processing, the SPM Screen Pac should be purged and cleaned immediately to remove filtered contamination from the device.

USE EXTREME CAUTION WHEN PURGING

- Use Screw rotate speed approximately 15 rpm to 20 rpm
- Do not boost injection pressure any higher than necessary to move the material, usually 200-300 psi (14-21 bar)
- Do not stand or allow others to stand next to filter when purging
- Use purging guard for protection
- Follow government and facility safety regulations

1. Preparation for procedure:

- Lower injection pressure to 0 psi / bar
- Check that Screen Pac is above minimum melt temperature
- Check that all safety precautions are in place during procedure
- Determine model of Screen Pac installed

2. Remove injection machine nozzle using the normal procedure for removing machine nozzles as designated by facility and/ or machine manual

- #### 3. Using a 5/8 inch deep well socket, remove the screen plug. Socket is U-shaped to properly engage the locking pin of the plug



4. With extreme caution, purge filter with approximately three shots of material using approximately 15 rpm to 20rpm screw rotation

5. After all contamination has been purged out of the filter, reduce the injection pressure to 0 psi / bar and carefully wipe clean

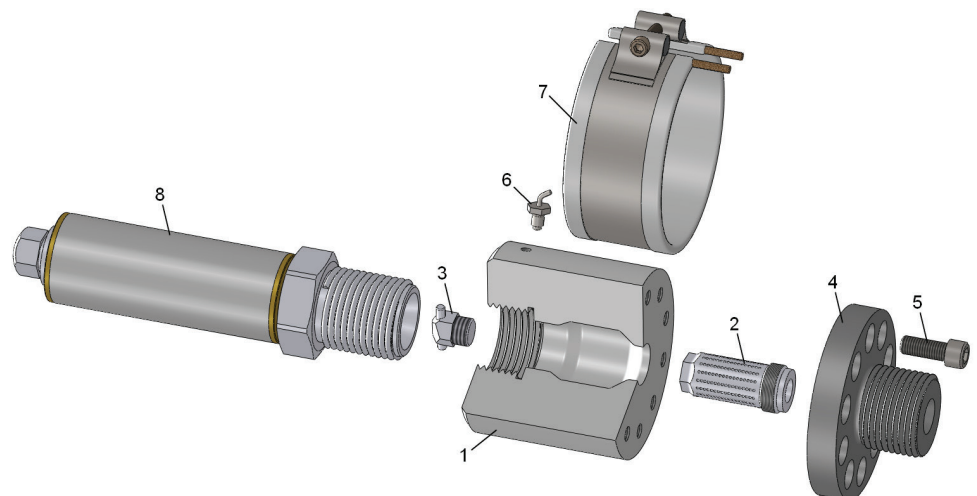
- Model 600 screens can be removed
- Use an 18mm socket to remove screen
- Contact INCOE Service Department if there is a need to remove the screen from the 4000 & 6000 Series
- Clean
- Reinstall screen plug and torque to 15-20 ft. lbs. (20-27N-m)

6. Reinstall Machine Nozzle

Always use anti-seize compound on all threads when assembling

Screen Pac Parts List

1. Main Body
2. Filter Screen
3. Screen Plug - 5/8" Socket
4. Threaded Flange (SPM4000 and SPM6000)
5. 1/2 - 20 x 1-1/4" Lg. SHCS (SPM4000 and SPM6000)
6. Thermocouple ISI-250SP, J Type Item# 012150
7. Heater Band
 - HB 42 (SPM600)
 - HB 454 (SPM4000)
 - HB 66 (SPM6000)
8. Machine Nozzle (Not Included)



Specify Voltage when ordering:
 120v, 240v, or 480v