

## DOSAGE CHART

Remarks: Injection Moulding and Blow Moulding follow the dosage below while Extrusion needs to double the dosage. The actual dosage may differ subject to the machine conditions

| MACHINE TONNAGE | SCREW DIAMETER (mm) / CAPACITY (gram) |           |
|-----------------|---------------------------------------|-----------|
|                 | A                                     | B         |
| 30              | 18 / 18                               | 20 / 22   |
| 50              | 20 / 26                               | 22 / 32   |
| 70              | 26 / 57                               | 30 / 85   |
| 90              | 30 / 100                              | 32 / 128  |
| 110             | 32 / 115                              | 35 / 166  |
| 140             | 38 / 188                              | 42 / 218  |
| 160             | 42 / 255                              | 45 / 365  |
| 200             | 45 / 300                              | 50 / 377  |
| 250             | 50 / 405                              | 55 / 519  |
| 280             | 55 / 602                              | 60 / 711  |
| 320             | 67 / 1002                             | 70 / 1116 |
| 380             | 70 / 1323                             | 75 / 1663 |

| MACHINE TONNAGE | SCREW DIAMETER (mm) / CAPACITY (gram) |             |
|-----------------|---------------------------------------|-------------|
|                 | A                                     | B           |
| 450             | 75 / 1663                             | 80 / 1824   |
| 500             | 80 / 1744                             | 85 / 2169   |
| 600             | 85 / 2169                             | 90 / 2345   |
| 750             | 90 / 2564                             | 95 / 2860   |
| 1000            | 105 / 3692                            | 110 / 3752  |
| 1200            | 110 / 4687                            | 115 / 5318  |
| 1400            | 115 / 5716                            | 120 / 6276  |
| 1700            | 120 / 6650                            | 130 / 7822  |
| 2000            | 130 / 8550                            | 140 / 10326 |
| 2500            | 150 / 11536                           | 160 / 13556 |
| 3000            | 180 / 26750                           | 210 / 36202 |
| 4000            | 240 / 51133                           | 260 / 73886 |



SCREW DIAMETER    RECOMMENDED RESIN MIX    DOSAGE : *PurgeMax EZ Double Dose Bottle*

| mm        | Kgs  | ml        | ml        | ml        | ml        | ml        |
|-----------|------|-----------|-----------|-----------|-----------|-----------|
| < 20      | 0.5  | 5         | 10        | 15        | 20        | 25        |
| 20 - 40   | - 2  | 10 - 20   | 20 - 40   | 30 - 60   | 40 - 80   | 50 - 100  |
| 40 - 60   | - 3  | 20 - 30   | 40 - 60   | 60 - 90   | 80 - 120  | 100 - 150 |
| 60 - 80   | - 4  | 30 - 40   | 60 - 80   | 90 - 120  | 120 - 160 | 150 - 200 |
| 80 - 100  | - 5  | 40 - 50   | 80 - 100  | 120 - 150 | 160 - 200 | 200 - 250 |
| 100 - 120 | - 6  | 50 - 60   | 100 - 120 | 150 - 180 | 200 - 240 | 250 - 300 |
| 120 - 140 | - 7  | 60 - 70   | 120 - 140 | 180 - 210 | 240 - 280 | 300 - 350 |
| 140 - 160 | - 8  | 70 - 80   | 140 - 160 | 210 - 240 | 280 - 320 | 350 - 400 |
| 160 - 180 | - 9  | 80 - 90   | 160 - 180 | 240 - 270 | 320 - 360 | 400 - 450 |
| 180 - 200 | - 10 | 90 - 100  | 180 - 200 | 270 - 300 | 360 - 400 | 450 - 500 |
| 200 - 220 | - 11 | 100 - 110 | 200 - 220 | 300 - 330 | 400 - 440 | 500 - 550 |
| 220 - 240 | - 12 | 110 - 120 | 220 - 240 | 330 - 360 | 440 - 480 | 550 - 600 |
| 240 - 260 | - 13 | 120 - 130 | 240 - 260 | 360 - 390 | 480 - 520 | 600 - 650 |