

## 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 : <i>PurgeMax EZ 60 Packs (10 ml/packet)</i>				
mm	Kgs		Packet(s)	Packet(s)	Packet(s)	Packet(s)	Packet(s)
< 20	0.5		1	1	2	2	3
20 - 40	- 2		1 - 2	2 - 4	3 - 6	4 - 8	5 - 10
40 - 60	- 3		2 - 3	4 - 6	6 - 9	8 - 12	10 - 15
60 - 80	- 4		3 - 4	6 - 8	9 - 12	12 - 16	15 - 20
80 - 100	- 5		4 - 5	8 - 10	12 - 15	16 - 20	20 - 25
100 - 120	- 6		5 - 6	10 - 12	15 - 18	20 - 24	25 - 30
120 - 140	- 7		6 - 7	12 - 14	18 - 21	24 - 28	30 - 35
140 - 160	- 8		7 - 8	14 - 16	21 - 24	28 - 32	35 - 40
160 - 180	- 9		8 - 9	16 - 18	24 - 27	32 - 36	40 - 45
180 - 200	- 10		9 - 10	18 - 20	27 - 30	36 - 40	45 - 50
200 - 220	- 11		10 - 11	20 - 22	30 - 33	40 - 44	50 - 55
220 - 240	- 12		11 - 12	22 - 24	33 - 36	44 - 48	55 - 60
240 - 260	- 13		12 - 13	24 - 26	36 - 39	48 - 52	60 - 65