

OMEGASONICS

Ultrasonic Procedure Document

Test Sheet Name: Injection Molds, Plastic

BEFORE

AFTER

Company Name: Omegasonics

City, State: Hollidaysburg, PA

Industry Type: Industrial

Description of Part: Steel and stainless steel molds or components

Contaminant: Mold release, hydraulic oil, grease, carbon & grime

Equipment Used To Clean: Omega Super Pro Model OMG-5036-4KW

Caution During Cleaning:

- **Molds or components must be rinsed immediately after removal from the ultrasonic tank to prevent cleaning solution residue from depositing on the mold surfaces.**

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PRESOAK REQUIRED: YES: NO: X		PRESPRAY REQUIRED: YES: NO: X			
CLEANING SOLUTION Omega Mold Release	SOLUTION/WATER 1:10	TEMPERATURE 165 F	PH 13.0	FREQUENCY/KHZ 40	CLEANING TIME 10-60mn
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RECOMMENDED CLEANING PROCEDURE:

- Preheat a 1:10 solution of Omega Mold Release to a temperature of 165° - 180° F in the ultrasonic tank. For extremely contaminated molds or components the dilution ratio can be increased to a 1:5 ratio of chemical to water.
- Place the steel/stainless steel mold or components into the ultrasonic bath. Clean the mold for 10-60 minutes depending on the level of residue on the surfaces.
- Half way through the cleaning process, turn the mold or components 180 degrees so the opposite side is facing the bottom of the tank. If the mold or component is being suspended in the ultrasonic bath remove, turn and replace for the remainder of the cleaning time.
- Once the mold / components are clean remove and immediately rinse all surfaces with hot water that is the same temperature as the ultrasonic bath. Rinsing can also be achieved by placing the mold / components into a secondary ultrasonic bath which contains clean, filtered water, which is the same temperature as the ultrasonic cleaning bath.
- **Note: Failure to completely rinse the mold / components with hot water will cause the detergents in the cleaning solution to remain on the mold / component surfaces.**
- The mold / components will flash dry after being rinsed.