

⇒ **Note:** When purging the barrel, screw and hot runner system *for the first time with Purgex™*, use 3 times the injection capacity and soak for 5 minutes. When routinely purging the barrel, screw and hot runner system with Purgex™, use approximately 1 to 1-1/2 times the injection capacity and soak for 3-5 minutes.

Preparation Before Purging

(with about 5 minutes remaining in the production run)

1. Turn off material flow.
2. Maintain process settings and continue running parts.
3. Clean hopper and/or colorant blender.
4. Load established amount of Purgex™ into hopper/feed zone.
5. When last part is completed, retract carriage and soak Purgex™ in the barrel for 3-5 minutes.
⇒ **Note:** A small amount of Purgex™ should be visible on the last part and/or a short shot occurs. Purgex™ is now soaking in the tool while the barrel is being purged.
6. Clean nozzle and sprue bushing.

Purging the Machine and Hot Runner System

1. Insure all hot runner gates are open.
⇒ **Note:** For ease of flow through the tool, it may be necessary to raise the hot runner temperatures 50°F (10°C).
2. In manual mode, purge barrel until Purgex™ is visible and then run one more Purgex™ shot.
3. Clean nozzle and sprue bushing.
4. Move carriage forward and seat nozzle into sprue bushing.
5. In semi-auto mode, cycle 2 shots, pulling Purgex™ parts off mold after each shot.
6. With Purgex™ still in barrel, stop and thoroughly clean hopper and/or colorant blender.
7. Turn on material flow and add the next production resin to hopper and/or colorant blender.
8. In semi-auto mode, cycle machine 4 shots, pulling Purgex™ parts off mold after each cycle.
9. Change settings to prepare machine for next production run.
10. In semi-auto mode, continue running Purgex™ parts until parts are free of Purgex™.
11. In auto mode, start machine and run 3 to 5 full shots to insure rinse is complete.
12. Begin counting production parts.

Comments & Recommendations

- ⇒ Minimum gate diameter is 0.030 inches.
- ⇒ Highly contaminated machines or the use of liquid colorants may require additional purging with Purgex™ and/or extra soak time (eliminate the soak time(s) on resins processed over 600°F (316°C)).
- ⇒ Purgex™ is stable and is safe to leave in the barrel for long term shutdowns.
- ⇒ Purgex™ can be used effectively in many ways. These procedures are offered as a reference and have been shown to be the most effective in plant trials and our controlled lab experiments.
- ⇒ Purgex™ should be thoroughly tested on any process following these basic guidelines as a baseline before using any alternative method.