

⇒ **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 full 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. Adjust shot size to roughly 25% of injection capacity.
⇒ **Note:** *The setting change in Step 1 is recommended because it assists Purgex™ in working more effectively and efficiently.*
2. In manual mode, purge out barrel and screw with Purgex™.
3. With about one half (1/2) an injection capacity of Purgex™ still in barrel, stop and thoroughly clean hopper and/or colorant blender.
4. Turn on material flow and add next production resin to hopper and/or colorant blender.
5. Insure all 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).*
6. Move carriage forward and seat nozzle into sprue bushing.
7. With mold open, extrude Purgex™ through the tool.
8. Continue purging the hot runner system with at least one injection capacity of the next production resin (with colorant on) to rinse out residual Purgex™ until the exiting material appears smooth and free-flowing.
9. Clean nozzle and sprue bushing.
10. Change settings to prepare machine for next production run.

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.