

⇒ **Note:** When purging the barrel and screw *for the first time with Purgex™*, use 2 times the injection capacity and soak for 5 minutes. When routinely purging 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 production run)

1. Turn off material flow.
2. Maintain process settings and continue running parts.
3. When last part is completed, retract carriage.
4. Clean hopper and/or colorant blender.
5. Load established amount of Purgex™ into hopper/feed zone.
6. Clean nozzle and sprue bushing.

Purging The Machine

1. Adjust shot size to roughly 25% of injection capacity.
2. In manual mode, purge barrel and screw until Purgex™ is visible (see Note above for quantity).
3. Stop purging and soak Purgex™ in the barrel for 3-5 minutes.
4. Continue purging until most of the Purgex™ is out of the hopper and then begin your normal changeover procedures.
5. Feed at least one injection capacity of the next production resin (with/without the colorant on) to rinse out any residual Purgex™.
6. If necessary, rinse with additional production resin.

⇒ **Note:** The setting changes above in Step 1 are recommended to assist Purgex™ in working more effectively and efficiently.

Comments & Recommendations

- ⇒ Highly contaminated machines or the use of liquid colorants may require additional purging with Purgex™ and/or an 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 many ways. These procedures are offered as a reference and have been shown to be 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.