

⇒ **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 (½) 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.