

To remove trace amounts of contamination (colorant, carbon) during a production run, this procedure is recommended for "on-the-fly" purging, *provided that the screen pack is no finer than 80 mesh. Should the screen pack be finer than 80 mesh, the screen pack must be removed prior to purging.*

Purging The Extruder

1. Keep running as normal, but prepare to divert the product from the finished goods stream.
2. Clean hopper and feed throat.
3. Load established amount of Purgex™ into hopper/feed zone.

⇒ **Note:** The amount of Purgex™ needed is equivalent to 10 lbs. per inch (25mm) of screw diameter.

4. Feed rapidly in one fast slug, increasing screw speed until safe pressure limits have been reached.
5. Purge through entire system, including die, if possible (die gap must be at least .030 inches).
6. Use maximum safe screw speed (within safe pressure limits) for 1 minute, then vary the screw speed from maximum to low to medium, completing the purge at maximum.
7. Follow the Purgex™ feed with the next production resin, and observe material for acceptability.

Comments & Recommendations

- ⇒ After long runs and/or heavily contaminated barrels and screws, it may be helpful to increase temperatures from barrel through die by 50°F (10°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.