

Preparation Before Purging

1. Keep temperature settings constant.
2. Maintain resin flow rate

Purging The Machine

1. Stop resin feed.
2. Empty machine.
3. Remove screen pack (recommended but optional).
4. Clean hopper and feed throat.
5. Load established amount of Purgex[™] into hopper/feed zone.

⇒ **Note:** Use 15 lbs of Purgex[™] per 100 lbs of throughput. Note that after Purgex[™] is used on a regular basis, the amount of Purgex[™] used to purge can often be reduced by 25 to 50%.

6. When Purgex[™] begins to exit the die, stop screw rotation.

⇒ **Optional:** Soak Purgex[™] in the machine for 5 to 15 minutes for first time purging or heavily contaminated lines.

7. Run remaining Purgex[™] through the system.
8. Follow with the next production resin (for about 5 minutes) to rinse out Purgex[™].
9. When resin appears clean and smooth, install screen pack (if removed in step 3).
10. Begin production.

Comments & Recommendations

- ⇒ Maintain as close to production speed as possible when purging.
- ⇒ When restarting the screw, monitor pressure and amp meters as screw speed is increased to standard operating speed.
- ⇒ 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.