

### Preparation Before Purging

1. Turn off resin, colorant and additive feeds.
2. Empty the extruder.
3. Clean hopper and feed throat.
4. Remove screen pack.

⇒ **Note:** It is a good practice to change the screen pack periodically. It may be convenient to combine this with purging.

5. Seal vents on extruder.
6. Maintain temperatures and begin run at low screw speed.
7. 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.

### Purging The Extruder

1. Begin feeding Purgex until barrel is full.
2. Soak Purgex in the system for at least 5 minutes.

⇒ **Note:** For heavily contaminated systems and difficult to remove resins or colors, up to a 20 minute soak may be beneficial.

3. Increase screw speed until safe pressure limits have been reached.
4. Purge through entire downstream system including die, if possible (die gap must be at least .030 inches).
5. Use maximum safe screw speed (within safe pressure limits) for one minute, then vary the screw speed from maximum to low to medium, completing the purge at maximum.
6. Follow the Purgex feed with the next production resin (the minimum amount of rinse resin needed is the same as the amount of Purgex used). Observe material for acceptability.
7. If contamination remains, repeat steps 1-4.
8. When acceptable resin appears, prepare extruder for production.
9. Begin production.

### Comments & Recommendations

- ⇒ When sealing the vent, it is advisable to monitor the upstream pressure.
- ⇒ Vent plugs are available from extruder manufacturers and other suppliers.
- ⇒ After long runs and/or heavily contaminated barrels and screws, it may be helpful to increase the extruder temperatures 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.