Document ID: PP-101 Issue Date: 09/21/12 Revision No.: 2 Revision Date: 2/10/26	**PURGING PROCEDURE FOR INJECTION MOLDING** **Hot Runner System: Open Mold**	Purgex™ Purging Compounds

Recommended Purgex™ Quantity

First Use: 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.	**Routine Usage**: When purging the barrel, screw, and hot runner system with Purgex *on a regular basis*, use 2 times the injection capacity and soak for 3 to 5 minutes.

Preparation Before Purging

1. With about 5 minutes remaining in the production run, turn off material flow.
2. Maintain process settings and continue running parts until the last part is completed.
3. Retract carriage.
4. Clean hopper and/or colorant blender and magnet area.
5. Load Recommended Purgex Quantity (as shown above) into hopper/feed zone.
6. For ease of flow through the tool, raise the hot runner temperatures by 50°F (approximately 28°C).

Purging the Machine and Hot Runner System

1. Adjust shot size to roughly 25% of injection capacity.
   - ⇨ ***Note:*** *The setting change in this step is recommended because it assists Purgex in working more effectively and efficiently.*
2. In manual mode, using about one-half (½) an injection capacity of Purgex, purge out barrel and screw.
3. Open all valve gates, including unused gates.
4. Move carriage forward and seat nozzle into sprue bushing.
5. With mold and all valve gates open, use short bursts, and inject Purgex through the tool until Purgex is visible at all gates.
6. Soak Purgex in the barrel and hot runner system for 3 to 5 minutes.
7. Resume purging through mold. Turn off gates that appear to be clean and purge any gate(s) with reduced material flow or where contamination/color is still observed (if needed, add more Purgex to hopper and continue purging valve gates until free of color/contamination).
8. Clean hopper and feed throat.
9. Turn on material flow and add next production resin to hopper and/or colorant blender.
10. With colorant on, continue purging the hot runner system with at least one injection capacity of the next production resin to rinse out residual Purgex until the exiting material appears unrestricted, smooth, and free-flowing.
11. Return shot size and hot runner temperatures to production settings.
12. Begin production.

Comments & Recommendations

- Minimum gate diameter is 0.030 inches.
- For resins processed above 600°F (316°C), eliminate soak times only when using a Purgex grade rated for the required processing temperature.
- For shutdown/startup, refer to Purgex Purging Procedure PP-107.
- Purgex should be thoroughly tested on any process following these basic guidelines as a baseline before using any alternative method.

Temperature clarification updated October 25, 2026.

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Purging Compounds That Really Work