Document ID: PP-107 Issue Date: 11/15/12 Revision No.: 0 Revision Date: n/a	**PURGING PROCEDURE FOR INJECTION MOLDING** **Shutdown / Start-up**	Purgex™ Purging Compounds

SHUTDOWN

Preparation Before Purging

(with about 5 minutes remaining in production run)

1. Turn off material flow.
2. Turn off colorant.
3. Maintain process settings and continue running parts.
4. When last part is completed, retract carriage.
5. Clean hopper and/or colorant blender.
6. Load Purgex™ into hopper/feed zone, using 1 to 1-1/2 times the injection capacity.
7. Clean nozzle and sprue bushing.

Purging The Machine

1. Adjust shot size to roughly 25% of injection capacity.
2. Purge two shots from the barrel and soak for 5 minutes.
3. In manual mode, purge out barrel and screw with remaining Purgex™ so that only residual Purgex™ remains in the barrel.
4. Shut down machine.

START-UP

1. When machine reaches process temperature, add 1 barrel capacity of Purgex™ to the hopper/feed zone.
2. Fill barrel with Purgex™.
3. In manual mode, purge the barrel and screw with Purgex™.
4. Continue purging until most of the Purgex™ is out of the hopper.
5. Feed at least one injection capacity of the next production resin (with/without colorant on) to rinse out any residual Purgex™.
6. If necessary, rinse with additional production resin.

Comments & Recommendations

- Highly contaminated machines or the use of liquid colorants may require additional purging with Purgex™ and/or an extended soak time.
- Purgex™ is stable and is safe to leave in the barrel for long term shutdowns.
- Purgex™ can be used effectively many ways. These procedures are offered as a reference and have been shown to be 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 testing using any alternative method.

Update October 25, 2026

For resins processed above 600°F (316°C), eliminate soak times only when using a Purgex grade rated for the required processing temperature.

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Purging Compounds That Really Work