Document ID: PP-200 Issue Date: 11/12/12 Revision No.: 2 Revision Date: 2/12/26	**PURGING PROCEDURE FOR EXTRUSION Extruder and Die**	Purgex™ Purging Compounds

Recommended Purgex™ Quantity

The amount of Purgex needed is 6 to 10 lb per inch (25mm) of screw diameter. Screws with mixing zones or deep flights may require as much as 10 lb per inch (25mm) of screw diameter.

Preparation Before Purging

1. Turn off resin, colorant, and additive feeds.
2. Empty the extruder.
3. Clean hopper, magnet, and feed throat.
4. If possible, remove the screen pack. If it cannot be removed, the recommended maximum screen size for purging with Purgex is 60 mesh (0.60).

   ⇨ **Note:** It is a good practice to change the screen pack periodically; we recommend changing it after purging.

5. Seal vents on the extruder.
6. Maintain temperatures and begin running at normal screw speed.
7. Load (6 to 10 lb per inch of screw diameter) of Purgex into hopper/feed zone.

Purging The Extruder

1. Begin feeding Purgex until it is visible exiting the die.
2. Shut off the screw and allow Purgex to soak 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. Start screw and increase speed within safe amperage limits.
4. Purge through the extruder, including die, if possible (die gap must be at least 0.030 inches/0.75 mm).
5. Use maximum safe screw speed (within safe pressure limits), then vary the screw speed from maximum to low to medium, completing the purge at maximum.
6. Clean hopper, magnet, and feed throat.
7. Load the next production resin.
8. If contamination remains, repeat steps 1-7.
9. When material output appears acceptable, prepare the extruder for production.
10. Begin production.

Comments & Recommendations

- ⇨ When sealing the vent, monitor the pressure.
- ⇨ Vent plugs are available from extruder manufacturers and other suppliers.
- ⇨ Purgex is stable and is safe to leave in the barrel if extended soak time is needed.
- ⇨ Purgex should be thoroughly tested on any process following these basic guidelines as a starting point before using any alternative method.

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