Document ID: PP-202 Issue Date: 11/14/12 Revision No.: 2 Revision Date: 6/05/18	**PURGING PROCEDURE FOR EXTRUSION Blow Molding: Accumulator(s)**	Purgex™ Purging Compounds

Recommended Purgex™ Quantity:
Use 1.5 times the combined capacity of barrel and accumulator(s).

Preparation Before Purging

1. Turn off resin, colorant and additive feeds.
2. Empty the extruder and accumulator(s).
3. Thoroughly clean feed throat, hopper, grinder, and feed lines from the grinder to the hopper.
4. Raise adaptor and accumulator temperatures by 80°F.

⇨ **Note:** For temperature-sensitive resins, raise adaptor and accumulator temperatures by 40° F.

5. Load established amount of Purgex into hopper/feed zone.

Purging The Extruder

1. Begin feeding Purgex, filling the barrel and accumulator(s) as close to 100% as possible, varying the screw speed from low to high (within pressure limits), and high to low, several times to aid in the cleaning process.
2. When Purgex exiting the head has lightened in color, stop, and allow Purgex to soak in the system for 10 to 20 minutes (a longer soak may be beneficial for difficult to remove resins or colors, or if contamination is present).
3. Vary the screw speed from low to high (within safe pressure limits) while emptying the machine.
4. Continue purging through entire downstream system, including accumulator(s). (Die gap must be <u>at least .030 inches</u> to process Purgex.)
5. Return temperatures to normal processing settings.
6. Clean hopper and feed throat to remove residual Purgex.
7. Follow the purge with the next production resin as a rinse, using 1.5 times the combined capacity of barrel and accumulator(s).

⇨**Note:** For highly contaminated systems, or after very long runs, a second or third purge may be required to remove excessive buildup. In some extreme cases, the accumulator heads may need to be cleaned manually.

8. When rinse resin appears clean, prepare extruder for production.
9. Begin production.

Comments & Recommendations

- ⇨ If machine has more than one accumulator, each accumulator must be purged with the recommended amount of Purgex.
- ⇨ 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.

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Purging Compounds That Really Work