



Chemical Purging Instructions

Concentrate grades must be mixed with a carrier resin prior to use – Please see Chemical Mixing Instructions

Preparation

- Run machine to empty all production material.
- Clean hopper and feed throat of residual material.
- If vented barrels, cap vents for maximum effectiveness. Clean vent throat of resident material.
- If possible, push hopper aside to get direct access to the throat. If not, RapidPurge can be fed via hopper magnet drawers or hopper itself.
- Move barrel away from mold
- Move the plunger back ¼ to ½ inch from its original set point



Tip

Pre-flush system with 3-7 shots of natural material to minimize resident material/color prior to purging. Empty system again.



Tip

If challenging degradation exists, raise temperature (25 degrees or more) on metering zone and nozzle for added chemical reaction and maximum cleaning results.

Never exceed maximum temperature of resident resin.

Temperature Sensitive Materials

If purging temperature sensitive materials like PVC, POLYACETALS, ABS, or Flame Retardant resin, please see page 2 before proceeding.

Purging

- Feed RapidPurge directly into the throat.
- Fill system by plunging RapidPurge forward as many times as it takes to fill the machine and RapidPurge is observed coming out of the nozzle. Bring plunger back after it is filled.
- Soak for approximately 15 minutes. Keep throat filled with RapidPurge and the drool coming from the nozzle. Keep cooling water on in the throat area.
- Empty system and inspect purgings. If contamination still visible, repeat purge.

Post-purge

- Empty system until all visible traces of RapidPurge are removed.
- Clean feed areas of RapidPurge to avoid contamination.
- Clean off end of plunger and make sure nothing clinging to the tip of the ram.
- Reset temperatures if raised for the purge.
- Follow with production material until all traces of RapidPurge are removed.



Tip

If switching to material of decreased viscosity, bridging down may be required to assure removal of purge residue.



Tip

RapidPurge chemical compounds are excellent for shutdowns.

Simply empty the machine after the purge, leaving residual RapidPurge in the system with heats turned off. At start-up, bring equipment up to operating temperature and introduce production material to remove residual RapidPurge

Temperature Sensitive Material

If purging temperature sensitive materials like PVC*, POLYACETALS, ABS, or Flame Retardant resin, two purges may be required.

- The first purge **MUST** be performed at normal operating temperatures to remove the temperature sensitive material.
- If carbon deposits are still present after the first purge, a second purge can be performed at higher temperatures.

***PVC**

If purging PVC with our standard chemical grades - **PM9240, PM5540, PM8240, IG3000**

- It is required to PRE-FLUSH system with natural PE/PP prior to introducing RapidPurge.

If purging PVC at low temperatures - below 380°F,

- Increase temperatures, except feed throat, to 380°F for the first purge.
- If carbon deposits are still present after the first purge, Raise the heats on the nozzle and front zone and purge again

If following RapidPurge with PVC or other temperature sensitive materials,

- Let machine cool back to operating temperatures before introducing the next resin, or use polyethylene as a temperature bridging material.

Questions/Comments? Contact us at 800-243-4203 or info@rapidpurge.com

These instructions are provided as general guidelines only. Your application, material, and/or process may have unique requirements. Please feel free to contact our Technical Services department at any time so that we may assist you in achieving maximum purge results with our RapidPurge products.