



Mechanical Purging Instructions

Note: If purging ACCUMULATOR equipped machines, increase shot size by 10-15% and move ram back, if possible.

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

Preparation

- Run machine to empty all production material.
- Remove screens to prevent blockage (not applicable to Blow Molding). Breaker plate can be left in for the purge.
- Clean hopper and screw inlet of resident material.
- If possible, push hopper aside to get direct access to the throat. If not possible, RapidPurge can be fed via hopper magnet drawers or hopper itself.



Tip

If purging MULTI-LAYER dies, each layer can be purged separately, until RapidPurge can be seen extruding from all layers.

Purging

- Feed RapidPurge directly into the throat at normal production RPM until RapidPurge is observed uniformly exiting from the die/head.
 - If HIGH TEMPERATURE purging - Starve feed RapidPurge to prevent bridging/collaring at the feed zone.
 - If MULTI-LAYER – repeat for each extruder in succession until all layers are observed exiting from the die.
 - IF TWIN-SCREW – starve feed RapidPurge one scoopful at a time and watch it move down the screws to prevent bridging issues. Progressively load scoops of RapidPurge until the purge exits the die uniformly.
 - If ACCUMULATOR / BLOW MOLDING – be sure to run RapidPurge through the accumulator as well to remove buildup of plastic/color that collects behind the piston.
- For vented-barrel systems, vary screw RPM to change velocity as it comes through the decompression zone.
- Continue adding RapidPurge as required until resident material/color/ degradation is removed.



Tip

Vary screw speed as RapidPurge is being run through to maximize scrubbing action and agitation inside the extruder and die

Temperature Sensitive Materials

If purging temperature sensitive materials like PVC, POLYACETALS, ABS, or Flame Retardant resin, temperatures can be kept at normal operating temperatures.

If purging PVC below 380°F and purge is sluggish, increase temperatures, except feed throat, to 360-380°F to allow HDPE carrier to flow better.

Post-purge

- Empty system until all visible traces of RapidPurge are removed.
 - If MULTI_LAYER – empty RapidPurge at normal RPM one extruder at a time. Flush from the bottom extruder working in sequence to the top.
- Clean RapidPurge from feed areas to reduce contamination.
- Replace screens, if removed.
- Follow with production material until all traces of RapidPurge are removed.

✓ *Tip* Varying screw speed while running new production material may help to clear RapidPurge from the system more quickly.

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

✓ *Tip* RapidPurge mechanical compounds are not recommended for shutdown.

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.