EXTRUSION / BLOWMOLDING

Chemical 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 Chemical Mixing Instructions

Preparation

- Run machine to empty all production material.
- 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* Pre-flush system with natural material to minimize resident material/color prior to purging. Empty system again.

✔ *Tip* If challenging degradation exists, raise temperature 25F or more in zones after the screw for added chemical reaction/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 at normal production RPM until RapidPurge is observed uniformly exiting from the die/head.
  - If ACCUMULATOR equipped machines - To prevent the accumulator from filling up with gases, fill the accumulator and then shoot it 2 to 4 times assuring it is filled with RP blend. Once the accumulator finishes shots, immediately refill the accumulator to prevent piston from being pushed back by gases. For best results: The accumulator head must be filled with RapidPurge to purge the buildup of plastic/color behind the piston.
- Continue adding RapidPurge as required until resident material is removed.

✔ *Tip* After RapidPurge is seen uniformly exiting from the die, screw speed can be reduced to a minimum RPM to increase residency time and provide maximum effectiveness. Extrude RapidPurge slowly through the system until purgings are clear of contamination. Do not stop the screw.

- If RECIPROCATING Screw - an alternate method can be achieved by stopping the reciprocating screw in a forward position and allowing for a soak cycle while taking one shot every 5-10 minutes.

Post-purge

- Empty system until all visible traces of RapidPurge are removed.
- Remove RapidPurge from feed areas to reduce contamination.

- Reset temperatures if raised for the purge.
- 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 system more quickly.

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

✔*Tip* **RapidPurge chemical compounds are excellent for shutdowns.**
Simply empty machine, leaving residual RapidPurge in the system at shutdown.
At start-up, bring equipment up to operating temperature and start with 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