



Chemical Purging Instructions

**Note: This procedure is for purging high temperature resins.
RapidPurge must be STARVE FED throughout entire purge.**

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

Preparation

- Run system until empty of the high temperature resin production material.
- Leave machine at operating temperature of resin being purged.
- If short barrel, decrease temperature 25 degrees on feed zone to avoid bridging
- Remove screens. Breaker plate can be left in for the purge.
 - If FIBER extrusion line - remove spinnerettes.
- Clean hopper, screw inlet, and vent throat of resident material.
- If vented barrels, cap vents for maximum effectiveness. Clean vent throat of resident material.
- Push hopper aside to get direct access to the throat. If not possible, RapidPurge can be fed via hopper magnet drawers but NOT via the hopper itself.
- Move barrel away from mold.



If available, pre-flush system with a natural HMWPE, or a very viscous low melt HDPE, to minimize resident material/color prior to purging. Empty system again.

Purging

- **STARVE FEED** RapidPurge directly into the throat. Keep screw at normal production RPM until RapidPurge is observed coming out of the nozzle/die.
- Reduce screw speed and let RapidPurge slowly extrude through the machine. Keep screw turning slowly to provide residency time but fast enough to avoid bridging on the rear zone flights. Do not stop the screw during the purge.
- Continue starving feeding RapidPurge as required until resident material/color has been removed.



For RECIPROCATING screws, if you cannot keep the screw turning slowly during the soak cycle, jog the screw every few seconds (turn on and off) to keep RapidPurge moving through the machine.

Post-Purge

- Empty system until all visible traces of RapidPurge are removed.
- Clean feed areas of RapidPurge to avoid contamination.
- Replace screens and/or spinnerettes.
- Reset temperatures.
- 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, 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.

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.