



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.
- Remove screens. Breaker plate can be left in for the purge.
- Clean hopper and screw inlet of resident 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 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 (25 degrees 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

- 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 seen exiting the die uniformly
 - If vented-barrel system, vary screw RPM as RapidPurge is being run through to change velocity through the decompression zone.

AFTER RapidPurge is seen uniformly exiting from the die,

- If the screw speed can be regulated easily, reduce screw RPM to a minimum speed and extrude RapidPurge slowly for a 30 minute soak cycle.
- If the screw speed cannot be regulate easily, twin screws can be stopped for the 30 minute soak cycle. Intermittently restart screw every 5-10 minutes to provide the system with fresh RapidPurge and maintain drooling out the die.



Tip

Twin screws can use large amounts of material – using a soak cycle with screws stopped saves cost in usage of purging material.

Post-purge

- Empty system until all visible traces of RapidPurge are removed.
- Clean RapidPurge from feed areas to reduce contamination.
- Replace screens.
- Reset temperatures if raised for the purge.

- Follow with production material until all traces of RapidPurge are removed.

- ✓ *Tip* Once new production material begins to exit from the nozzle, varying screw speed may help to clear RapidPurge from system.
- ✓ *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 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
Visit our website at www.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.