

**Physical Description:**

Blend, polyethylene and FDA-approved active component

Non-toxic, non-abrasive, and safe

Ready to use and easy to remove

**Temperature Range:**

Operating temperature range of 300°F to 600°F (149°C to 316°C)

**Applications:**

PURGEX 3056 Plus is used to effectively remove all types of colorants and engineering resins, such as nylon and polycarbonate, from the barrel, screw nozzle, and hot runner systems. PURGEX 3056 Plus includes a modified polyethylene for higher temperature resins. PURGEX 3056 Plus assures rapid turnaround on color and material changes with PC/ABS, PBT, PPO, and many other resins processed in this temperature range. This blend operates up to 600°F (316°C) with a five minute soak, or higher temperatures without a soak.

**How To Use:****INJECTION MOLDING**

- Empty barrel of production resin.
- Add PURGEX 3056 Plus to the hopper (a minimum of 1.5 times the injection capacity).
- Purge the barrel until PURGEX exits the nozzle.
- Soak five minutes at processing temperature with barrel full and screw in forward position.
- Purge barrel to empty.
- Follow with next production resin, rinsing PURGEX from machine. Resume molding.

**EXTRUSION**

- Empty extruder.
- Remove screen.
- Seal vent.
- Fill extruder with PURGEX 3056 Plus.
- Make certain extruder is full and PURGEX is exiting the nozzle as a foaming material.
- Soak five minutes at processing temperature.
- Add the next resin to be extruded and remove all PURGEX from the extruder.
- When it appears that PURGEX has been completely removed, replace the screen, open the vent, and commence production.



## Electronics Manufacturer Dramatically Reduces Machine Downtime

A West Coast electronics part manufacturer operates a 35 ton Newbury press to make small parts for specialty applications. The press utilizes a 20% glass-filled nylon 6,6 engineering resin to run 150 parts per hour, operating at 550°F. High impact polystyrene (HIPS) was historically used to purge the machine.

Just 1 lb. of PURGEX 3056 Plus was used to purge black nylon from the machine and only  $\frac{3}{4}$  lb. of HIPS (value \$0.69/lb.) to rinse the PURGEX from the machine to changeover to red nylon. Twelve parts were rejected in the process. Total purging time using PURGEX was only eight minutes.

Before using PURGEX, the molder used 3.5 lbs. of HIPS to purge the machine (value \$0.69/lb.). In the process, 50 parts were rejected. Total purging time was 20 minutes.

### Results

The results using PURGEX 3056 Plus yielded a savings of 12 minutes per purge, or \$5.60 based on \$28 per hour machine time cost. This translated into a time savings of 60% per purge, resulting in significantly increased production uptime.

Material costs using PURGEX were reduced by an extra \$0.70 per purge, resulting in a total savings of \$6.30 per purge (including machine time), a 45% reduction from previous purging using HIPS.

Based on an average of two daily color changes, the molding operation was able to save more than \$3,500 annually per press. Additionally, with faster purging times, each press can be operated an additional 300 hours per year.



**Purging Compounds That Really Work**  
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