


## PURGING PROCEDURE 100


### Injection Molding: Barrel, Screw, Check Ring, and Nozzle

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|  <b>Note:</b> Use this procedure for: <ol style="list-style-type: none"><li>1. Purging the 1<sup>st</sup> time with Purgex.</li><li>2. Purging the barrel and screw only.</li><li>3. The problem area is believed to be the barrel and/or screw.</li></ol> |
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#### Preparation Before Purging

(When 5 minutes remain in production run.)

1. Turn off colorant.
2. Maintain temperature settings.
3. Empty resin from machine.
4. Clean hopper.
5. Retract carriage.
6. Clean nozzle and sprue bushing.
7. Load PURGEX into hopper.






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|  <b>Note:</b> When purging the first time with PURGEX, use 2 times the injection capacity*. When routinely purging with PURGEX, use 1-1/2 times the injection capacity. |
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**\*Injection Capacity** – If the total volume (weight) of the barrel of the injection molding machine could be molded into a part, it would be defined as the injection capacity.

#### Purging The Machine

1. Retract the barrel from sprue bushing.
2. Fill the barrel with PURGEX (begin timing).
3. Manually make two shots at 25% of injection capacity.
4. Soak 5 minutes.
5. In manual mode, purge all remaining PURGEX.
6. Add next production resin to the hopper or feeder system.
7. Feed one injection capacity of the next production resin (with colorant on) to rinse out any residual Purgex.
8. Begin molding parts.

## Comments & Recommendations

-  It is not necessary to increase the back pressure.
-  To retract the screw, lower the back pressure.
-  Highly contaminated machines or the use of liquid colorants may require additional purging.
-  To improve purging efficiency, substitute PURGEX 457 Plus or PURGEX 3057 Plus, which contain 3% glass fiber.
-  Avoid the 5 minute soak for resins processed over 316°C (600°F).

Questions? Call our Technical Support team at (888) 843-0788.