

## PURGING PROCEDURE 102A

### Injection Molding: Hot Runner System

### Closed Mold (at least 1000T press)

#### Preparation Before Purging

(When 5 minutes remain in production run.)

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






When purging the barrel, screw and hot runner system for the first time with PURGEX, use 2-1/2 times the injection capacity\*. When routinely purging the barrel, screw and hot runner system with PURGEX, use 2 times the injection capacity.

\* **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. Fill barrel with PURGEX (begin timing).
2. Manually make one shot at 25% of the injection capacity.
3. Soak 5 minutes.
4. Move carriage forward and seat nozzle into sprue bushing.
5. Run machine on semi-auto, single shot.
6. Begin molding PURGEX parts. Try to mold as close to a full part as possible. (If needed, increase injection pressure 10 to 15%).
7. After PURGEX is depleted, continue molding parts using next production resin with colorant on.
8. Continue molding until acceptable parts are produced.

## Comments & Recommendations

-  To assist in filling the mold, it may be necessary to increase manifold and tip temperature by 10°C (50°F).
-  To improve purging efficiency, purge with PURGEX 457 Plus, which contains 3% glass fiber.
-  Highly contaminated machines or the use of liquid colorants may require additional purging.

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