

## **PURGING PROCEDURE 103**

### **Injection Molding: Liquid Colorant**

The standard Purging Procedures for PURGEX blends do not always remove liquid colorants. Liquid colorant from resin being molded sometimes deposits on the screw and barrel walls, especially in the first zone. This modified procedure will facilitate removal of liquid colorant deposits.

#### **Preparation Before Purging**

1. Increase heaters in inlet zone by 10°C (50°F).
2. Empty resin from machine.
3. Clean mixing chamber and top of feed throat with a cleaner or degreaser to remove any liquid colorant deposits.
4. Load PURGEX into hopper.
6. Retract carriage.
7. Clean nozzle and sprue bushing.





**Note:** 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 injection capacity.
3. Soak 15 minutes (this is 10 minutes longer than the standard soak time) to allow PURGEX adequate time to melt and activate in the first zone.
4. Purge the remaining PURGEX from the barrel.
5. After PURGEX is depleted, continue purging with the next production resin with the color on, to rinse PURGEX out of the machine.
6. Begin production.

## Comments & Recommendations

-  It is vital that the liquid colorant be cleaned from the mixing chamber and top of the feed throat before beginning the purging process.
-  To improve purging efficiency, purge with PURGEX 457 Plus or PURGEX 3057 Plus, which contain 3% glass fiber.

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