

PURGING PROCEDURE 105




Prolonged Shutdown or Maintenance of Injection Molding Machines

This procedure is designed to reduce the time and labor required to prepare an injection molding machine for extended shutdown.

Prior To Pulling The Screw

1. Turn off resin and colorant.
2. Empty remaining resin from the barrel and screw.
3. Load PURGEX into the hopper, using 1-1/2 times the injection capacity.
4. Purge two shots from the barrel and soak for 5 minutes.
5. In manual mode, empty the barrel of the remaining PURGEX. Do not load any material into the hopper.
6. Shut off barrel heaters.
7. Before pulling the screw, allow screw temperatures to fall to plant safety requirements.

Why Purge Before Pulling The Screw?

-  With contaminant deposits removed, less force will be required to pull the screw.
-  PURGEX contains lubricating agents which will assist in screw removal.
-  Residual PURGEX will be easy to remove using standard cleaning methods and tools.

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