


## PURGING PROCEDURE 200


### Extrusion - General

#### Preparation Before Purging

1. Turn off resin, colorant and additive feeds.
2. Empty the extruder.
3. Clean hopper and feed throat.
4. Remove screen pack.

 **Note:** It is a good practice to change the screen pack periodically. This may be convenient to combine with purging.

5. Seal vents on the extruder.
6. Maintain temperatures and screw speed.
7. Load PURGEX into the hopper.

 **Note:** Amount of PURGEX needed is equivalent to 10 minutes of residence time.

#### Extruder Purgex Weight Determination

1. Required weight of Purgex:  
Residence Time x Feed Rate = Weight of Purgex to use
2. Example calculation for Purgex weight requirement  
Extruder Capacity = 300lbs/hour





$$\text{Therefore: } 300 \frac{\text{lbs}}{\text{Hr}} \times \frac{\text{Hr}}{60 \text{ Min}} = \underline{5\text{lbs Purgex}}$$

$$\text{Purgex required} = \frac{5\text{lbs}}{\text{Min}} \times 10 \text{ Min} = \mathbf{50\text{lbs Purgex}}$$

## Purging The Extruder

1. Begin feeding PURGEX 457 Plus – This grade is recommended for all extrusion applications, although any PURGEX grade will perform efficiently.
2. Purge through entire downstream system, including die, if possible. Die gap must be at least .030 inches.
3. Maximize safe screw speed for one minute during PURGEX purge.
4. Follow the PURGEX feed with the next host resin.
5. Remove PURGEX and observe the appearance of the next resin for acceptability.
6. Repeat steps 1-5 if heavy contamination remains.
7. When acceptable resin appears, turn off screw and install screen pack.
8. Prepare extruder for production.
9. Begin production.

## Comments & Recommendations

-  When sealing the vent, it is advisable to monitor the extruder upstream pressure.
-  Vent plugs are available from extruder manufacturers and other suppliers.
-  Highly contaminated extruders, after long runs with resins such as ABS and polyurethane, may require two or three purges. In these circumstances, it may be helpful to increase the extruder temperatures by 10°C (50°F), on the second and third purge.
-  Doubling the recommended amount of PURGEX in the second and third purge may significantly reduce the time necessary for complete cleaning.

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