

PURGE-ATORY

Technical Guide

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PURGE-ATORY GRADE

Technical Procedure Guide

Ready to use Purging Compound

PURGE-ATORY is a specially developed cleaning compound that is delivered in a premixed and ready-to-use pellet form. It is specifically developed for the cleaning of screws, barrels, nozzles, and hot runners to remove burned material, color hang-ups, deposits and black specks during color and/or material changes specifically for the following resins: **PA-PC-ABS-SAN-PMMA** etc.

PURGE-ATORY processing temperature range from 374° F to 608° F (190° C to 320° C). It removes, at the temperature of the previously processed material any hang ups and deposits.

PURGE-ATORY compound is **not abrasive** and works with a chemical reaction. Since **PURGE-ATORY** is manufactured with non-abrasive chemical components, colored and burned polymers, incrustations, black specks and also rust are softened, removed and purged from the press. There is “**NO MECHANICAL ACTION**” made on the Machine Parts or Hot Runner System!

PURGE-ATORY cleans at the processing temperature of the previous production material and no soak time is required. It is recommended for hot runners.

PURGE-ATORY is not toxic and is odorless. It will not damage your equipment because it does not contain solvents: all components are qualified as GRAS (Generally Recognized as Safe) by FDA.

It may happen that running **PURGE-ATORY** in older machines, where the equipment is overused, the cleaning process may not remove all of the old deposits of material that ran months ago. In this case, a second application may be required to fully purge the machine.

It is highly recommended to close the container properly after each use. The forming of small balls of sticky substance may occur. ***This will not alter the efficiency of the product.***

The recommended storage time for **PURGE-ATORY** is 12-18 months.

SAFETY: Safety is always first. Follow your established Company Procedures and Practices for Purging Machines. Purging should be performed with purge guards closed and proper face shield, gloves and long sleeve clothing. Hot Plastic can cause burns! Use Caution!

Use with Injection Molding Machines:

ATTENTION! Do not use PE or PP as intermediate material.

- Increase the cylinder Temperature by 50° to 90° F; this operation is not strictly necessary but you will obtain a better cleaning result.
- Load screw, barrel with neutral grade of plastic resin (possibly suitable material) and run the machine until the material comes out in a lighter color (i.e. from red to pink and from dark blue to light blue).
- Run barrel empty and place screw in full forward position. Adjust the back-pressure of the machine to allow the loading of the **PURGE-ATORY** (generally 70 to 120 PSI).
- **For larger machines we recommend reducing the shot size by 10-20% of the maximum shot size.**
- Load the **PURGE-ATORY** (fill the barrel completely) and start injection cycle.
- **PLASTIFICATION TIME:**
 - Approximately for 40 seconds for machines up to 200 tons.
 - Approximately for 60 seconds for larger machines.
- Continue with injection process with short shots until the purged **PURGE-ATORY** appears visibly clean.
- Load machine with the next production material and run machine (with normal processing values) to eliminate the rest of the **PURGE-ATORY** within the machine.
- Begin normal production.

Use with Extrusion Machines:

- Run the machine with a neutral plastic resin.

ATTENTION! Do not use PE or PP as intermediate material.

- **If a screen pack filter is installed, it is recommended to remove it from the machine.**
- Load **PURGE-ATORY** and run machine at a 70 to 90°F (20 to 30°C) increased temperature (if possible).
- Adjust screw rotation to a slow speed to allow the compound to expand inside the machine. The extruded purging compound should have a foamy appearance. If it does not, further reduce the screw rotation speed.
- **For larger extruders, allow PURGE-ATORY to soak for 3 minutes once it begins to extrude out of the machine.**
- Continue to extrude the **PURGE-ATORY** until it appears visibly clean.
- Load neutral or production material and run machine to eliminate the rest of **PURGE-ATORY** within the machine.
- Begin normal production.