

PurgeMax[®] Instructions

Before Purging:

Purging with PurgeMax[®] is extremely simple. First, use the chart below to estimate the number of PurgeMax[®] packets to be used which is dependent on the barrel/screw diameter.

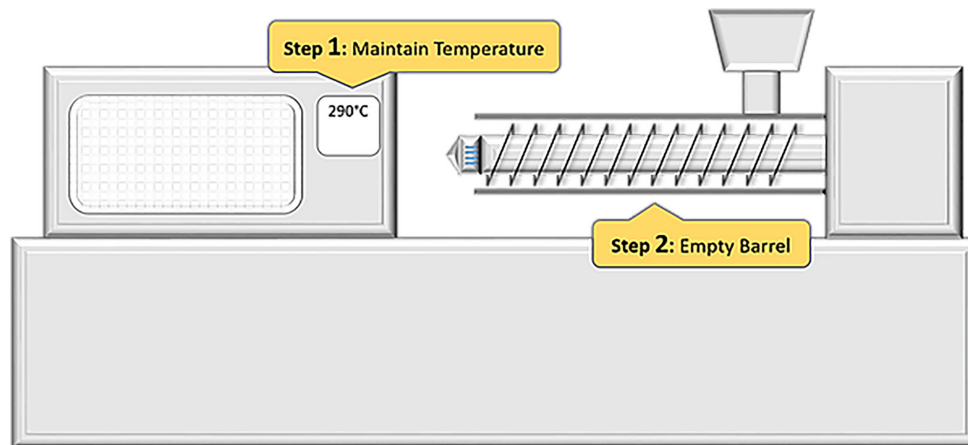
PurgeMax[®] is used in conjunction with carrier/purging resin. We recommend using the next production run resin as the carrier/purging resin. However, other lower cost alternative carrier resins can be used to save cost – please refer to the “PurgeMax[®] Purging Resin Selection Guideline” sheet for recommendation.

For extreme/stubborn carbon build up or if the machine has not been cleaned in long time, mix 1 packet of PurgeMax[®] per 3kg of purging resin and start purging process.

PurgeMax[®] Recommended Dosage Chart

SCREW/BARREL DIA.	INJECTION & BLOW MOLDING	EXTRUSION MOLDING
Less 45mm (1"-3/4")	1-2 packets	2-4 packets
46-88mm (1-3/4" - 3-1/2")	2-4 packets	4-6 packets
86-125mm (3-1/2" - 5")	4-7 packets	6-9 packets
126-165mm (5"-6-1/2")	7-9 packets	9-13 packets
166-205mm (6-1/2" - 8")	9-12 packets	13-16 packets
205-245mm (8" - 10")	12-15 packets	16-19 packets

Starting the Purging Procedure:



Step 1:

- Maintain machine's normal production profile for the resin, and keep to the normal operating temperature or at least maintain the minimum operating temperature of 150°C or 300°F.

Step 2:

- Empty the screw and barrel of residual resin. Small residual resin may be left inside the hopper and barrel before PurgeMax[®] is placed.

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Special Note #1: In case of **polyvinyl chloride (PVC)** and **FR (fire resistant) filled resins** which are highly heat sensitive, carbonization due to heat oxidation can lead to degradation within just a few minutes. Therefore, we recommend that you do **NOT** empty the barrel before the purging procedure. Instead, PurgeMax[®] should be introduced at the end of the resin run by adding the PurgeMax[®] on top of the resident resin in the hopper and follow by purging material.

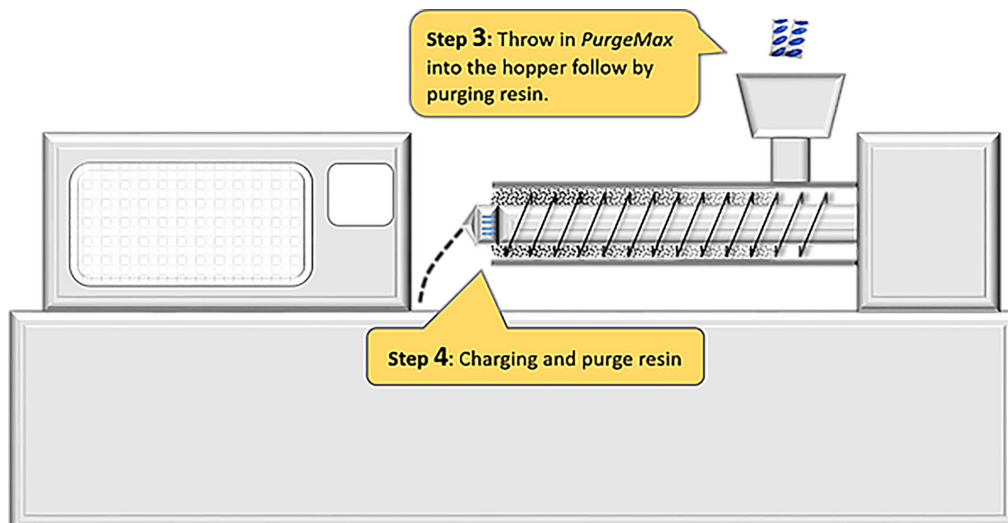
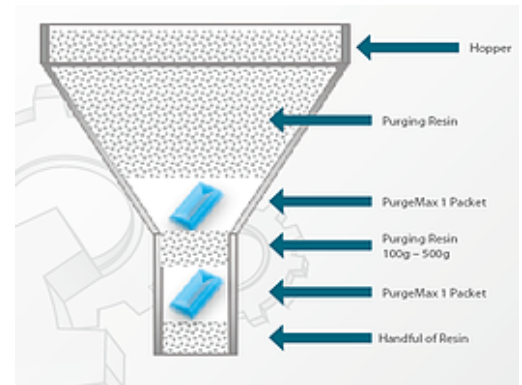
Special Note #2: In case of purging **polyvinyl chloride (PVC)**, please pour the liquid contents of PurgeMax[®] without tossing in the plastic bag into the hopper. The plastic bag of PurgeMax[®] packet is made of polyethylene (PE) which reacts with PVC to form strong glue-like substance which is difficult to remove/purge. Therefore, the PurgeMax[®] packet should be cut open and poured into the hopper without the plastic bag.

Step 3:

- Place a small amount of purging resin along with a PurgeMax[®] packet directly into the hopper, immediately follow by the remaining purging resin. Toss in the PurgeMax[®] packet in whole with the plastic wrapping – do NOT rip open the plastic packet – except in case of PVC (please see **Special Note #2 from Step 2**).

- Layering PurgeMax[®]:** When two or more packets of PurgeMax[®] are prescribed, layer the packets evenly through out the purging resin inside the hopper. That is, first place a small amount of purging resin (about 100~500g or 1/4~1 pound) then toss in the first PurgeMax[®] packet. Then place layer of purging resin before placing another PurgeMax[®] packet. Place one packet at a time.

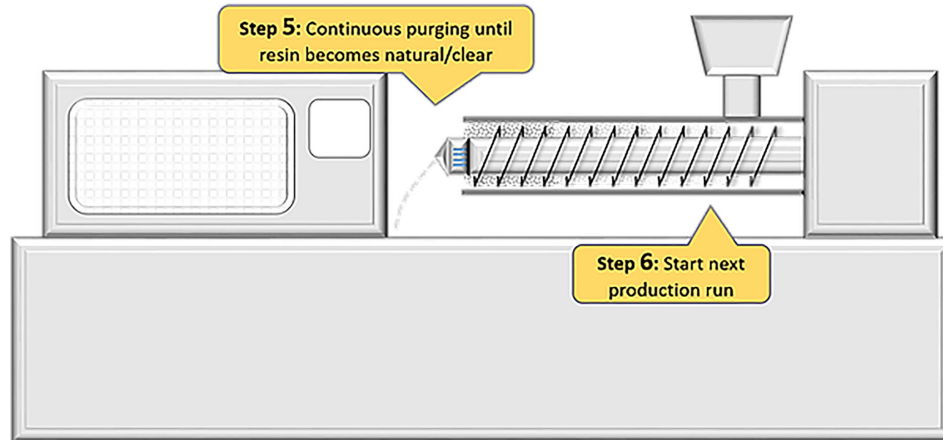
Special Note #3: For polycarbonate (PC) resin purging, user may consider mixing PurgeMax[®] with purging resin in a plastic bag before loading them into barrel port. This is to prevent “occasional charging” – screw is unable to take in resin due to the slipperiness upon contact with PC material.



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Step 4:

- Begin the purging process by discharging the purging resin by normal machine operation. On occasion, one may find a small amount of smoke rising from the barrel or hopper which is considered normal.
- **Special Note:** For hot runner and manifold system, purge a small amount from the nozzle before proceeding to open mold purging or injection

**Step 5:**

- Continue the purging process or normal operation until resin appears clean or free of any undesired color or carbon deposits.
- **Note:** If molding machine is heavily contaminated, the user may consider adding one more packet of PurgeMax[®] and repeat the purging process. For extreme/stubborn carbon build-up, mix 1 packet of PurgeMax[®] per 3kg of purging resin and repeat the process.

Step 6:

- When the purging process is complete, resume the normal production.

PurgeMax[®] Purging Resin Selection Guide

Purge and shutdown compounds are generally used to reduce changeover time and start up yield loss for injection molding and extrusion lines. PurgeMax[®] recommends using these purging/carrier resins in conjunction with PurgeMax[®] to improve the purging efficiency - speeding up the turnaround time and reducing start-up scrap.

PRODUCT TO BE PURGED:	PURGING RESIN RECOMMENDATION:
ABS	Cast Acrylic, HDPE, PS, SAN
ABS/PVC Alloys	Cast Acrylic, PS, HDPE
Acetal Copolymer	HDPE, PP, PS (Do not contact with PVC)
Acrylic	Clean Acrylic Regrind
ASA Blends	Cast Acrylic, HDPE, PP
Flame Retardant Compounds	Immediate purging with natural non-FR resin
Fluoropolymers	Cast Acrylic followed by HDPE
Filled Reinforced Resins	Cast Acrylic
Isoplast	GPPS, HIPS, SAN, ABS
LCP	PP
Nylon PBT	HDPE, PP
PBT	PS, HDPE, Next material to be run
PC / PBT Alloys	HDPE, PS, Cast Acrylic
PC / ABS	Natural ABS, SAN, PS, Cast Acrylic
PEI	HDPE, Glass reinforced PC
PET	Cast Acrylic, ASA, HDPE
Polycarbonate	Cast Acrylic, ASA, HDPE ,PS
Polylefins	HDPE
Polystyrene	Cast Acrylic
Polysulfone	Reground Polycarbonate, extrusion grade PP
Polysulfone / ABS	Reground Polycarbonate, extrusion grade PP
PPO / PPE	Cast Acrylic, PS
PPS	Acrylic, LDPE, HDPE
PPS	HDPE
PVC - Flexible	HDPE
PVC - Rigid	General Purpose, non-FR ABS, Acrylic, PS
Polyester Alloys	HDPE
TPE	HDPE, PP
TPU	HDPE, PP, non-FR ABS

Notes:

- 1) Run barrel dry and leave the screw forward if resuming with the same material after shutdown.
- 2) **CAUTION!** Do not combine acetal and PVC in the barrel for any reason!
- 3) When purging PVC, please remove the plastic wrap of PurgeMax[®] which is PE in material. Remove the plastic wrap and pour its content directly into the hopper.
- 4) Remove nozzle when purging with cast acrylic.