



SUGGESTED PURGING GUIDELINES- FOR Shutdown and Start-Up

Product: PCS Pellet Purge SP/PP & SP/PE Grade

Description: Modified Olefin, Non-Abrasive, Easy and Safe to Use

Process: Injection Molding / Blow Molding / Extrusion

SHUTDOWN:

- Typically there is no need to modify the RPM or Temperature Setting.
- Make certain that all auxiliary equipment is disconnected.
- Clean the hopper and feed throat.
- Clear the barrel by starving the screw- leaving the barrel free of resin.
- Introduce PCS Pellet Purge SP/PP or SP/PE at a Ratio of 100%. Typically only one barrel capacity is required for a Normal Purge Process- older equipment and more difficult purging applications may require an additional purge cycle.
- Load the PCS Pellet Purge into the hopper or feed throat and charge the entire barrel:
- Purge continuously through until the purge is clean and free of any contamination.
- During the process the PCS Pellet Purge is experiencing a thermal mixing reaction that is breaking down any color or degraded polymer in the barrel and on the screw.
- Although soaking is not required, it may be necessary for tough purging applications. In some cases, reducing the temperatures slightly and allowing the PCS Pellet Purge to stand in the barrel will result in a more effective purge.
- Once the barrel is completely clean, charge the entire barrel with the PCS Pellet Purge, stop screw rotation and turn off all heaters on the machine.
- **CAUTION- Do Not rotate screw while system is cooling down.**

START-UP:

- Turn Machine power ON and raise the operating temperature to 350-375°F.
- DO NOT ROTATE SCREW UNTIL HEATS ARE AT OPERATING TEMPERATURE.
- Follow any additional Start-up procedures necessary for the process.
- Once the operating temperature has been reached, slowly rotate the screw- do not rotate screw at full speed.
- If the purge coming out of the machine has any contamination, introduce more of the purge compound and flush the system until thoroughly clean.
- Using the resin required for the next production run, flush out remaining purge.
- Ready the machine and begin production.

Contact PCS at 1-800-521-0546 or sales@pcs-company.com for further information.