



Turn To The Industry Experts

PCS Liquid Purge Guidelines

Temperature Range is 180-710°F

Typical Dosage is 1 oz. per 1" Screw Diameter. (1 inch = 25.4mm)

Example: 6" Screw Diameter would use 2 — 3oz. Packets

- Typically there is NO need to modify the back pressure or temperature settings on the process.
- Empty the barrel and clean the feed throat.
- Once the barrel is empty, place a small amount of base resin in the feed throat (*depending on the size of the machine- just enough resin to cover the top of the screw*).
- Insert the entire single dose packet directly into the feed throat (Again, depending on the size of the machine- divide the suggested dose to feed evenly and complete this process until the entire barrel is charged- See DOSING Instructions Below).
- Normally only one barrel capacity is required for a well maintained injection unit - Older equipment and more difficult applications may require an additional purge cycle.
- During this process there is a scouring reaction that is breaking down the degraded resin in the barrel and on the screw. Soaking is not required but Do Not Rush through this process- Allow the PCS liquid purge to travel through the barrel at a regulated rate.
- Once the barrel is completely charged with resin / purge take short bursts with the screw rotating to allow the PCS liquid purge to get into all the dead spots of the screw and barrel.
- The purging process is complete when there is no visible contaminants coming from the injection unit.
- After the purge cycle has been completed, add the next resin to prime the barrel and remove any residual purge/resin from the injection unit.

Dosing:

- Typical dosages are: 1oz. for every 10/lbs. of resin or 1oz. for every 1 inch of screw diameter.
- For machines requiring more than one packet to purge- place a small amount of resin into the feed throat and the first package (place the entire package into the feed throat- there is no need to open it). Add at least enough resin to charge a proportionate amount of the barrel and then add the second package. **Continue this process until all packages have been used and finish by charging the barrel with resin.**

Benefits and Features:

- Reduce the volume of resin required to complete the purge process.
- Save on the actual cost of purging product.
- Minimize the downtime of the purging process
- FDA Compliant and Environmentally Safe
- Works with ANY RESIN- No Need for Multiple Grades
- Convenient and Easy to Use
- Reduces Resin Required to Purge
- Minimizes Process Equipment Down-Time
- Made in the USA

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