



Speci Purge™

Injection Molding Purging Instructions

Recommended Temperature Range 175-320°C (350-600°F)

Tips: The best way to keep your extrusion equipment clean is preventative purging. Frequently scheduled and shorter purges will be more effective than purging only when problems are observed.

Safety First: When performing these procedures, it is the machine operators responsibility to know their company's safety policy, machine safety operating parameters, and wear appropriate protective safety equipment.

Procedure

1. Keep the barrel mostly full at all times to prevent oxygen from entering the barrel – excess oxygen will accelerate material decomposition of all polymers.
2. Maintain all zone temperatures of the material that is to be purged. Speci Purge is designed for a wide range of temperatures (175 - 320°C)
3. Retract the injection unit allowing sufficient room for exiting purge.
4. Wipe the hopper and feed throat clean of residual resin and color.
5. Introduce Speci Purge into the extruder and purge approx. 2 to 3 times of the barrel volume.

(This volume is only a guideline. The condition of the equipment, the resin being purged and the length of run time between purges may require more or less Speci Purge.)

6. Set machine shot size to 30% of maximum allowable setting.
7. When Speci Purge starts to exit the nozzle, increase the shot size to maximum operational shot size.
8. Once Speci Purge starts to exit cleanly, reduce shot size to 30%.





9. Adjust temperatures for next production resin.
10. Thoroughly clean remaining Speci Purge from hopper and replace with the next production resin.
11. Purge out remaining Speci Purge with new production resin. (50% to 100% of maximum operational shot size).
12. Ensure that feed nozzle and sprue bushing have been thoroughly cleaned.
13. Engage injection unit to begin production.

These instructions are general guidelines only. Your purging techniques may vary depending on materials and processes.

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