

Preparation Before Purging

1. Empty resin from machine.
2. Increase accumulator temperature/manifold temperature by 100°F to 120°F (40°C to 50°C) without exceeding 520°F (270°C).
3. Clean hopper and feed throat.
4. Load established amount of Purgex™ into hopper/feed zone.

⇒ **Note:** When purging accumulators with Purgex™, use at least 3 times the accumulator weight capacity. For example, if accumulator holds 20 lbs use at least 60 lbs of Purgex™.

5. Fill accumulator to capacity with Purgex™.
6. Center the die.
7. Open the valve gap .030 inches (0.5mm) and allow a small amount of Purgex™ to flow out (about 5% of total).
8. Allow Purgex™ to soak for 15 minutes.

⇒ **Note:** For highly contaminated systems or after very long runs, a longer soak time may prove to be beneficial.

9. Open the valve gap to maximum.
10. Empty Purgex™ from the accumulator with continuous, sequential flow.
11. Refill accumulator and empty until no Purgex™ remains, followed by the next production resin.
12. Reset accumulator temperature to process settings.
13. Begin production.

Comments & Recommendations

- ⇒ If machine has more than one accumulator, each accumulator must be purged with the recommended amount of Purgex™.
- ⇒ Purgex™ is stable and is safe to leave in the barrel for long term shutdowns.
- ⇒ Purgex™ can be used effectively in many ways. These procedures are offered as a reference and have been shown to be the most effective in plant trials and our controlled lab experiments.
- ⇒ Purgex™ should be thoroughly tested on any process following these basic guidelines as a baseline before using any alternative method.