



PURGEPACKS™

HIGH PERFORMANCE PURGING SOLUTION

GRADE SELECTOR

GRADE	Product Form	Process	Temp. Range	Dosage	Hot Runners	ABS	POM	PE	PP	Nylon	PC	PBT	PET	PS	PVC	PEEK
PurgePacks Standard	Liquid	Injection Blow Mold Extrusion	275°F to 765°F	1 oz. per 1" Screw Dia.	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
PurgePacks +Plus	Liquid	Injection Blow Extrusion	275°F to 765°F	1 oz. per 1" Screw Dia.	.75mm minimum clearance	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
PurgePacks Xpress	Crystal	Injection Blow Extrusion	275°F to 765°F	1 oz. per 1" Screw Dia.	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes

Purging Guidelines

Follow these suggested procedures with PurgePacks™ to Simplify the Purging Process and Save.

Step 1: Maintain processing profile for resin in the machine and empty the barrel and screw of residual resin.

Step 2: Clean feed throat and hopper of any contaminates. Dump or vacuum. Do not reach into feed throat opening for any reason!

Step 3: Adjust machine profiles for the resin required for the next job.

CAUTION

When purging molding machines of any kind, always use safety equipment such as, but not limited to gloves, safety glasses, face-neck shields, arm sleeves, safety vests, etc.

PurgePacks™ Usage Chart

Use 1 ounce of PurgePacks™ for every 1 inch of screw diameter (1 inch=25.4 mm)

<u>INCH</u>	=	PurgePacks™	MM	=	PurgePacks™
1 in.	=	1 oz.	25.4mm	=	1 oz.
1.5in.	=	2 oz.	38.1mm	=	2 oz.
2 in.	=	2 oz.	50.8mm	=	2 oz.
2.5in.	=	3 oz.	63.5mm	=	3 oz.
3 in.	=	3 oz.	76.2mm	=	3 oz.
3.5in	=	4 oz.	88.9mm	=	4 oz.
4 in.	=	4 oz.	101.6mm	=	4 oz.

Step 4: Once the machine is ready, place PurgePacks™ directly into the hopper and follow with enough resin you are going to run next to fill the barrel. (with applications that require more than one PurgePacks™, place one PurgePacks™ into the hopper and follow with a small amount of resin and repeat until entire dosage has been added- then charge the barrel with resin).

Step 5: Make certain that the screw is in the forward position and add enough resin to flush the barrel of any residue and resin appears natural and clean.

Step 6: Purging Process is Complete, resume with standard procedures for next job.

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