



ACRYLIC PURGER INSTRUCTIONS FOR INJECTION

SUGGESTED PURGING GUIDELINES- FOR COLOR AND RESIN CHANGES

Product: 114656AP Standard Clear Cast Acrylic Purger
114600PP Super-Scrub Acrylic/Polymer Hybrid Purger

Temp Range: 180° to 595°F (82° to 312°C)

Process: Injection Molding

- ✓ Not recommended for Hot Runner Runner Systems.
- ✓ Nozzle orifice must be 3/16" diameter or larger or nozzle must be removed.
- ✓ Typically there is no need to modify the RPM or Temperature Setting.
- ✓ Retract the machine carriage from the mold, exposing the nozzle.
- ✓ 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 as much as possible.
- ✓ Introduce the Acrylic Purger at Rate 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 Acrylic Purger into the hopper or feed throat.
- ✓ With the shot size set between 20-25%- purge with short bursts until the machine is clean and free of any contamination.
- ✓ During the process the Acrylic Purger 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 Acrylic Purger to stand in the barrel will result in a more effective purge.
- ✓ Once the barrel is completely charged with the Acrylic Purger, take a moment to wipe the feed throat and hopper down. Be certain machine is locked out and screw is not rotating.
- ✓ The purging process is complete when there is no visible contaminants emerging from the nozzle.
- ✓ After the purge cycle has been completed- Add the next resin to prime the barrel and remove any residual purge/resin from the barrel and screw.

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.



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ACRYLIC PURGER INSTRUCTIONS FOR EXTRUDERS

SUGGESTED PURGING GUIDELINES- FOR COLOR AND RESIN CHANGES

Product: 114656AP Standard Clear Cast Acrylic Purger
114600PP Super-Scrub Acrylic/Polymer Hybrid Purger

Temp Range: 180° to 595°F (82° to 312°C)

Process: Extrusion- Profile, Sheet, Compounding

- ✓ Remove Die, Adapters, Clamp Rings, Breaker Plate and Screen Packs. Opening must be free of restrictions.
- ✓ 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.
- ✓ Add the Acrylic Purger at a Rate 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 Acrylic Purger into the hopper or feed throat.
- ✓ Remove Screen Pack(s).
- ✓ Purge continuously until purge is clean and free of any contamination.
- ✓ During the process the Acrylic Purger 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 Acrylic Purger to stand in the barrel will result in a more effective purge.
- ✓ Once the barrel is completely charged with the Acrylic Purger, take a moment to wipe the feed throat and hopper down. Be certain machine is locked out and screw is not rotating.
- ✓ The purging process is complete when there is no visible contaminants emerging from the die opening.
- ✓ After the purge cycle has been completed- Add the next resin to prime the barrel and remove any residual purge/resin from the barrel and screw.

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.



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