



4PURGE® Purging Compound

PURGING INSTRUCTIONS FOR INJECTION MOULDING

1. Check that all zones are in the proper temperature range for the grade of **4PURGE** being used.
2. Retract the injection unit. Run the barrel empty using maximum backpressure. Wipe the hopper and feed throat.
3. Feed the required amount of **4PURGE** into the hopper. About ¼ to ½ barrel capacities is required for purging a typical injection moulding machine. The actual amount required depends on the difficulty of the application and the condition of the equipment. Start with about ¼ barrel capacity.
4. With the screw completely forward, increase the backpressure to the maximum level.
5. After **4PURGE** begins coming from the nozzle, increase the screw speed to the maximum safe level.
6. Drop the backpressure after the **4PURGE** coming from the nozzle is almost clean.
7. Retract the screw and perform short, high-velocity injection shots.
8. Repeat steps 1 through 7 if contaminants are still visible.
9. The machine is clean and purging is complete when **4PURGE** coming from the machine is visibly free of contamination.
10. Displace the **4PURGE** remaining in the machine with the next resin, again, at the maximum backpressure and maximum safe screw speed with the screw completely forward.

- **4PURGE does not work by chemical reaction. No soak time or hold-up time is required for an effective purge.**
- **For maximum performance, 4PURGE should not be diluted with other materials.**
- **4PURGE works best with maximum agitation. Use the maximum safe screw speed and maximum safe backpressure with the screw in the most forward position**

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Test Values: Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/ die, the processing conditions and the colouring.