



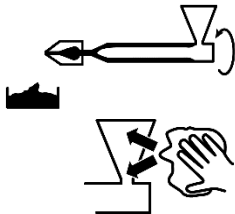
# BBU Extrusion Instructions

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Aquapurge products are not intended to be incorporated in finished plastic goods. In the view of the many factors that may affect processing and application, users should make their own independent determination that the products are suitable for their intended use and can be used safely and legally.

## First Use (per machine) Safety Evaluation

**Explanation:** **BBU** is an aggressive, stiff carbon removal system consisting of a polyolefin carrier and a high percentage scrubbing additive. The scrubbing additive is within the range of 0.5mm to 1.0mm and does not melt or compress. As such precautions need to be followed to ensure safe processing through equipment.



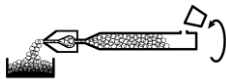
Empty Machine of last material

Clean Hopper and Screw Throat thoroughly

**Remove mesh / filter from screen changer**

**Turn off vent vacuum**

**Not suitable for Basket, Spiral Flow or complex flow channel dies, check with Aquapurge for other suitable products**



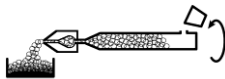
### **Check Additive Size is suitable**

Dose one cup of **BBU** into the HOPPER THROAT followed by the next material to be run

Continue purging the “next material” watching and comparing the screw torque required and the head pressure.

### **Check Additive Loading is suitable**

If pressure and torque are within safe limits and the **BBU** exits the dies satisfactorily empty the “next material” completely from the extruder



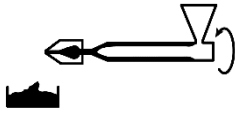
Dose one cup of **BBU** into the HOPPER THROAT followed by one cup of the “next material” to be run

Continue purging one cup of each watching and comparing the screw torque required and the head pressure. If within safe limits increase the ratio to two **BBU** and one “next material”

If still within safe limits you are okay to run **BBU** at full dose levels, if not please contact Aquapurge with full details of your findings.

## Degraded Material Removal Instructions

**Explanation:** **BBU** is an aggressive, stiff carbon removal system. It is designed to mechanically scrape carbon off screws and barrels at normal processing temperatures. Ensure Safety Precautions are read and understood before use.



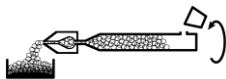
Empty Machine of last material



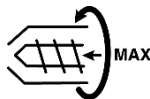
Clean Hopper and Screw Throat thoroughly

**Remove screens from screen changer**

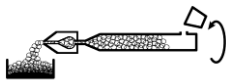
**Turn off vent vacuum**



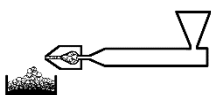
Dose **BBU** into the HOPPER THROAT until purge is evident at the die exit



Increase Screw Speed to Maximum **SAFE** running conditions (**Do not** exceed max pressure or torque)



Dose **BBU** into the HOPPER THROAT until all degraded material is clear from the extrudate (**Should look white**)

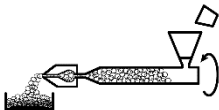


**(STARVE)**

Extrude till clear then run Screw **empty**



Clean Hopper and Screw Throat **thoroughly**

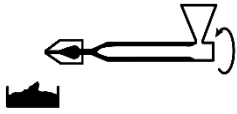


**(FEED)**

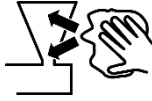
To clear **BBU** fill hopper throat with the next material

**Repeat STARVE–FEED a minimum of 3 times then fill hopper completely**

## Colour / Material Change Instructions



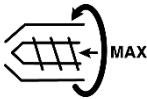
Empty Machine of last material



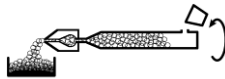
Clean Hopper and Screw Throat thoroughly

**Remove screens from screen changer**

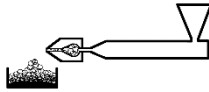
**Turn off vent vacuum**



Increase Screw Speed to Maximum **SAFE** running conditions (**Do not** exceed max pressure)



Dose **BBU** into the HOPPER THROAT until all colour removed

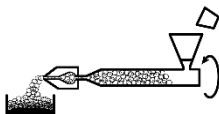


**(STARVE)**

Extrude till clear then run Screw **empty**



Clean Hopper and Screw Throat **thoroughly**



**(FEED)**

To clear **BBU** fill hopper throat with next material

**Repeat STARVE–FEED a minimum of 3 times then fill hopper completely**

## Safety Precautions



Do not use **BBU** for material with melt temperatures below 160°C



Do not use **BBU** for material with melt temperatures above 340°C

### PPE



Wear suitable protective clothing when cleaning down equipment, using, handling or viewing the purging agent



If contact with skin occurs, wash with cool water



In case of eye contact, irrigate with plenty of cool water



Do not swallow product



In situations of excessive shear heat place purgings in cool water to eliminate fumes