

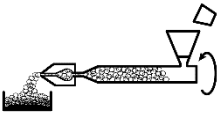
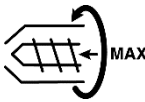
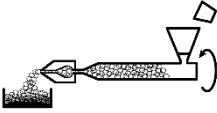
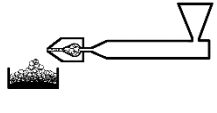
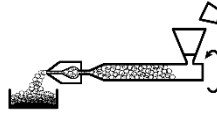


Extrusion Instructions

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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.

Color / Material Change Instructions

  	Remove screens from screen changer and re-insert breaker plate Set Melt Pump to manual (the pump should not control the screw speed) Add PCP to the extruder and purge until evident at the die exit Increase Screw Speed to Maximum SAFE running conditions (Do Not exceed max amperage or pressure) and continue purging until there are no signs of previous material or color
If Removing Carbon (Decarbonizing procedure) go to next page	
 	Run Screw <u>empty</u> until material discontinues exiting the die “Starve-Feed” the <u>next production material</u> 5 times (fill the hopper throat and empty the hopper throat 5 times), then empty the machine completely Fill hopper throat with next production material and extrude until 90% clear Stop extruder, remove Breaker Plate(s), manually clean any excess color from adaptor, repack screens, refit and reset melt pump Restart and extrude until extrudate is acceptable

Carbon Removal

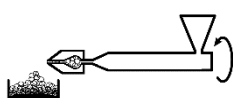
PCP will highlight carbon during a color change if your equipment has large deposits inside. This will generally start once most of the color has been removed and the **PCP** is now flowing over the carbon choked surfaces. At this stage it is important to continue purging with **PCP** until all loosened carbon has been removed from the extrudate otherwise specs will come out over many metres of product.

This carbon in the purge highlights the need to do maintenance by decarbonizing using **PCP**. Decarbonizing allows the surfactants in **PCP** to soak through the carbon cracks to loosen them whilst an additional additive causes the carbon to adhere to the polymeric carrier. For decarbonizing to work effectively the machine needs to cool to ambient to allow the carrier to shrink and have the strength to pull the carbon off the metal surfaces. In most cases this can be carried out over a weekend but during the week is also possible with fans to aid cool down speeds.

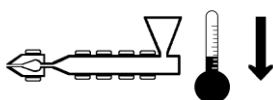
Decarbonizing Procedure Continued

In summary the procedure follows the color change procedure with following differences.

Keep purging until **all** signs of loosened carbon are removed



Empty the screw **completely** of **PCP**



Turn off the heats **completely**

It is now imperative that the machine is allowed to cool to ambient or at least, 80°C in the centre of the head, if not the carrier will not have enough strength or shrinkage to pull the carbon off the metal surface.

On start-up the carbon will be loosened and only requires another **PCP** color change procedure to remove all the loosened carbon.

Safety Precautions



Do not use **PCP** for material with processing temperatures below 320°F



Do not use **PCP** for material with processing temperatures above 554°F

PPE



Wear suitable protective clothing when cleaning down equipment, using, handling or viewing the hot or cold **PCP**



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