



BBU Extrusion Instructions

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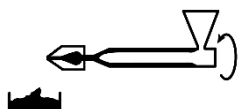
Aquapurge products are not intended to be incorporated in finished plastic goods. In the view of the many factors that may affect processing and application, users should make their own independent determination that the products are suitable for their intended use and can be used safely and legally.

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

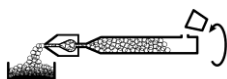


Clean Hopper and Screw Throat thoroughly

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.



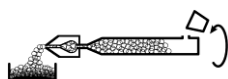
Check Additive Size is suitable

Dose one cup of **BBU** into the HOPPER THROAT followed by the next production 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.

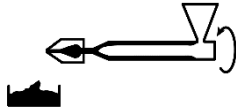
Continue purging one cup of each watching and comparing the screw torque required and the head pressure. If within safe limits increase the ratio to two **BBU** and one “next material”

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.**



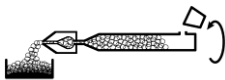
Empty Machine of last material



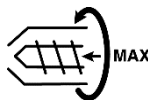
Clean Hopper and Screw Throat thoroughly

Remove screens from screen changer

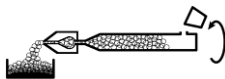
Turn off vent vacuum



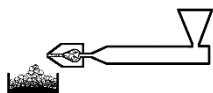
Dose **BBU** into the HOPPER THROAT until purge is evident at the die exit.



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)**

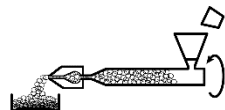


(STARVE)

Extrude until clear then run Screw empty



Clean Hopper and Screw Throat **thoroughly**

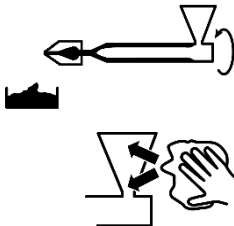
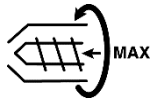
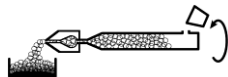
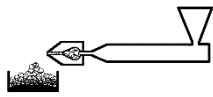
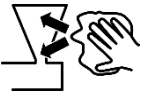
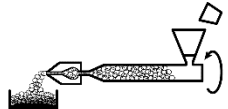


(FEED)

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	Remove screens from screen changer
Turn off vent vacuum	Turn off vent vacuum
	Increase Screw Speed to Maximum SAFE running conditions (Do not exceed max pressure or torque)
	Dose BBU into the HOPPER THROAT until all colour removed
	(STARVE) Extrude until clear then run Screw <u>empty</u>
	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	Repeat STARVE–FEED a minimum of 3 times then fill hopper completely

Safety Precautions	
 	Do not use BBU for material with processing temperatures below 160°C Do not use BBU for material with processing temperatures above 340°C
PPE	    Wear suitable protective clothing when cleaning down equipment, using, handling or viewing the hot or cold BBU
   	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