



aquapurge

REMOVE CARBON
RESTORE CONTROL



:PVCpurge

Injection Molding Instructions

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Removal of Loosened Carbon through a Screw and Barrel

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Standard Screw and Barrel Strip-Down Instructions

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Safety Information

General Safety Information, Refer to Health and Safety Document for Full Information

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DO NOT USE THROUGH FILTER OR MIXER NOZZLES OR ON HOT RUNNERS

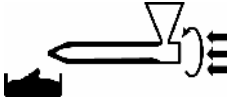
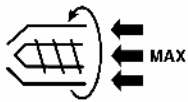
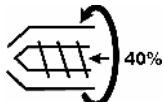
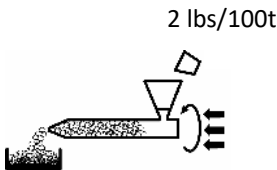
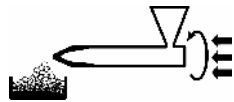
Aquapurge products are not intended to be incorporated in finished plastic goods. In the view of the many factors that may affect processing and application, users should make their own independent determination that the products are suitable for their intended use and can be used safely and legally.

Start-up Instructions

Explanation:

PVC Purge is an aggressive, stiff carbon removal system. It is designed to mechanically scrape carbon off screws, barrels and nozzles at normal processing temperatures.

Ensure Health & Safety Precautions are read and understood before use

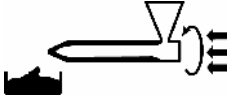
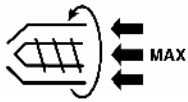
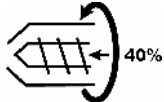
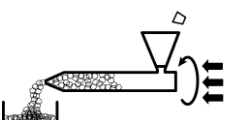
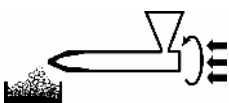
	Ensure Machine is empty of last production material
	Increase Back Pressure to Maximum
	Run Screw Speed at 40% of Maximum
	Initially dose 2 lbs per 100t of Machine (i.e. 500t = 10 lbs) Inspect the purge, if carbon choked and purge is green, repeat the above procedure until the purge is clear of carbon and blue / white in color
	(STARVE) Run Screw empty
	Clean Hopper and Screw Throat thoroughly
	Fill Hopper with next material and purge until clear

Strip-Down Instructions

Explanation:

PVC Purge is an aggressive, stiff carbon / material removal system. It is designed to mechanically scrape carbon and material off screws, barrels and nozzles at normal PVC processing temperatures

Ensure Health & Safety Precautions are read and understood before use

	Empty machine of last production material
	Increase Back Pressure to Maximum
	Run Screw Speed at 40% of Maximum
	Dose PVC Purge until clear
	(STARVE) Run Screw COMPLETELY empty Return Back Pressure and Screw Speed to standard settings
	Clean Hopper and Screw Throat thoroughly

Strip equipment and ensure all **PVC Purge** has been removed **HOT** before reassembly.

If hot, **PVC Purge** normally only requires rubbing with a rag to remove.

Safety Precautions

 	Do not use PVC Purge for material with processing temperatures below 320°F Do not use PVC Purge for material with processing temperatures above 410°F
	It is NOT recommended that PVC Purge is used through tools (<i>hot runners, manifolds etc.</i>) Not suitable for machines with nozzle filters, mixers, screens or diameters smaller than 0.1" (³/₃₂) (2.5 mm) Always purge behind a purge guard
PPE	    Wear suitable protective clothing when cleaning down equipment, using, handling or viewing the hot or cold PVC Purge
   	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