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# Extrusion Purging Instructions

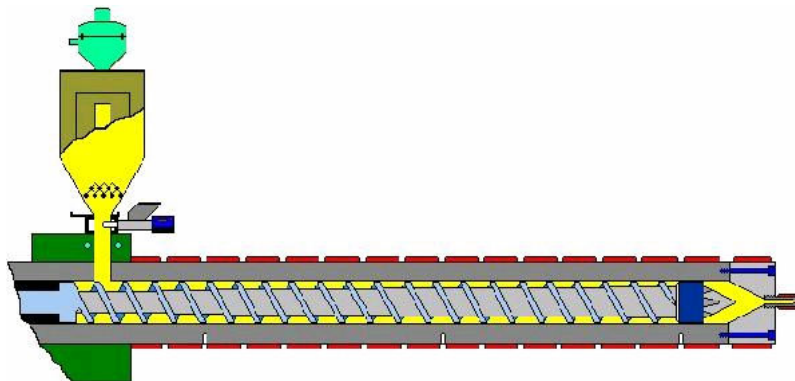
## ExtraPurge – XT™

**ExtraPurge - XT™** is an Odorless High Performance Chemical Purging Compound used to clean out plastic processing equipment.

**ExtraPurge - XT™ Concentrate** is a Free Flowing Powder-less Pelletized Highly Loaded Concentrate. It must be mixed with the appropriate carrier resin (**see Mixing Guidelines**) matching your process affording you the freedom to tailor the concentration to your cleaning needs.

**ExtraPurge - XT™ Redi-Mix Grades** specially formulated for your particular resins and individual process.

Both are extremely effective in removing degraded thermoplastic, rapidly changing colors and materials as well adding to your arsenal an extremely powerful weapon for Preventative Maintenance programs.



Your Fastest, Lowest cost Purging Solution™

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## FOR NON-HEAT SENSITIVE RESINS

- 1) Shut off resin feed to hopper and run the extruder empty of production resin. Manually clean the hopper and feed throat of residual production color and resin. Raise the temperatures on all mixing sections of the extruder and down stream plumbing including the die 50 – 100 degrees f. **Remember this is for non-heat sensitive resins** so check with your resin manufacturer to see if these temperatures are safe for your production resin. Prepare enough ExtraPurge to fill the extruder 2 – 3 times.
- 2) Pre Purge the machine with a High Density Polyethylene Resin until you see the remaining color or production resin exiting the system.
- 3) Fill the extruder rapidly until ExtraPurge exits the die.
- 4) Slow the screw to a minimum RPM for 15 – 20 minutes soaking the system keeping the throat full of ExtraPurge.
- 5) Run the extruder empty at RPM greater than normal production speeds.
- 6) Examine the purge exiting machine. If the purge pile contains significant contamination repeat above procedure.

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## FOR HEAT SENSITIVE RESINS

- 1) Shut off resin feed to hopper and run the extruder empty of production resin. Manually clean the hopper, and feed throat of residual production color and resin. Prepare enough ExtraPurge to fill the extruder 4 – 6 times.
- 2) Pre purge the machine with a High Density Polyethylene Resin until you see the remaining color or production resin exiting the system.
- 3) Fill the extruder rapidly until ExtraPurge exits the die.
- 4) Slow the screw to a minimum RPM for 15 - 20 minutes soaking the system keeping the throat full of ExtraPurge.
- 5) Run the extruder empty at RPM greater than normal production speeds.
- 6) Raise the temperatures on all mixing sections of the extruder and down stream plumbing including the die 50 – 100 degrees f. Repeat the above procedure.
- 7) Examine the purge exiting machine. If the purge pile contains significant contamination repeat above procedure.

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## FOR MULTI-LAYER DIES

- 1) Shut off resin feed to hopper and run the extruders empty of production resins. Manually clean the hoppers and feed throat of residual production color and resin. Raise the temperatures on all mixing sections of each extruder and down stream plumbing including the die 50 – 100 degrees f. Remember this is for non-heat sensitive resins so check with the resin manufacturer if these temperatures are safe for the resin. Prepare enough ExtraPurge to fill the extruder 2 – 3 times.
- 2) Pre purge the machine with a High Density Polyethylene Resin until you see the remaining color or production resin exiting the system.
- 3) Fill the extruder rapidly until ExtraPurge exits the die.
- 4) Slow the screw to a minimum RPM for 15 - 20 minutes soaking the system keeping the throat full of ExtraPurge.
- 5) Run the extruder empty at RPM greater than normal production speeds.
- 6) Examine the purge exiting machine. If the purge pile contains significant contamination repeat above procedure.
- 7) If the condition of some of the extruders known to be clean run a High Density Polyethylene through them at a minimum RPM for the duration of the purge procedure to eliminate contamination.

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