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# Injection Molding Machine Purging Instructions

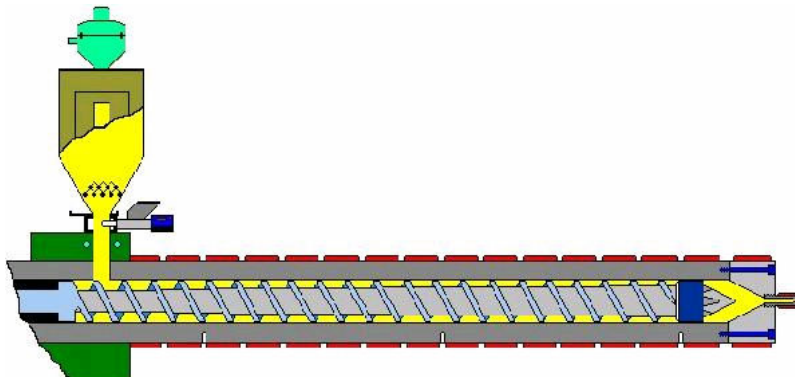
## ExtraPurge – XT™

**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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# Purging Instructions

## FOR NON-HEAT SENSITIVE RESINS

- 1) Shut off resin feed to hopper and run the screw and barrel empty of production resin. Manually clean the hopper and feed throat of residual production color and resin. **(Barrel Heat Raising is Optional)** Raise the temperatures on all sections of the screw and barrel, tip and nozzle 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 – XT™ mixture to fill the screw and barrel 2 – 3 times.
- 2) Pre Purge the machine with High Density Polyethylene Resin until you can see the bulk of the color or production resin exiting the system.
- 3) Fill the screw and barrel rapidly until the ExtraPurge – XT™ mixture drools out of the nozzle.
- 4) Stop the screw and let the ExtraPurge – XT™ soak for 10 minutes.
- 5) ExtraPurge – XT™ should continuously drool out of the nozzle, if the drooling stops start the screw until the drooling resumes (keep the throat full).
- 6) After 10 – 15 minutes run the screw empty at RPM greater than normal production speeds.
- 7) Examine the purge exiting machine. If the purge pile contains significant contamination repeat above procedure.

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# Purging Instructions

## FOR HOT MANIFOLDS / HOT RUNNERS NON HEAT SENSITIVE RESINS

- 1) Perform Purging Steps for Non-Heat Sensitive Resins.
- 2) Raise temperatures in the Hot Manifold / Hot Runners 100 – 200 degrees f. Prepare enough ExtraPurge to fill the whole system 4 – 6 times.
- 3) Once the Heats line out, Making parts in the mold pre-purge through the hot runners with a High Density Polyethylene Resin until you see the previously processed production color and resin exiting the system.
- 4) Fill the screw and barrel running the ExtraPurge - XT mixture into your machine on Manual. Shoot the ExtraPurge – XT™ mixture directly into the mold and hold closed for up to 5 minutes. Repeat the process shooting directly into the mold holding for up to a minute repeating this 4 – 6 times.
- 5) Empty the machine making shots.
- 6) Examine the purge exiting machine. If the purge pile contains significant contamination repeat above procedure.

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# Purging Instructions

## FOR HEAT SENSITIVE RESINS

- 1) Shut off resin feed to hopper and run the screw and barrel empty of your **heat sensitive** production resin. Manually clean the hopper, and feed throat of residual production color and resin. Prepare enough ExtraPurge – XT™ to fill the screw and barrel 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 screw and barrel rapidly until the ExtraPurge – XT™ mixture drools out of the nozzle.
- 4) Stop the screw and let the ExtraPurge – XT™ soak for 10 minutes.
- 5) ExtraPurge – XT™ should continuously drool out of the nozzle, if the drooling stops start the screw until the drooling resumes (keep the throat full).
- 6) After 10 – 15 minutes run the screw empty at RPM greater than normal production speeds.
- 7) Raise the temperatures on sections of the screw and barrel including the nozzle 50 – 100 degrees f. **Repeat the above procedure from Step 3 - 7.**
- 8) Examine the purge exiting machine. If the purge pile contains significant contamination repeat above procedure.

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