

Resin Mixing Matrix

ExtraPurge - XT Concentrate

to New Production Resin

from Current Production Resin	to ABS	to Acetals	to Acrylic	to Nylon	to PC	to PE	to PP	to PET	to PBT	to Styrene
ABS	HDPE	HDPE	Acrylic	HDPE	PC	HDPE	HDPE/PP	PET	HDPE	LDPE
Acetals	HDPE	HDPE	HDPE	HDPE	HDPE then PC	HDPE	HDPE/PP	HDPE then PET	HDPE	HDPE
Acrylic	HDPE	HDPE	Acrylic	PC	PC	HDPE	HDPE/PP	PET	PC	PC
Nylon	HDPE	HDPE	Acrylic	Nylon	PC	HDPE	HDPE/PP	PET	HDPE	HDPE
PC	HDPE	HDPE	Acrylic	Nylon	PC	HDPE	HDPE/PP	PET	HDPE	HDPE
PE	HDPE	HDPE	Acrylic	HDPE	PC	HDPE	HDPE/PP	PET	HDPE	HDPE
PP	PP	HDPE	Acrylic	HDPE	PC	HDPE	PP	PET	HDPE	HDPE
PET	HDPE	HDPE	Acrylic	HDPE	PC	HDPE	HDPE/PP	PET	HDPE	HDPE
PBT	HDPE	HDPE	Acrylic	HDPE	PC	HDPE	HDPE/PP	PET	HDPE	HDPE
Styrene	HDPE	HDPE	Acrylic	HDPE	PC	HDPE	HDPE/PP	PET	HDPE	Styrene

How to read this chart: From the column on the left find your current production resin. From the row on the top find the resin you are going to process next. Follow the row across from your current production resin to where it meets the column descending from your next production resin and that is the suggested resin you should use to mix ExtraPurge - XT with to form your purging compound.

Mixing Instructions: Use the chart above to find the proper resin to mix with the ExtraPurge - XT concentrate. Mix between 10 % ExtraPurge concentrate with 90 % by volume plastic resin. For extremely dirty or badly carbonized screws and barrels use 40 % ExtraPurge with 60 % Resin as indicated in the chart above. Mix enough material to fill the screw and barrel 1 - 2 times. For applications such as Injection Molding machines with Hot runners and manifolds, Injection Blow Molding machines, screw and shooting pot (Husky PET preform applications) prepare enough material to fill the machine 4 - 6 times. For instructions how to use ExtraPurge please refer to appropriate instructions for your type of process, i.e., Injection Molding (including injection blow, Injection Stretch Blow) Extrusion, Extrusion Blow Molding).

Recommended

LDPE = Low Density PolyEthylene Melt Index of 12

HDPE = High Density PolyEthylene Fractional Melt Index of 0.7

HMWPE = High Molecular Weight PolyEthylene Melt Index of 0.03

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