



SUGGESTED PURGING PROCEDURES for resin / color changeovers

Process: Blow molding extrusion

SAFETY FIRST: Before performing any procedure, it is the machine operator's responsibility to be aware of their company's safety policy, to wear the appropriate personal protective equipment, and to make sure that only authorized personnel are in the area.

CHANGEOVER PROCEDURE:

1. Maintain temperature and RPM settings for resident resin.
2. Disconnect or shut-off auxiliary feeding equipment and thoroughly clean the hopper.
3. Begin to empty barrel and, when resident resin is below the feed throat, introduce Dyna-Purge (1 to 2 times barrel capacity) into empty hopper or side port.
Note: actual amount needed depends on machine conditions.
4. Remove screen pack and ensure head clearance is at least .025 inch (.65mm).
Note: if unable to do either, refer to Dyna-Purge SF in the "Grade Selection Guide."
5. Purge continuously through the head until the purge is clean and free of contamination.
6. Thoroughly clean the hopper and adjust temperature settings for your next production resin.
7. Using your next production resin, flush out the remaining Dyna-Purge.
8. Thoroughly clean the head surface to remove any contamination and, if applicable, install new screen pack and make adjustments to head clearance.
9. Start production run.

▪ **see shutdown / start-up procedure for additional information** ▪

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