



SUGGESTED PURGING PROCEDURES for resin / color changeovers

Process: Blow molding injection

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. Retract machine carriage from mold, leaving ample room for purge to exit nozzle.
3. Disconnect or shut-off auxiliary feeding equipment and thoroughly clean the hopper.
4. Empty barrel and starve the screw of the resident resin.
5. Introduce Dyna-Purge (1 to 2 times barrel capacity) into empty hopper or side port.
Note: actual amount needed depends on machine conditions.
6. Set machine shot size between 50% and maximum allowable setting.
7. Purge until the compound flushed out of the machine is clean and free of contamination.
8. Thoroughly clean the hopper and adjust temperature settings for your next production resin.
9. Using your next production resin, flush out the remaining Dyna-Purge.
10. Thoroughly clean machine nozzle and sprue bushing to remove any contamination.
Caution: wear the appropriate personal protective equipment.
11. Move machine carriage forward to make contact with mold sprue bushing.
12. Start production run.

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

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