



## SUGGESTED PURGING PROCEDURES for resin / color changes and shutdown / start-up

### Process: Blown film extrusion- while maintaining bubble

**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 material feed system, ensuring all components including blenders, hoppers, loaders, filters, magnets, hoses, and drain ports are cleaned.
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. Inspect screen pack for contamination and replace, if necessary.
5. Purge through the die opening until Dyna-Purge appears in the film. Slow down the process and open the air ring to increase wall size. If necessary, adjust the airflow to stabilize the bubble.
6. Continue purging until the purge is clean and free of contamination.
7. Thoroughly clean the hopper and adjust temperature settings for your next production resin.
8. Using your next production resin, flush out the remaining Dyna-Purge.
9. If applicable, install new screen pack and readjust settings to achieve production gauge.
10. Start production run.

▪ see shutdown / start-up procedure on reverse side ▪

## **SHUTTING DOWN:**

1. Maintain temperature and RPM settings for resident resin.
2. Disconnect or shut-off auxiliary feeding equipment and thoroughly clean material feed system, ensuring all components including blenders, hoppers, loaders, filters, magnets, hoses, and drain ports are cleaned.
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. Inspect screen pack for contamination and replace, if necessary.
5. Begin to purge. Short bursts of high agitation (RPMs) will loosen build-up. Subsequently slowing the speed or stopping the screw allows the purge to expand and then push out the loosened contamination. Continue to alternate this process until the purge is clean.
6. Ensure barrel is filled with Dyna-Purge to prevent the chance of oxidation. Stop screw rotation and reduce the temperature by lowering or turning off the heat zones of the machine. Caution: as the purge solidifies, take care not to rotate screw.

## **STARTING UP:**

1. Turn on and/or raise the temperature to 50°F (10°C) above the minimum operating temperature of Dyna-Purge.  
Note: make sure to review start-up protocol on machinery for additional information.
2. When the desired temperature of Dyna-Purge has been reached, begin rotating the screw slowly to avoid too much torque. The purge may still be stiff, so do not rotate the screw at full RPM.
3. If the purge compound exiting the machine shows signs of contamination, introduce more Dyna-Purge until the compound flushed out is clean.
4. Thoroughly clean the hopper and adjust temperature settings for your next production resin.
5. Using your next production resin, flush out the remaining Dyna-Purge.
6. Thoroughly clean the die surface to remove any contamination and, if applicable, install new screen pack and make die gap adjustments.
7. Start production run.

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