



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

### Process: Injection molding- hot runner quick color change

**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.

#### PROCEDURE:

1. Maintain temperature and RPM settings and, when resident resin is below the feed throat, 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.
2. Introduce Dyna-Purge (1 to 2 times barrel capacity) into empty hopper or side port and continue to make parts until Dyna-Purge appears in the part.  
Note: actual amount needed depends on machine conditions.
3. With the nozzle still attached to mold base and mold in the open position, purge shots through the barrel and hot runners. If applicable, for difficult channels and gates, run more Dyna-Purge through them by closing off the other gates.
4. When Dyna-Purge is below the feed throat, thoroughly clean material feed system as described above.
5. Introduce the next production resin.
6. Using your next production resin, and with the mold still open, flush out the remaining Dyna-Purge.
7. Check gates in mold for any blockage or drool and start production run.

- see shutdown / start-up procedure on reverse side

## **SHUTTING DOWN:**

1. Maintain temperature and RPM settings for resident resin.
2. Retract injection unit from mold, leaving ample room for purge to exit nozzle.
3. 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..
4. Empty barrel and 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. With the screw in the forward position, purge until the compound flushed out of the machine is clean and free of contamination.  
Note: If unable to purge with the screw in the forward position, set machine shot size between 50% and maximum allowable setting.
7. 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 material feed system, ensuring all components including blenders, hoppers, loaders, filters, magnets, hoses, and drain ports are cleaned.and adjust temperature settings for your next production resin.
5. Using your next production resin, flush out the remaining Dyna-Purge.
6. Thoroughly clean machine nozzle and sprue bushing to remove any contamination.  
Caution: wear the appropriate personal protective equipment.
7. Move injection unit forward to make contact with mold sprue bushing.
8. Continue to run next production resin through hot runners until it is clean.
9. Check gates in mold for any blockage or drool and start production run.

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