



Extrusion Instructions

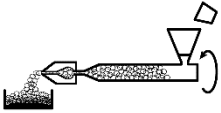
	Page
Removing Colour / Material Colour Changes Through a Screw, Barrel and Die	2
Carbon Removal Carbon Highlighting and Decarbonising	3
Safety Information General Safety Information, Refer to Health and Safety Document for Full Information	4

Aquapurge products are not intended to be incorporated in finished plastic goods. In the view of the many factors that may affect processing and application, users should make their own independent determination that the products are suitable for their intended use and can be used safely and legally.

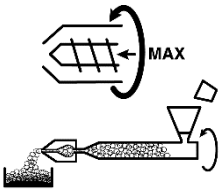
Colour / Material Change Instructions

Remove screens from screen changer and re-insert breaker plate

Set Melt Pump to manual
(the pump should not control the screw speed)

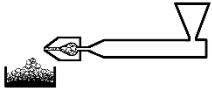


Add **PCP** to the extruder and purge until evident at the die exit



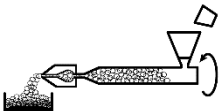
Increase Screw Speed to Maximum **SAFE** running conditions
(**Do Not** exceed max amperage or pressure) and continue purging until there are no signs of previous material or colour

If Removing Carbon (Decarbonising procedure) go to next page



Run Screw empty until pressure in die decreases below 60 bar

“Starve-Feed” the next production material 5 times (fill the hopper throat and empty the hopper throat 5 times), then empty the machine completely



Fill hopper throat with next production material and extrude until 90% clear

Stop extruder, remove Breaker Plate(s), manually clean any excess colour from adaptor, repack screens, refit and reset melt pump

Restart and extrude until extrudate is acceptable

Carbon Removal

PCP will highlight carbon during a colour change if your equipment has large deposits inside. This will generally start once most of the colour has been removed and the **PCP** is now flowing over the carbon choked surfaces. At this stage it is important to continue purging with **PCP** until all loosened carbon has been removed from the extrudate otherwise specs will come out over many metres of product.

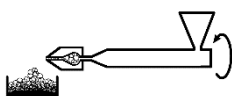
This carbon in the purge highlights the need to do maintenance by decarbonising using **PCP**. Decarbonising allows the surfactants in **PCP** to soak through the carbon cracks to loosen them whilst an additional additive causes the carbon to adhere to the polymeric carrier. For decarbonising to work effectively the machine needs to cool to ambient to allow the carrier to shrink and have the strength to pull the carbon off the metal surfaces. In most cases this can be carried out over a weekend but during the week is also possible with fans to aid cool down speeds.

Decarbonising Procedure Continued

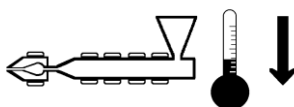
In summary the procedure follows the colour change procedure with following differences.

Keep purging until **all** signs of loosened carbon are removed

Run Screw empty until pressure in die decreases below 60 bar



Turn off the heats completely



It is now imperative that the machine is allowed to cool to ambient or at least, 80°C in the centre of the head, if not the carrier will not have enough strength or shrinkage to pull the carbon off the metal surface.

On start-up the carbon will be loosened and only requires another **PCP** colour change procedure to remove all the loosened carbon.



Safety Precautions



Do not use **PCP** for material with processing temperatures below 160°C



Do not use **PCP** for material with processing temperatures above 290°C

PPE



Wear suitable protective clothing when cleaning down equipment, using, handling or viewing the purging agent



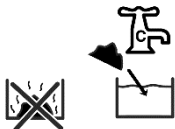
If contact with skin occurs, wash with cool water



In case of eye contact, irrigate with plenty of cool water



Do not swallow product



In situations of excessive shear heat place purgings in cool water to eliminate fumes