



PVCPurge

Injection Moulding Instructions

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Safety Information General Safety Information, refer to Health & Safety Document for full information	4

“DO NOT” use Through Filter Nozzles, Mixer Nozzles or Hot Runners

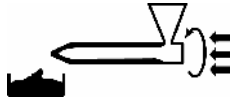
Aquapurge products are not intended to be incorporated in finished plastic goods. In the view of the many factors that may affect processing and application, users should make their own independent determination that the products are suitable for their intended use and can be used safely and legally.

PVC Purge

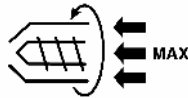
Start-up Instructions

Explanation: PVC Purge is an aggressive, stiff carbon removal system. It is designed to mechanically scrape carbon off screws, barrels and nozzles at normal processing temperatures.

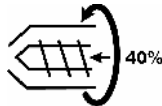
Ensure Safety Precautions are read and understood before use



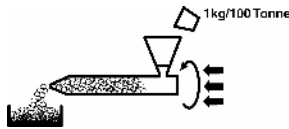
Ensure Machine is empty of last material



Increase Back Pressure to Maximum

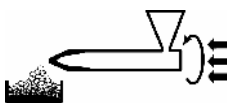


Run Screw Speed at 40% of Maximum



Initially dose 1 kg per 100 Tonne of Machine
(i.e. 500 Tonne = 5 kg)

Inspect the purge, if carbon choked and purge is green, repeat the above procedure until the purge is clear of carbon and blue / white in colour



(STARVE)
Run Screw empty



Clean Hopper and Screw Throat thoroughly



Fill Hopper with next material and purge till clear

PVC Purge

Strip-Down Instructions

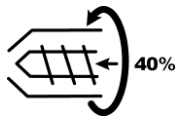
Explanation: PVC Purge is an aggressive, stiff carbon / material removal system. It is designed to mechanically scrape carbon and material off screws, barrels and nozzles at normal PVC processing temperatures



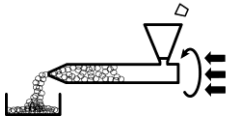
Empty Machine of last material



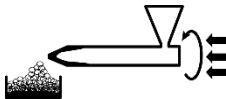
Increase Back Pressure to Maximum



Run Screw Speed at 40% of Maximum



Dose PVC Purge until clear



(STARVE)
Run Screw **COMPLETELY** empty

Return back pressure and screw speed to standard settings



Clean Hopper and Screw Throat **thoroughly**

Strip equipment and ensure all PVC Purge has been removed **HOT** before reassembly.

If hot, PVC Purge normally only requires rubbing with a rag to remove.

Safety Precautions



Do not use PVC Purge for material with processing temperatures below 160°C



Do not use PVC Purge for material with processing temperatures above 210°C



It is NOT recommended that PVC Purge is used through tools (*hot runners, manifolds etc.*)

Not suitable for machines with nozzle filters, mixers, screens or diameters smaller than 2.5 mm

Always purge behind a purge guard



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