

# TECH-PURGE WORKING INSTRUCTIONS

## TECH- PURGE PROCEDURE FOR INJECTION MOLDING

1. Ensure that the barrel is empty of material to be changed before introducing purge.
2. Pour purge into hopper. For the first time use, use approx. 2 to 3 times barrel capacity. After this use only what is required for normal use.
3. Rotate the screw ensuring that the back pressure is high enough to keep the screw forward, until material comes out of the nozzle. This will ensure that the heat is evenly distributed at the back end of the screw. The amount of time the purge needs to activate properly is 90 seconds from the time it hits the screw to the time it leaves the nozzle. If the time is less than this leave the material in the barrel until 90 seconds elapses.
4. This purge is also safe to purge through some larger manifolds on the tools. It is also recommended as this will help rid of contamination in the manifold.
5. If the purge that is coming out of the nozzle is brownish in color, then the purge is doing its job. If the material is blackish in color, then it has sat in the barrel too long and will not clean properly. You will need to complete the procedure again. At no time will the purge become white in colour. This is normal.
6. Repeat the extruder run until no more purge comes out of the nozzle or manifold. At this point simply introduce the next material to be used into the screw and start to purge it out. Run next material.

**Note: This material requires special instructions for use with  
Acytel materials.**

**\*\*\*Before the purge comes in contact with the Acytel you must first use Polypropylene then Tec-Purge then Polypropylene so that the purge is clear from the barrel.\*\*\***