

ASACLEAN MECHANICAL GRADE PURGING INSTRUCTIONS FOR EXTRUSION

1. Check that all zones are in the proper temperature range for the grade of ASACLEAN being used.
2. Run the barrel empty. Wipe the hopper and feed throat.
3. For unfilled grades of ASACLEAN, screens and dies may be left in place for purging (consult your Asaclean technical representative for mesh size and minimum die clearances required). If the machine is heavily contaminated and a glass-filled grade-(EX, PX2, and NF) is required, **remove the screen pack to prevent plugging. Remove the die as well if necessary.**
4. Feed 1-2 barrel capacities of ASACLEAN into the extruder.

Note: Feed ASACLEAN into the barrel at a rate which allows for filling the flights of the screws as best as possible.

5. Start purging at low screw speed; after material begins coming out from the head, increase the screw speed to the maximum safe level. Periodically stop the screw and allow the ASACLEAN to sit for a few seconds. Resume screw rotation at maximum screw speed.
6. Continue until most of the ASACLEAN is purged from the barrel.
7. Visually inspect the purge pile. The machine is clean and purging is complete when ASACLEAN coming from the machine is visually free of contamination.
8. Repeat steps 4-7 if contaminants are still visible.
9. Displace the ASACLEAN with the next resin, again at maximum safe screw speed.

- **Asaclean mechanical grades do not depend on chemical reactions.**
- **For maximum performance, ASACLEAN should not be diluted with other materials.**
- **ASACLEAN is most effective when pressure within the barrel is maximized.**

Tips to target specific areas of the extruder:

Vented Barrels

Special procedures may be required to effectively clean extruders with vented barrels. If you cannot plug the vents, contact Technical Service to discuss the most appropriate method for your situation.

Dies

Raising the temperature of the die 15-30°C (30-55°F), while remaining within the service temperature range for both the resin and ASACLEAN grade being used, may help remove material deposits more quickly. If purging a heat sensitive resin, do not exceed the safe processing temperature of the material. **If using a highly-polished or textured die, contact us before running a glass-filled ASACLEAN grade.**

Exercise proper safety precautions and use appropriate PPE.

Temperature Ranges:

<u>Grade</u>	<u>°C</u>	<u>°F</u>	<u>Grade</u>	<u>°C</u>	<u>°F</u>
U	180-330	355-625*	E	160-300	320-570
EX	200-330	390-625*	NC	180-330	355-625
UP	170-300	340-570	PX2	280-420	535-790
HP	170-300	340-570	PF	280-420	535-790
SX	300-370	570-700	NF	180-330	355-625*
NH	180-330	355-625*	NB	180-330	355-625

*If processing between 330°C-360°C(625°F-680°F), local ventilation is required.

Technical Questions?

To request detailed technical bulletins or technical support, contact us at Asahi Kasei Asaclean Americas Inc.

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