

ASACLEAN™ PF GRADE EXTRUSION PURGING INSTRUCTIONS

For High Heat Resins (280°C – 420°C (535°F –790°F))

Notes before purging:

- ASACLEAN PF Grade should not be left idle in the barrel for any period of time above 370°C (700°F) as decomposition may occur.
- Keep the barrel full of ASACLEAN PF Grade at all times to prevent oxygen from entering the barrel – excess oxygen will accelerate material decomposition and carbon formation.
- PF Grade works best if screen packs are removed. However, screens and dies may be left in place for purging with the ASACLEAN PF Grade as long as the screen does not exceed 100 mesh (only 1 layer of mesh). Special procedures may be required to effectively clean extruders with vented barrels. If possible, plug the vents. If the vents cannot be plugged, contact Technical Service to discuss the most appropriate options.
- While purging, it is recommended that a bucket of water be kept near the machine. Place ASACLEAN PF Grade purge piles in water immediately after coming out from the nozzle.

Purging Instructions:

1. Upon completion of the production run, extrude the high heat resin from the machine, emptying the barrel. Purging must begin as soon as possible. Thoroughly clean the hopper and feed throat.
2. Feed about 1 system capacity (barrel and die) of ASACLEAN PF Grade into the hopper. Start purging at a slow screw speed. After the ASACLEAN PF Grade starts coming out of the extruder, increase the screw speed to a moderate level. Several times during the purge, stop the screw and allow the ASACLEAN PF Grade to sit for about 30 seconds, then resume screw rotation. If resin contamination is still visible in the purge pile, repeat this step until clean.

Note: If processing temperatures are at or near the maximum recommended temperature for ASACLEAN PF Grade, a low to medium screw speed is recommended. Screw speed can be increased at lower temperatures within the recommended range to maximize cleaning.

3. After the machine is clean, and extrude the ASACLEAN PF Grade from the machine, emptying the barrel, as far as possible, start feeding the next resin to be processed. Displace the ASACLEAN PF Grade with the next resin following the same purging procedures above.
4. After all of the ASACLEAN PF Grade has been displaced, begin production using normal processing conditions for the resin.

Technical questions? Contact us at Asahi Kasei Asaclean Americas:

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