

ASACLEAN EXTRUSION PURGING INSTRUCTIONS **for Transitions from High Heat Resins to Other Resins using PX2 Grade**

Above 360°C (680°F) to below 300°C (570°F)

Screens must be removed before purging with the ASACLEAN PX2. Consult Technical Service to discuss whether or not it's possible to purge through the die. 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.

1. Upon completion of the production run, extrude the high heat resin from the machine, emptying the barrel. Clean the hopper and feed throat.
2. Purge out of first resin prior to dropping temps.

Note: ASACLEAN PX2 should not be left idle in the machine for ANY period of time at ANY temperature.

3. Drop temps to next resin processing temperature.
4. When 280°C - 300°C (535°F - 570°F) is reached, begin feeding a lower temperature, non-glass filled grade of ASACLEAN that is rated to the temperature range of the next resin.

Note: If processing temperatures are at or near the maximum recommended temperature for the PX2 Grade, start with low to medium screw speed. Screw speed can be increased at lower temperatures within the recommended range to maximize cleaning.

5. Using maximum safe screw speed, run until all of the ASACLEAN PX2 is displaced by the lower-temperature ASACLEAN grade. Leave the barrel full of the lower-temperature grade and stop the screw. The lower-temperature grade should have a slightly different appearance than the ASACLEAN PX2. The lower-temperature grade should not be left at temperatures above 300°C (570°F) for more than 30 minutes. If it takes longer than 30 minutes to get to the required lower temperature, run a fresh barrel of ASACLEAN and continue dropping temperatures.
6. Do not allow the temperatures in the barrel to drop below 280°C (535°F) with ASACLEAN PX2 in the barrel as overloading of the screw may occur during rotation.
7. When the temperature drops into the processing range of the lower-heat resin, empty the ASACLEAN from the barrel. Then start feeding the next resin to be processed.
8. Completely displace all ASACLEAN with the next resin and begin production.

Technical questions? Contact us at Asahi Kasei Asaclean Americas Inc.:

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