

ASACLEAN EXTRUSION PURGING INSTRUCTIONS
for removal of high heat resins for pre-maintenance cleaning using PX2 Grade
(Above 360°C, 680°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. Set system temps to 315°C - 325°C (600°F - 620°F). Do not allow the temperatures in the extruder to drop below 280°C (535°F) with ASACLEAN PX2 in the barrel as overloading of the screw may occur when screw rotation resumes.
4. Displace the ASACLEAN PX2 with lower temperature glass-filled ASACLEAN EX grade to remove deposits from the screw and barrel and to make it easier to pull the screw. Follow the standard “ASACLEAN PURGING INSTRUCTIONS for PRE-MAINTENANCE CLEANING and SCREW PULL.” An unfilled grade of ASACLEAN, such as ASACLEAN U, can be used to clean the screw and barrel, instead of the EX grade, but may not be as effective at removing stubborn deposits.

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

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