

# ASACLEAN™ NCT GRADE EXTRUSION PURGING INSTRUCTIONS

**For High Heat Resins 175°C – 360°C (345°F – 680°F)**

1. Empty the system of production resin. Do NOT remove die.
2. Make sure feed areas are clean.
3. Flush the machine by running 1-4 system volumes of clean, natural HMW-HDPE.  
Run system empty.
4. Add ASACLEAN NCT at normal screw speed until the purge extrudes uniformly from the die.
5. Soak the system with the screw turning at minimum controllable rpm for 20-30 minutes (if sealing, turn off all heaters with the system full of ASACLEAN NCT).

**If transitioning to a resin with a lower processing temperature, stay at initial operating conditions until the system is clean. ASACLEAN NCT is heat activated and works best in the 260°C - 315°C (500°F - 600°F) range.**

6. Empty system.
7. If contamination is visible as the last of the ASACLEAN NCT exits the die, repeat steps 4-6.
8. Set temperature profile for next resin to run.
9. When safe, displace the ASACLEAN NCT with the next resin.
10. Begin production under normal processing conditions.

## Technical Questions?

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

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