

NOTE 3 - NOZZLE AND CHECK RING HANG-UP

Occasionally color or degraded resin particles will hang up stubbornly in the nozzle or check ring area. This should be addressed with modest use of heat and increased agitation. If the nozzle is the problem, raise the temperature of the nozzle 50°F (30°C). If the check ring is the source of the problem, drop the backpressure and with the screw rotating, retract it in quick “pulses” to lift the check ring and dislodge the contamination. In both instances, follow up with short high-pressure purge shots to complete cleaning.

NOTE 4 - OPEN-MOLD PURGING OF HOT MANIFOLDS

If system design permits, a hot manifold may be purged by extruding InstaPurge™ through the mold at a safe velocity with little or no backpressure, using maximum safe screw RPM.

NOTE 5 - GRADE SELECTION

InstaPurge™ is available as a filled or unfilled product. The filler gives the product additional “scrubbing” effectiveness for difficult changeovers, but extensive use over a long period may cause wear in soft metal finishes. NOVACHEM recommends use of the unfilled grade where: (1) the more aggressive nature of the filled material may cause concern, (2) the equipment has narrow passages (less than 0.040in. (1.0mm)) that might become blocked, or (3) the next production resin is of such low viscosity (e.g., flexible PVC, LDPE, etc.) that removal of a filled cleaning compound could be difficult. Otherwise, the filled grade can be used. *Use of the filled grade is not recommended for hot manifolds.*

NOTE 6 - OPERATING PRINCIPLES

InstaPurge™ gains its purging effectiveness from three factors:

- The proprietary formulation works in combination with a high level of agitation during the purging process to dislodge contaminants.

**FOR TECHNICAL SUPPORT OF InstaPurge™
CLEANING COMPOUND, CONTACT NOVACHEM:**

ON THE INTERNET AT www.instapurge.com

BY TOLL-FREE TELEPHONE AT 1-800-762-3984

BY TELEFAX AT 1-203-367-0647.

NOVACHEM

955 Connecticut Avenue, Bridgeport, Connecticut 06607-1222

<http://www.instapurge.com>

Toll Free: 1-800-762-3984

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WHAT IS INSTAPURGE ?

InstaPurge™ Commodity-Grade Cleaning Compound from NOVACHEM is a mechanical purging agent that dislodges the residues of previous production colors and resins that remain on cylinder walls and screws after the barrel is run empty. It permits these residues to be quickly removed from the machine and is then readily purged from the barrel by the next production color or resin. The machine is back to producing good parts with minimum

INSTRUCTIONS FOR USE IN INJECTION MOLDING EQUIPMENT

InstaPurge™ Cleaning Compound from NOVACHEM is recommended for the following situations:

- Conventional reciprocating screw injection molding systems. If equipped with hot runner systems, refer to the separate instructions that begin at the bottom of Page 2.
- All thermoplastics processed at temperatures between 350°F and 630°F (175°C and 332°C). For elevated temperatures, see

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INSTRUCTIONS FOR USING InstaPurge™

1. **VERIFY** that the temperature of each heating zone is at an appropriate level (at least 350°F (175°C) but not above 630°F (332°C) — see Note 1 on Page 3).
2. **EMPTY** the machine of the production resin as thoroughly as possible; if backpressure and screw speed are adjustable you can use maximum backpressure and high screw speed to empty the barrel most effectively. Results may be enhanced by pre-flushing the machine with clean natural resin. If you choose to pre-flush, refer to Note 2 on page 3.
3. **LOAD** the hopper with the required amount of InstaPurge™ Cleaning Compound. In a typical purging situation, about one to two barrel capacities of InstaPurge™ should be needed. More or less material may be required, depending on such things as the difficulty of the application and the condition of the equipment. Start with one barrel capacity and adjust as conditions dictate.
4. **FILL** the barrel with InstaPurge™ Cleaning Compound by rotating the screw. For best results, keep the reciprocating screw forward, and backpressure at maximum. Use normal screw RPM until InstaPurge™ begins to emerge from the nozzle — then increase to maximum safe RPM.
5. **PURGE** the system empty of InstaPurge™ when the material emerging from the nozzle is almost clean. Do this by dropping the backpressure (if raised) to normal level and performing high-velocity purge shots. If the machine was heavily contaminated, and contamination is visible as the last of the InstaPurge™ empties from the machine, repeat steps 3 through 5. If nozzle or checking hang-up is suspected, see Note 3 on Page 4.
6. **RUN** new production material through the system until all traces

INSTRUCTIONS FOR USE IN HOT MANIFOLDS

1. **EMPTY** the system of the production resin as thoroughly as possible. Results may be enhanced by pre-flushing the machine with clean natural resin. If you choose to pre-flush, refer to Note 2

2. **RAISE** the manifold temperature 50°F (30°C) to increase flow *provided this can be done without exceeding temperature limitations of the equipment or the materials involved*. Otherwise, leave heats at operating temperature.
3. **PRE-PURGE** the screw and barrel (while retracted from the mold) using steps 3 through 5 of the basic instructions shown on Page 2. Then, move the screw and barrel back to the mold.
4. **LOAD** the hopper with the required amount of InstaPurge™ Cleaning Compound. Start with 1/2 of the barrel capacity and adjust as conditions dictate.
5. **INJECT** InstaPurge™ through the manifold, ejecting the parts immediately (while warm). De-molding of the purge material may be easier if a mold release is used and shot size is reduced. (See Note 4 on Page 4 for an alternate method.) Continue until InstaPurge™ parts are visually free from color and/or carbon contamination. Then, inject parts until the system runs empty.
6. **PURGE** the residual InstaPurge™ from the system by running the next production resin, molding parts until no InstaPurge™ can

ADDITIONAL NOTES AND INFORMATION

NOTE 1 - ELEVATED TEMPERATURES

It is recommended that you avoid subjecting InstaPurge™ Cleaning Compound to temperatures above 630°F (332°C). In this thermal environment some polymers used in InstaPurge™ may begin to decompose and release irritant vapors. This should not be an issue if exposure to temperatures near 630°F (332°C) is brief (a few minutes). For regular use with materials processed above 630°F (332°C), contact NOVACHEM to discuss alternative products.

NOTE 2 - PRE-FLUSHING

For some difficult changeovers, results may be enhanced by pre-flushing with clean natural resin before loading the cleaning compound. This will push most of the residual production resin out of the machine. If you choose to pre-flush, use resin as stiff as, or stiffer than the production resin that is being displaced and of a resin type similar to either the initial or succeeding production resin. Flush