# PurgeMax® EZ

High Performance Cost Saving Purging Solution

## TIPS BEFORE USE:

If you cannot decide how many kilograms of resin should be used for purging?

First time user, prepare 50% of your average purging resin quantity used.

For illustration:

Normal purging resin quantity is 10kg. Prepare 5kg of your usual purging resin (crushing/original), follow the Purging Guideline and start purging process. Continuous purging until purging resin becomes natural and clean. The total quantity of purging resin used for purging are your wastage and the rest would be your saving.

## PURGEMAX EZ Results After Use:

- Effectively reduce material wastage up to 80%
- Reduce machine downtime up to 50%
- Improve the lifetime condition of machine's screw and barrel.
- The result of the cost savings can be treated as the KPI assignment, please use our Cost-to-purge calculation sheet

## PURGING GUIDELINE AND TROUBLESHOOTING

### Purging guideline – Standard (Injection Moulding)

Step 1: Maintain processing profile for resin in the machine.
Step 2: Empty the screw and barrel of residual resin.
Step 3: * Premix purge resin with PurgeMax®EZ into polybag or container for evenly shaking purpose and pour into the hopper.
Step 4: ** Continue purging until resins appear to be clean and no bubbles appearance.
Step 5: Once the purging process is completed, resume standard procedure for the next job.

*i) Standard mixing ratio (For new machine & fast color change)
1 Kg = 1% - 2% = 10ML ~ 20ML = recommend 15ML
2Kg = 30ML or 3Kg = 45ML

ii) Standard mixing ratio (Machine > 10 years & fast color change)
1 Kg = 2%- 4% = 20ML ~ 40ML = recommend 30ML
2Kg = 60ML or 3Kg = 90ML

iii) If your machine is heavy contaminated with black spot and for 1st time use
1 Kg = 5% = 50ML
3 Kg = 150ML

** For hot runner and manifold system, purge a small amount from the nozzle before proceed to open mold purging or injection.

Note: Repeat step 3 to step 5 if needed. It is normal to experience a small amount of vapour which may appear during purging process.

| Screw Diameter | mm | < 20 | 20-40 | 40-60 | 60-80 | 80-100 | 100-120 | 120-140 | 140-160 | 160-180 | 180-200 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Recommended resin qty for mixing | kg | 0.5 | 1-2 | 2-3 | 3-4 | 4-5 | 5-6 | 6-7 | 7-8 | 8-9 | 9-10 |
| | lbs | 1.1 | 2.2-4.4 | 4.4-6.6 | 6.6-8.8 | 8.8-11 | 11-13.2 | 13.2-15.4 | 15.4-17.6 | 17.6-19.8 | 19.8-22 |

### TROUBLESHOOTING TIPS:

| Case Studies | Troubleshooting |
|---|---|
| Can I adjust low to high temperature type of resins, 150$^0$C to 350$^0$C? | For change of resin type; e.g from PVC to PC/ Nylon, we encourage to use the intermediate resin such as PP, ABS to obtain desired purging result. |
| What should I do for heat sensitive resin? | PVC and FR filled resin are heat sensitive resin. Carbonization due to heat oxidation can lead to degradation within few minutes. Always make sure the barrel is not left empty for long time and if so, load a small amount of purging resin before load PurgeMax®EZ. |
| What if the purging result forms melt plastic? | Use probe to test the melted resin to confirm the temperature due to overheat. Reduce barrel temperature even further and continue standard purging procedure. If melted resin happens again, repair or exchange the parts that produce unfavourable flow. |


For more questions, please write to **office@purgemax.eu** or **petros@purgemax.eu**

Available in 500ml

EN 71 NON TOXIC RoHS Compliant