

Case Study

1st part now passes quality inspection as Dyna-Purge[®] helps injection molder revive product line.



Brett Industries purchased the renowned line of Williams Brothers models, inheriting two injection molding machines that had only been purged by running shots of resin. Initial purging with Dyna-Purge removed a considerable amount of build-up, according to the company, and Dyna-Purge continues to clean the machines as part of mandatory standard operating procedure.



Before using Dyna-Purge, black specks appeared intermittently during runs, as shown in the model product (above left). Purging with Dyna-Purge reduces waste and improves overall quality as the first part of the run (above right) is now free from contamination. **In fact, a typical run of 202 flesh-colored parts after purging with Dyna-Purge had zero rejects.**

Situation:

When Daniel Brett purchased the rights to Williams Brothers, Inc., a manufacturer of model cars and air-planes, he acquired two aging plastic injection molding machines, a Toyo 145ES built in 1986 and a Boy 50T built in 1983.

With no evidence of previous purging history Brett began using the machines and found that black specks were present at the start of the run, intermittently during runs, and particularly prominent in light colored runs. His initial purging procedure consisted of cleaning the hopper, filling it with the next resin and running it until usable parts could be produced. **After more than ten shots at 100% shot size, it still wouldn't entirely solve the specking problem. Start-up with the resin inside also produced discolorations due to over heating the resin.**

Solution:

Use Dyna-Purge M, an engineered purging compound for use with a wide range of resins processed at temperatures from 350° to 600°F (177° to 315°C).

Results:

- **After purging with Dyna-Purge, discoloration and black specks were eliminated, and rejects have been reduced to zero.**
- Color and resin changeover were greatly improved using only 1/2 lb. of Dyna-Purge to purge.
- Overnight shutdown with Dyna-Purge keeps the barrel cleaner and makes start-ups easier.
- **Purging with Dyna-Purge is now a mandatory operation.**

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