



## **DYNA-PURGE<sup>®</sup> B**

### **Product Information Sheet**

#### ***Designed for Injection and Extrusion Blow Molding***

**DYNA-PURGE B** is a non-abrasive, non-chemical “engineered” thermoplastic purging compound, formulated to flow naturally through the barrel and accumulator head. A non-melting but softening thermoplastic scrubs the screw and barrel, while the carrier matrix flushes away impurities.

#### **FEATURES & BENEFITS OF DYNA-PURGE B**

- Excellent for color changes, resin changes, preventative machine maintenance, and before manual cleaning
- Developed for purging through the barrel and die head with a minimum clearance of .025 inch (.65 mm)
- Effective through a wide temperature range 320°F to 575°F (160°C to 302°C)
- Easy to use – no process adjustment necessary – use at the resident resin processing temperature and RPM speed
- Non-abrasive, non-melting but softening thermoplastic, which thoroughly loosens carbonized and degraded resin, allowing it to be flushed out of the system
- Safe, non-hazardous, with no chemicals – ingredients are FDA compliant
- Heat stable – recommended during shutdown and start-up
- Low “cost-per-purge” – only small quantity needed to be effective
- No mixing required – simply use “as is”
- Unlimited shelf life

Dyna-Purge is the top performing purging compound on the market today. The product line offers superior cleaning and economic value over in-house methods and other commercial purging compounds. We invite you to sample Dyna-Purge at no charge, so you can prove it to yourself. Dyna-Purge, the industry leader for over 25 years!

***See other side for information on “Suggested Operating Procedures”***

## SUGGESTED OPERATING PROCEDURES DYNA-PURGE® B

	INJECTION	EXTRUSION
<b>Temperature Range:</b>	320° F - 575° F (160° C - 302° C)	320° F - 575° F (160° C - 302° C)
<b>Types of Resins:</b>	All	All
<b>Minimum Orifice:</b>	Nozzle- .025 inch or .65 mm	Die- .025 inch or .65 mm
<b>Hot runner systems:</b>	N / A	N / A
<b>Screen Packs or other flow restrictions:</b>	Must have minimum clearance of .025 inch (.65 mm)	Combination of 20, 40, 60, or 80 mesh; 100 or more, use SF
<b>Amount of Purge:</b>	Approx. 2 lbs.(.9 kgs) per diameter inch(2.5 cm) of screw	Approx. 10 lbs.(4.5 kgs) per diameter inch(2.5 cm) of screw; L:D dependent

**SAFETY FIRST:** Before performing this procedure, it is the machine operator's responsibility to be familiar with the equipment in use, to wear the appropriate personal protective equipment, and to make sure that unauthorized persons are clear of the affected area.

### **SUGGESTED PROCEDURE FOR PURGING THE BARREL, SCREW AND ACCUMULATOR**

1. Maintain temperature / RPM settings used for resident resin.
2. If applicable, retract nozzle from mold, leaving ample room for purge to exit nozzle.
3. Thoroughly clean the hopper. Empty barrel, starve the screw, and empty accumulator of resident resin.
4. Aggressively meter Dyna-Purge, one scoop at a time, into empty hopper or side port. (Actual amount used depends on the condition of the machine prior to purging.)
5. Purge continuously through the die or nozzle opening and, if applicable, through the accumulator.
6. Continue to add Dyna-Purge until the compound flushed out of the machine is clean and free of contamination.
7. Adjust the temperature settings for your next production resin.
8. Flush out Dyna-Purge residue with next resin.
9. Start to make parts with next resin.

**YOUR EQUIPMENT IS NOW READY FOR YOUR NEXT PRODUCTION RUN!**

- SEE OUR SUGGESTED PROCEDURES FOR SHUTDOWN & START-UP ●

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