



## **DYNA-PURGE® M**

### **Product Information Sheet**

***Most versatile & widely used in the Plastics Industry***

**DYNA-PURGE M** is a versatile non-abrasive, non-chemical “engineered” thermoplastic purging compound, formulated to flow naturally through the barrel and hot runner system of the injection molding machine, as well as extrusion equipment. A non-melting but softening thermoplastic scrubs the screw and barrel, while the carrier matrix flushes away impurities.

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

- Developed for color changes, resin changes, preventative machine maintenance and before manual cleaning
- Excellent for purging through hot runner systems with a minimum clearance of .030 inch (.75 mm)
- Effective through a wide temperature range 350°F to 600°F(177°C to 315°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® M

	INJECTION	EXTRUSION
<b>Temperature Range:</b>	350° F - 600° F (177° C - 315° C)	350° F - 600° F (177° C - 315° C)
<b>Types of Resins:</b>	All	All
<b>Minimum Orifice:</b>	Nozzle- .030 inch or .75 mm	Die- .030 inch or .75 mm
<b>Hot runner systems:</b>	.030 inch (.75 mm) minimum melt channel & gate clearance	N / A
<b>Screen Packs or other flow restrictions:</b>	Must have minimum clearance of .030 inch (.75 mm)	Must be removed (otherwise use Dyna-Purge X or SF)
<b>Amount of Purge:</b>	Approx. 2 lbs.(.9 kgs) per diameter inch(2.5 cm) of screw	Approx. 10lbs.(4.5kgs) 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.

### **STEP 1 - PROCEDURE FOR THE BARREL AND SCREW**

1. Maintain temperature / RPM settings for resident resin.
2. Retract nozzle away from mold, leaving ample room for purge to exit nozzle.
3. Thoroughly clean the hopper.
4. Empty barrel and starve the screw of the resident resin; leave screw forward.
5. Set machine shot size between 50% and maximum allowable setting.
6. Rotate the screw and aggressively meter Dyna-Purge, one scoop at a time, into empty hopper or side port until screw retracts to appropriate shot size setting. When the screw reaches the shot size set point, move the screw forward and repeat the process until the purge is clean and free of contamination.

**Note:** On some open nozzle machines, the screw may not move back while rotating/feeding Dyna-Purge into barrel. If so, continually purge Dyna-Purge through nozzle until purge is clean and free of contamination. (Actual amount used depends on the condition of the machine prior to purging.)

### **STEP 2 - PROCEDURE FOR THE HOT RUNNER SYSTEM**

1. Move the nozzle to the mold base.
2. Bring the temperature of the hot runner system to approx. 500°F (260°C).
3. Meter Dyna-Purge, one scoop at a time, into the empty hopper or side port.
4. With the mold plate open, begin to purge.
5. Continue to add Dyna-Purge until the purge is clean and free of contamination. Empty the barrel and mold, and starve the equipment of Dyna-Purge.
6. Adjust temperature settings for your next production resin.
7. Flush out Dyna-Purge residue with next resin.
8. 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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