

# Use Directions for **CylaPurge**<sup>®</sup> Extruder Purging Compound

A fast, safe and effective universal purge  
for all resins and colors.

### **IMPORTANT INFORMATION**

*CylaPurge is made by a patented process and is unique. Unlike most other purges, it uses your current molding resin. Foreign resins used in other purges can take hours in some cases to completely clear out. When a machine is cleaned with CylaPurge, you can immediately begin molding good parts. With CylaPurge, you do not increase barrel temperatures, and you do not soak the purge in the unit. CylaPurge combines maximum cleaning with minimum downtime and rejects.*

- **Always Pre-Mix CylaPurge concentrate** at the ratio of one purge pack (65g) to one gallon (5 lbs.) of new color or natural resin. This is the Purge Mix. Before beginning the Purge Cycle, see chart below for suggested Purge Mix volumes.

| <b>Suggested Purge Mix Volumes for Each PURGE CYCLE</b> |                          |                           |                          |                            |                            |
|---|--------------------------|---------------------------|--------------------------|----------------------------|----------------------------|
| Barrel Diameter   | 1"-1½"                   | 1½"-2"                    | 2"-4½"                   | 4½"-8"                     | 8"-10"                     |
|   | <i>23-38mm</i>           | <i>38-50mm</i>            | <i>50-114mm</i>          | <i>114-203mm</i>           | <i>203-254mm</i>           |
| Purge Mix   | 1 Quart<br><i>1¼ Lbs</i> | 2 Quarts<br><i>2½ Lbs</i> | 1 Gallon<br><i>5 Lbs</i> | 2 Gallons<br><i>10 Lbs</i> | 3 Gallons<br><i>15 Lbs</i> |

- Always run barrel empty before starting Purge Cycle.
- Run a Purge Cycle by feeding the suggested volume of Purge Mix to the screw. Allow the Purge Mix to completely clear the feed, and then add just enough new color or natural resin to push the foamed resin from the barrel (this is usually close to the same amount as the Purge Mix volume). The Purge Mix will foam the barrel contents, capturing colors and carbon in the foam, and the chase resin will clear the contaminated foamed resin from the barrel. If the chase resin still shows contamination, repeat the procedure. Depending upon machine, material and processing conditions, from 1 to 3 Purge Cycles will normally be required.
- CylaPurge is a fast, continuous-run purge. Do not soak. Do not change normal resin processing temperatures.



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# PURGING TIPS

- **Injection Molding Machines** - Part screw from mold before purging, and run screw at medium speed. Run a Purge Cycle with screw held forward, and if additional cleaning is required, follow with a Purge Cycle with full barrel inject cycles (air shots). Repeat sequence until unit is clean.
- **Hot Runners** - Insure that hot runners are open before purging. Purge barrel as above with screw parted from the mold before purging hot runners. Purge with mold open.
- **Blow Molding Machines** - Run barrel and accumulators empty before purging operation and between Purge Cycles.
- **Sheet, Film and Compounding Extruders** - Remove screens and filters, since dislodged carbon and gels will plug them. Run screw at medium speed and empty barrel between Purge Cycles. Close vents if so designed to prevent foamed resin from exiting through vents. When purging through a die, increase screw speed to clean edges of die.
- **Resin Changes** - Run a single charge of Purge Mix made with the same resin that is in the machine. Use the new resin as a chase, and run additional Purge Cycles using the new resin for both the Purge Mix and the Chase Resin.

*When switching from a very High Heat resin (such as PEI or PES) to a much Lower Heat resin (such as LDPE) it is advisable to add an Intermediate Heat resin (such as PC) to the purging scheme. Feed a single charge of Purge Mix made with the High Heat resin, drop heats, chase with plain Intermediate Heat resin, feed a single charge of Purge Mix made with Intermediate Heat resin, drop heats and chase with Low Heat resin. Run additional Purge Cycles using Low Heat resin for both Purge Mix and Chase Resin.*

- **Caution** - Foamed resin has a low viscosity, is compressible, and can be ejected further than normal resin, especially during release through plugged orifices which clear during purging. Do not stand in front of dies, nozzles, runners, vents, etc., and take care that all personnel are protected from hot ejecting resin.

## Purging Time Guidelines

| Barrel Diameter   | 1"-1½"<br>23-38mm | 1½"-2"<br>38-50mm | 2"-4½"<br>50-114mm | 4½"-8"<br>114-203mm | 8"-10"<br>203-254mm |
|---|-------------------|-------------------|--------------------|---------------------|---------------------|
| Estimated maximum time to clean and be ready for production | 10 min.           | 20 min.           | 30 min.            | 40 min.             | 45 min.             |

**Questions? Call 1-330-492-2854 or Fax us at 1-330-492-3956**

The above estimated purging times to clean an average machine of a specific size are based upon field experience. If your times are significantly above these listed times, we suggest you call us at 330-492-2854 for additional recommendations on how to improve your purging times.

# ***CylaPurge***<sup>®</sup>

## **SUPER CONCENTRATE PELLETS**

**SPECIAL INSTRUCTIONS FOR HIGH TEMPERATURE,  
HIGH VISCOSITY RESINS SUCH AS  
LCP, PES, AND PEI (ULTEM\*).**

PLEASE READ ENTIRE INSTRUCTION SHEET CAREFULLY BEFORE PROCEEDING.

The last amount of high temperature resin fed to the unit should contain CylaPurge mixed at the ratio of 1 packet of CylaPurge per gallon of high temperature resin. Run barrel empty, and then feed a quantity of this mixture equal to at least the screw volume. Run barrel empty again and drop heats to 650°F. Follow with high molecular weight LEXAN\*, such as 3413 glass filled, or series 100 material until clean LEXAN appears at discharge. Lastly, adjust heat to normal running temperature for the LEXAN you are using and run three LEXAN purge cycles (each purge cycle consists of 1 mixed volume of CylaPurge/LEXAN followed by an equal volume of LEXAN) as per general instructions.

Unit can be switched from LEXAN to another resin such as HDPE by following the resin change procedures in the general instructions (run barrel empty, add CylaPurge to the last quantity of LEXAN fed to the unit, feed straight HDPE, then follow purge procedure with HDPE. Adjust heats to prevent charring of resin).

**Note:** Depending upon screw size, less than a gallon of mixed purge material may be required. For smaller quantities, mix 1/4 packet of CylaPurge per quart of resin.

\*ULTEM & LEXAN are registered trademarks of GE Plastics.

**PROBLEMS? Call (330) 492-2854**