

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 from 20% up to 80%.
- Reduce machine downtime to cost savings 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: * Place mixed resin with **PurgeMax®EZ** into the hopper.
 Step 4: ** Purging process can be done by purging or injection.
 Step 5: *** Continuous purging until resin appears to be natural.
 Step 6: 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% - 3% = 10ML ~ 30ML = recommend 15ML
 2 Kg = 30ML or 3 Kg = 45ML

ii) Standard mixing ratio (Machine > 10 years & fast color change)

- 1 Kg = 2% - 4% = 20ML ~ 40ML = recommend 25ML
 2 Kg = 50ML or 3 Kg = 75ML

iii) If your machine is heavy contaminated with black spot and for first time use:

- 1 Kg = 5% = 50ML
 3 Kg = 150ML

Then follow purging guideline from Step 1 to Step 6.

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

*** Place in next resin for the next job.

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°C to 350°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 sales@purgemax.com. We value your feedback and thank you for the support.

