

## **Purging Instructions for Cleaning an Extruder with KAUTEX PURGE**

1. Stop the production, run the machine until it is empty, remove existing screens and put in a blank breaker plate instead of them.  
Hand clean the vent and cap it (if there exists a vent zone).

2. Raise the temperature in the heating zones of the screw's front zone and in the mould.

**Important!** Do not raise the temperature higher than allowed by the safety margin of your plastic. If processing temperature-sensitive material in any case follow the instructions mentioned below in this manual.

3. Run some natural HDPE as a flush trough the machine and run the machine empty again.
4. Clean the hopper and the filling zone of old material. Feed KAUTEX PURGE directly into the throat at normal production RPM until you see it coming out of the nozzle.
5. When observing KAUTEX PURGE coming out of the nozzle reduce the screw speed to minimum RPM and slowly continue filling KAUTEX PURGE into the throat. Take care that the filling zone stays covered with KAUTEX PURGE. For avoiding bridging do not fill the throat completely.
6. After 20 to 25 minutes purge KAUTEX PURGE out of the extruder at normal production RPM.
7. If there still can be seen contamination or black specks raise the temperature up to 295 °C and repeat steps 4 to 6.
8. After finishing the cleaning process you should wait 10 minutes before continuing the production process for allowing remainders of KAUTEX PURGE to become low-viscous so that they can be removed by the material following them.
9. Clean the filling zone and the feeding zone in order to keep KAUTEX PURGE from contaminating the material to be processed in the next production cycle.
10. Reduce the temperature in the machine to working temperature and continue the production. If you want to finish the production process you now merely need to switch-off the machine. You should use KAUTEX PURGE as material which you can leave in the machine over the weekend.

### **Cleaning-off temperature-sensitive materials (PVC etc.)**

You should clean according to the instructions contained in this manual, but in any case keep the working temperature while cleaning, or at least do not raise the temperature above 180°C.

If there still can be seen black specks or greater contaminated parts after running the machine empty and cleaning it, then there is necessary a second cleaning cycle at higher temperatures, as described in steps 4 to 6.

### **Cleaning-off high-temperature-resistant materials (Ultem, PEEK)**

Proceed according to the instructions in this manual, but do not raise the purging temperature, and let the screw rotate at minimum RPM during the soaking time.

After finishing the cleaning process, adjust the temperature to the working temperature of the material to be processed next.

For lowering the temperature more quickly, you can use the material to be processed next for scouring, as soon as the temperature in the machine has reached the processing margin of this material (according to supplier).

### **Extrusion Blow Moulding**

For cleaning the accumulator increase the shot size at least 10 % and let the system run automatically. Proceed according to the instructions for cleaning an extruder.

### **Cleaning Temperature**

1. For a cleaning temperature up to 300° C.