

## How to get the best purge results with NPT

These instructions are intended as general guidelines. Purge according to your specific needs and situation.

### Through Purge

For color changes, preventive maintenance, and resin changes where no significant resin buildup is expected, use the "Through Purge" technique:

- 1) Run machine empty of all resin and stop machine.
- 2) Add NPT directly into the throat of the machine at rate of 1.5 times barrel capacity.
- 3) Run machine at normal temperatures, pressure and cycle speeds.
- 4) If barrel temperatures exceed 400°F, you may notice black streaking with the purged out material. This is normal and part of the reactive cleaning process. Discard all purged out material.
- 5) After NPT is no longer visible coming out of the machine, clean out remnant materials by using HDPE or your next desired resin.
- 6) Be certain that the barrel temperature falls within the safe operating limits of the next resin.

### Short Soak

If unwanted resin remains in the barrel or if there are known stubborn resin or carbon deposits present, proceed with a "Short Soak".

- 1) Run machine empty of all resin and stop machine.
- 2) Raise the nozzle and front zone temperature 50°F, not exceeding the safe operating temperature of the resin. Add NPT directly into the throat of the machine at rate of 1.5 times barrel capacity.
- 3) Run NPT through the system until the material appears at the nozzle. Stop the screw and allow the system to soak for 5-10 minutes.
- 4) Remove NPT from the barrel by flushing with HDPE or your next resin. Be certain that the barrel temperature falls within the safe operating limits of the next resin.
- 5) If traces of contamination remain, repeat steps 2 and 3.

### Special Molding Situations

- 1) At temperatures above 400°F the concentrated purge pellets may turn black and may cause streaking within the purged material. This is a normal part of the reactive cleaning process. The black is removed once the system is flushed with your next resin.
- 2) If running a hot manifold system, elevate the nozzle and front-end temperatures 50°F if allowable. Run NPT directly through the manifolds. Lower temperatures as NPT begins to completely exit the machine.
- 3) For an extrusion process, remove the screen pack prior to adding NPT.
- 4) For vented barrels, hand clean the vent and cap the vent if possible. If vent can not be capped, feed 1/4 of the NPT gradually through the vent hole for optimal performance.
- 5) The first use of NPT may result in the freeing of resin deposits that have accumulated over time. Continue purging until this discharge stops.