Dugdale

High performance PVC compounds & alloys

DUCAPURGE: THERMOPLASTC PURGE COMPOUND

DESCRIPTION:	A thermoplastic purging compound suitable for both injection moulding and extrusion
PRODUCT FORM:	Granules

PROCESS INFORMATION:

Note: DucaPurge does not work by chemical reaction. No soak time or hold-up time is required for an effective purge. DucaPurge is designed as a “PURGING” compound and should not be used as a “FREEZING” compound. For maximum performance, DucaPurge should not be diluted with other materials.

PURGING INSTRUCTIONS FOR INJECTION MOULDING

- Following completion of the production run, check that all temperature zones are set at 175°C
- Retract the injection unit. Run the barrel empty using maximum backpressure. Wipe the hopper and feed throat
- Feed the required amount of DucaPurge into the hopper. About one to two barrel capacities is required for purging a typical injection moulding machine. The actual amount required depends on the difficulty of the application and the condition of the equipment. Start with about one barrel capacity
- With the screw completely forward, increase the backpressure to the maximum level
- After DucaPurge begins to exit the nozzle, increase the screw speed to the maximum safe level
- Decrease the backpressure once the DucaPurge exiting the nozzle is almost clean
- Retract the screw and perform short, high-velocity injection shots
- Repeat the above if contaminants are still visible
- The machine is clean and purging is complete when DucaPurge is visibly free of contamination
- Displace the DucaPurge remaining in the machine with the next resin, again, at the maximum backpressure and maximum safe screw speed with the screw completely forward

Note: DucaPurge works best with maximum agitation. Use the maximum safe screw speed and maximum safe backpressure with the screw in the most forward position. Experience may allow this procedure to be varied slightly to suit the processing equipment concerned.

PURGING INSTRUCTIONS FOR EXTRUSION

- Following completion of the production run, check that all zones are in the correct temperature range for the grade of DucaPurge used
- Ensure that the hopper and barrel are empty. Wipe the hopper and feed throat
- Whilst the screws are turning, slowly feed the required amount of DucaPurge into the hopper. The actual amount depends on the difficulty of the application and the condition of the equipment. Start with the minimum amount
- Ensure that a safe extrusion torque and pressure are observed at all times during purging until DucaPurge is visibly free of contamination. If contamination does not clear, repeat the process
- Displace the DucaPurge remaining in the machine with the next material, again ensuring that a safe extrusion torque and pressure are maintained at all times

Note: Experience may allow this procedure to be varied slightly to suit the processing equipment concerned.

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