

Purging

Generally at the end of a molding run, the injection molding press should be purged of resin. Basically the process consists of replacing the RADEL R resin in the barrel with a lower melting polymer to make start up easier. A variety of techniques and materials can be used.

One effective procedure is a step-wise purge beginning with natural polysulfone and following it with a fractional melt flow rate high density polyethylene. First, run the machine dry of RADEL R resin. The next step is to feed polysulfone to the machine and purge until the extrudate is clear. The extruder barrel temperature may be lowered 30°F to 50°F (15°C to 25°C) as the polysulfone replaces the RADEL R resin. Continue lowering the temperature and begin feeding the polyethylene when the temperature reaches 625°F (329°C). Continue running until the purge is primarily polyethylene.

Another procedure is to run the injection molding machine dry of RADEL R resin, then lower the barrel temperature between 625°F to 650°F (329°C to 343°C). Then feed fractional melt flow rate polypropylene and purge until the purge is mostly polypropylene. Once the purge is mostly polypropylene, follow your normal machine shut-down procedure.

Commercially available purging compounds, such as Rapidpurge® and Asaclean®, can be beneficial in some cases. Polycarbonate and cast-acrylic resin have also been used as purging materials.

To learn more about our products and services, please visit our web site at www.solvayadvancedpolymers.com.

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Material Safety Data Sheets (MSDS) for our products are available upon request from your Solvay Advanced Polymers sales representative or by writing to the addresses shown above. Always consult the MSDS for the product you consider using.

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