



## Standard Operating Procedure for Blow Molding

Ultra Purge™ 5150

Ready-To-Use Purging Compound with Ultra-X™

### Cleaning for Shut-Down and Start-Up – Blow Molding Extruder with Accumulator:

#### SHUT DOWN

1. Add Ultra Purge™ and make shots until the product is ejected from the die.
2. Reduce the thickness of the parison and adjust accumulator shot size to the maximum allowed settings.
3. After 4-5 shots with thin parison, increase the parison thickness and empty the system completely. **DO NOT ADD RESIN AFTER ULTRA PURGE!**
4. Turn off the machine completely (do not leave heaters in "Maintenance/Idle" mode).

#### START-UP

1. Turn on the machine to production settings.
2. Load Ultra Purge™ until it is ejected from the die. Reduce the thickness of the parison and adjust accumulator shot size to the maximum allowed settings.
3. Let Ultra Purge™ soak in the barrel and accumulator for 5-10 minutes.
4. After 4-5 shots with thin parison, increase the parison thickness and make full shots with the production resin to flush away contamination.
5. Begin normal production, if contamination persists follow the standard cleaning procedure. It is normal to see contamination being flushed out on startup.

### Cleaning - Blow Molding - Extruder without Accumulator:

1. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
2. In case of difficult color changes and black specks removal increase the head temperatures of about 30°C/54°F. For easy color changes and thermo-sensitive material. **DO NOT** increase the temperatures.
3. We recommend removing the finest layer of the screen pack. Make sure that the pressure or torque force remains within the safety limits when running Ultra Purge™.
4. Add Ultra Purge™ (roughly 1.5 times the barrel capacity).
5. If present, open the purging valve located on top of the head to allow the resin to be flushed out during the purging process.

6. When Ultra Purge™ is ejected from the die let it soak in the barrel for 5-10 minutes. Add the next production resin directly after Ultra Purge™.
7. Increase and decrease alternatively the parison thickness (if possible) to flush away contamination.
8. If possible, replace the screen pack during this phase.
9. Set all the parameters to the next production settings. If contamination persists repeat steps

### **Cleaning for Shut-Down and Start-Up – Blow Molding - Extruder without Accumulator:**

#### **SHUT DOWN**

1. We recommend removing the finest layer of the screen pack. Make sure that the pressure or torque force remains within the safety limits when running Ultra Purge™.
2. When all production resin has been used up, load 50%-barrel volume capacity of Ultra Purge™.
3. If present open the purging valve located on top of the head to allow the resin to be flushed out during the purging process.
4. Extrude at slow screw rotation speed until the barrel is completely empty.
5. Turn off the machine completely (do not leave heaters in “Maintenance/Idle” mode).

#### **START-UP**

1. Turn on the machine to production settings.
2. Load Ultra Purge™, at slow screw rotation speed, until it is ejected from the die. Allow Ultra Purge™ to pass through the barrel in 5-10 min.
3. Add the next production resin directly after Ultra Purge™ and begin normal production.
4. If possible, replace the screen pack during this phase.
5. If contamination persists, follow the standard cleaning procedure. It is normal to see contamination being flushed out on startup.