



Standard Operating Procedure for Sheet Extrusion

Ultra Purge™ 5150

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

Cleaning - Sheet Extrusion:

1. Before starting the purging process, decrease the temperatures in the head middle area (-20°C/-36°F) and increase the temperatures on the sides (+20°C/+36°F).
2. Manually remove all contaminations from the feeding area.
3. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
4. 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™.
5. Add Ultra Purge™; the amount required for the purging process equals 1 full system capacity (barrel and head).
6. Reduce the screw rotation speed in order to allow Ultra Purge™ to pass through the barrel in 5-10 minutes.
7. Load the next production resin directly after Ultra Purge™.
8. When Ultra Purge™ starts to be ejected, increase the screw rotation to the maximum safe speed to flush out all contaminations.
9. Set all the parameters to the next production settings and begin normal production.
10. If possible, replace the screen pack during this phase.
11. If contamination persists repeat steps.

Cleaning for Shut-Down and Start-Up - Sheet Extrusion:

SHUT DOWN

1. We recommend keeping the barrel full of resin when adding Ultra Purge™ in the machine.
2. Manually remove all contaminations from the feeding area.
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™. The amount of Ultra Purge™ required for the purging process equals 50% of the system volume capacity (barrel and head).
5. Purge out until the barrel is completely empty. **DO NOT ADD RESIN AFTER ULTRA PURGE™!**
6. Turn off the machine completely (do not leave heaters in "Maintenance/Idle" mode).

START-UP

1. Turn on the machine to production settings.
2. Add Ultra Purge™. The amount of Ultra Purge™ required for the purging process equals 50% of the system volume capacity (barrel and head). Load the next production resin directly after Ultra Purge™.
3. Reduce the screw rotation speed. When Ultra Purge™ starts to be ejected, increase the screw rotation to the maximum safe speed to flush out all contaminations.
4. Set all the parameters to production settings and begin normal production.
5. If possible, replace the screen pack during this phase.
6. If contamination persists, follow the standard cleaning procedure. It is normal to see contamination being flushed out on startup.

