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BioXpresS[®]-Purge Processing Guide

BioXpresS[®]-Purge is a biodegradable compound designed for cleaning extruders between color or polymer changes. BioXpresS[®]-Purge contains materials that have greater affinity to hot metal than most polymers and pigments. This results in an efficient removal of old pigments and polymers.

Processing Temperature Profile	
Melt Temperature	165°C
Feed Throat	110°C
Compression Section	160°C
Metering Section	165°C
Die	165°C
Screw Speed	50 - 175 rpm

Note: These are starting points and may need to be optimized.

Purging recommendations for color and polymer changes:

Empty the hoppers of the previous materials and purge the extruder until the screw flights in the feed zone can be completely seen.

Lower the machine barrel temperatures to 110°C in the feed zone and 165°C at the die.

Add BioXpresS[®]-Purge and purge for three to five times the material residence time.

Change the barrel temperature setting to the normal processing temperatures for the polymer to be processed and then switch the hoppers and feeders to the next polymer.

Purge the remaining BioXpresS[®]-Purge from the barrel with the new polymer.

For color changes, when the purge of the BioXpresS[®]-Purge is complete, add the pigments for the new color.

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