

# PEKUTHERM®

## THE THERMO-ELASTIC PURGE

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### DIRECTIONS FOR PURGING SOFT PVC WITH PEKUTHERM® INJECTION PURGING COMPOUNDS

PEKUTHERM® N, SM, OR SK: 375°F to 572°F (190°C to 300°C)

PEKUTHERM® HLT, HLT Fine: 302°F to 752°F (150°C to 400°C)

1. Leave the barrel full of the out-going polymer. Remove just enough out-going material until the back of the machine screw can be seen.
2. Move the barrel back from the tool. (**DO NOT** run Pekutherm® through the tool or any other restrictions -manifold, dispersion disc, etc. Minimum nozzle opening - 3mm.)
3. Put a receptacle (carton or box) in front of the machine nozzle to catch the purged material.
4. Set the screw in the forward position and leave it there. Turn up the back pressure enough to keep the screw forward.
5. Purge at approximately 50% of the screw rotation speed.
6. **NEVER PURGE STRAIGHT WITH PEKUTHERM®.**  
**CHASE THE PVC WITH PP OR CRYSTAL STYRENE FIRST, THEN PEKUTHERM®.**
7. Leave the barrel ½ full of the out-going PVC. You must back up the Pekutherm® to start soft scrubbing.
8. Rotate the screw until the hopper throat is empty of out-going material.
9. Introduce a small amount of Pekutherm®, about 20-30% of the total barrel capacity.  
(Add in small amounts. **Too much at one time could block the barrel.**)
10. Move the Pekutherm® down the barrel and introduce some in-coming material at this time.  
(If more cleaning is needed, add another small amount of Pekutherm® at this time.)
11. Put in enough in-coming material to fill the barrel and run it through the machine.
12. At this point the change should be complete.

**NOTE:** Additional amounts of Pekutherm® should be run on extremely dirty or worn machines. Also, add 10-15% more Pekutherm® when purging a vented barrel machine or a worn machine.

#### ADDITIONAL NOTES:

Use proper formulation of Pekutherm® (N for 150 tons or larger, SM for 80-150 tons, SK for smaller than 80 tons).

**For further assistance, please contact us at UniTemp, Inc. or our sales representative.**