

PEKUTHERM® ULT, ULT FINE

EXTRUDER PURGING DIRECTIONS

175°F to 625°F (79°C to 330°C)

1. **Only purge with an open screw.** Dies & profiles should be separated out and away from the screw.
2. Filters and static mixers should be removed before purging.
3. Clean hopper, throat, etc. of all remaining material. Any ledges on the inside of the feed throat should be free from any type of debris.
4. Leave the barrel full of the out-going polymer.
5. Increase the temperature of the back heat zone by 10-15% (heat zone nearest the hopper throat).
6. Purge at 50% of extrusion speed in order to let the PekuTherm® soft-scrub the screw/barrel clean.
7. Introduce the PekuTherm® onto a continuously running screw.
8. Continue to run PekuTherm® until our thermoplastic compound is free of colorant/contaminant.
9. Introduce incoming polymer and run until clean. If a lot of color is still present, run some more PekuTherm® through the extruder. Follow with incoming material.
10. After purge is complete, clean out the venting zone.

ADDITIONAL NOTES:

Use proper Pekutherm® grade (Determined by screw diameter):

PekuTherm® ULT should be used for 1 ½" diameter or larger.

PekuTherm® ULT Fine (Special Fine Grade) should be used for 1" diameter or smaller.

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