

Instruction manual for purging an extruder

Operating instructions for cleaning extruders

1. Close all vent zones if existing.
2. Interrupt the material supply and run the barrel empty.
3. Produce the purging mixture and fill it into the hopper
4. Produce the purging mixture as follows:
5. Mix 3% of the purging concentrate to the cold raw material which is needed for the next production.
6. Start the screw rotation till the purging mixture is coming out the nozzle. To be recognized on the foamy material structure.
7. Stop the machine for approximately 15 minutes. In this time the purging mixture will foam up, reach and clean all metal surfaces and death zones.
8. Start screw rotation and evaluate the extruded material.
9. In case the result is not satisfied please repeat the process again.