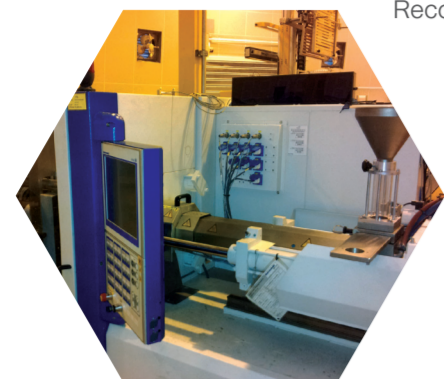




GUIDELINE OF X PURGE FOR INJECTION MACHINE



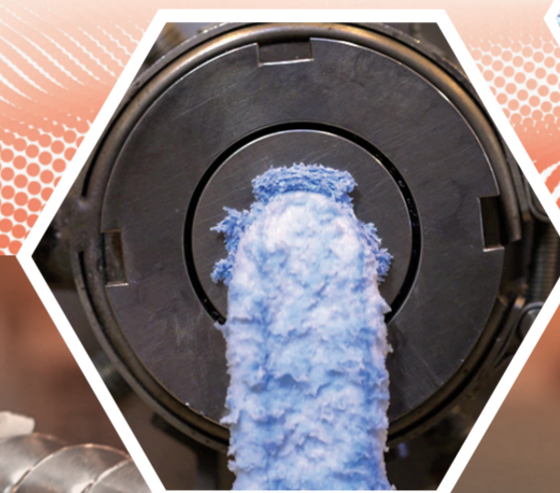
Recommended quantity of  according to the clamping force.

Clamping Force (Ton)	Recommended Quantity (kg)
100	1.5
200	3.0
550	6.0
750	15.0
1200	65.0

GUIDELINE OF X PURGE FOR BLOW MOLDING, BLOWN FILM AND EXTRUSION MACHINE

Recommended quantity of  according to screw diameter.

Screw Diameter (mm)	Recommended Quantity (kg)
65	11
90	17
100	20
130	30



Remark: Blending with resin at ratio 50:50 is recommend for the best cleaning. The actual amount required may depending on equipment and material.



Special Tips

To enhance a cleaning performance, and black spot removal. Soaking within machine 5-10 min is recommended.



Restriction on usage

Fume may occur at high processing temperature. It can cause temporary slight eye and nose irritation but it is unlikely to cause significant skin irritation.



Personal protection

Safety glass with side shield should be worn. Mask or respirator for organic vapor is recommended when the ventilation in working area is not sufficient.

Any inquiry about cleaning other plastic machines and shut-down/start-up machines, please contact our technical team for further information.



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PURGING COMPOUND

Data as of 1 July 2022



is high efficiency ready-to-use purging compound which provides fast and effective color, material change and contaminant removal in the machine without disassemble. X PURGE will reduce machine downtime and/or maximize productivity. This product is designed for cleaning various types of the machines i.e., injection molding machines, blow molding machine, blown film machine, sheet casting machine, sheet/profile extrusion machine.



FAST



SAFE AND EASY



EFFICIENCY

X PURGE GRADE

	Recommend temperatural and matterial				Type of Machine		Feature
	140-240 °C	200-240 °C	240-290 °C	290-340 °C	Injection	Extrusion	
GX168	PVC, TPE, PE				✓	✓	General Grade
EX20T	POM, PP, PS, ABS, PC/ABS, PA6, PBT, PA6+GF		PA66+GF, LCP		✓	✓	High Heat Stability
PX319 NEW	PE, POM, PP, PS, ABS, PC/ABS, PA6, PBT, PA66, PA6+GF				✓		Low smoke and Smell Superior Efficiency

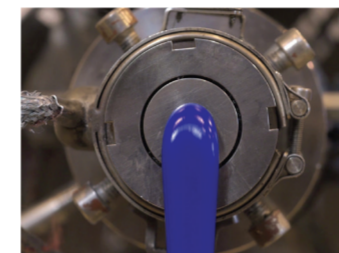
Comply with US, FDA, RoHS and REACH regulation



“FAST AND EFFECTIVE PURGING MATERIAL”

CLEANING OR CHANGEOVER PROCEDURES:

Step I. Preparing



- 1 • Clean hopper & Empty the barrel by running machine until the material is used up.



- 2 • Adjust screw speed by 30-50% of normal condition.
- Remove screen pack (if, machine is equipped).

Step II. Cleaning by X PURGE



- 3 • Pour X PURGE into the hopper.
- Purge continuously until machine is completely clean.

Step III. Flushing the X PURGE



- 4 • Run machine until X PURGE is used up.
- Flushing out the remaining X PURGE by using the next desired material.

Step IV. Starting next production



- 5 • Adjust processing condition to normal & Install screen pack (if, machine is equipped).
- Start next production.