

Technical Guide

SLIDE®

plastixs®
manufacturing solutions

Plastic
Specialty Die
Sheeting
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STOP AND READ

SAFETY: Safety is always most important. Follow your established company procedures and practices for purging machines. Purging should be performed with purge guards closed and proper face shield, gloves and long sleeve clothing. Hot plastic can cause burns! Use Caution!

SLIDE HI-TEMP Purge is a specially developed purging/cleaning compound that is delivered in a premixed and ready-to-use pellet form. It is specifically developed for the cleaning of screws, barrels, heads, and dies to remove burned material, color hang-ups, resin deposits and black specks during color and/or material changes specifically when working with resins requiring higher operating temperatures.

SLIDE HI-TEMP Purge processing temperature range is from 485° F to 752° F (250° C to 395° C). It removes, at the temperature of the previously processed resin material, any hang ups and deposits of resin inside the screw and barrel unit.

The **SLIDE HI-TEMP Purge** compound is **not abrasive** and works with a chemical reaction.

Since **SLIDE HI-TEMP Purge** is manufactured with non-abrasive chemical components, color and burned polymers, black specks and also rust are softened, removed and purged from the molding machine. There is “**NO MECHANICAL ACTION**” made on the molding machine or tooling.

SLIDE HI-TEMP Purge cleans at the processing temperature of the previous production material and no soak time is required. It is NOT recommended for hot runners.

SLIDE HI-TEMP PURGE is non-toxic and is odorless. It will not damage your equipment because it does not contain solvents: all components are qualified as GRAS (Generally Recognized as Safe) by FDA.

It may happen that when running **SLIDE HI-TEMP PURGE** in older machines, where the equipment is overused, the cleaning process may not remove all of the old deposits of material that ran months ago. In this case, a second application may be required to fully purge the machine.

It is highly recommended to close the container properly after each use. The forming of small balls of sticky substance may occur. *This will not alter the efficiency of the product.*

The recommended storage time for **SLIDE HI-TEMP PURGE** is 12-18 months.

Use with Injection Molding Machines:

- If your resin material is supplied from a conveyor system and silos, take off the supply tube as well as any masterbatch/color supply lines. Make sure that there are no traces of the color concentrate inside the machine. Use compressed air to clean if needed!
- Increase the barrel temperature by 50°F to 85°F (10°C-30°C) (if possible); this operation is not strictly necessary but may give a better cleaning result. With resin material processed at 626°F (330°C) or higher **do not** increase temperature.
- **The temperature curve inside the barrel must be increasing: the temperature on the rear zone must be the lowest and the nozzle zone temperature must be set the highest!**
- Load the screw and barrel with a neutral color/grade of plastic resin (possibly production material) and run the machine until the material comes out with a lighter color (i.e. from red to pink or from dark blue to light blue)
- Set hydraulic backpressure between 70 and 140 PSI (if material is not feeding correctly, reduce it further until the purging compound can be loaded). If it is still difficult to move the purging compound, increase the screw speed.
- Load Slide Hi-Temp Purge into the machine (one to two times the net weight resin capacity of the barrel) and begin to purge out of the nozzle.

ATTENTION: DO NOT COMPLETELY EMPTY THE BARREL FOR LONGER THAN 2 MINUTES. Immediately load the production resin material following the use of the Slide Hi-Temp Purge.

No soak time required

- Due to the fact that the Slide Hi-Temp Purge is quite fluid at the higher run temperatures, we do NOT recommend that the Slide Hi-Temp Purge be used to clean the hot runner components. If you need to clean a hot runner at these high temperature levels, please reach out for additional support from a Slide purge expert.
- Purge with neutral resin to eliminate all traces of the purging compound.
- Begin normal production.

ATTENTION: All indicated instructions are general instructions and may vary from one type of machine and its condition to the other. In case of questions, needed information and/or doubt, do not hesitate to contact a Slide purge expert for technical support. You can call us at 800-323-6433 or email info@slideproducts.com.