



Purging Recommendations for Geon[®] Vinyl Rigid Molding Compounds

Purging Recommendations - Shutdown/Prolonged Interruption

- Rigid vinyl compounds are heat sensitive materials.
- Vinyl compounds must be purged from the barrel after molding is complete or during a prolonged interruption in the molding cycle.
- Purge at least every 15 minutes during prolonged interruptions.
- General purpose natural ABS or natural polystyrene are ideal purge materials.
- Commercial purging compounds such as Dynapurge[®] can also be used. CylaPurge[®] should only be used between color changes and not for production shut-down because it contains a blowing agent mixed with a vinyl polymer. You do not want to shut-down a press with vinyl in the barrel.

Purging Recommendations - Power Loss or Process Upset

- Shut off heaters to the barrel and nozzle.
- Cool the barrel with fans if emergency power is available.
- When power is restored, restart the injection molding press.
- Set barrel and nozzle temperature 250°F for one hour.
- Increase barrel and nozzle temperature 25°F every 30 minutes until reaching 350°F.
- Start purging with natural ABS, natural polystyrene, or commercial purge when barrel has reached 350°F.

Dynapurge[®] is a registered trademark of Shuman Plastics, Inc.
CylaPurge[®] is a registered trademark of Cylatec, Inc.

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