




The following steps are recommended when cleaning an injection molder with OPTIX Purge. These are general guidelines and may require adjustments for your process.

Step	Instructions	Special Instructions
1.	<b>Drain</b> the production resin.	
2.	<b>Remove</b> small nozzle orifices, if applicable.	
3.	<b>Start</b> the molder temperature at 400°F (280°C) to 450°F (232°C). Maximum temperature is 500°F (260°C).	 If the purge compound bridges or freezes, it may be necessary to mix a higher melt resin to increase the flow.
4.	<b>Fill</b> the barrel with OPTIX Purge.	 Use lesser amounts at first. It is recommended that the hopper is not completely filled with OPTIX Purge.
5.	<b>Purge</b> by rotating the screw.	 Apply minimal back pressure.
6.	<b>Continue</b> the screw rotation and completely fill the length of the barrel.	
7.	<b>Repeat</b> the cycle multiple times until there are no black specks or char present in the extrudate.	
8.	<b>Flush</b> the system with a high flow resin or a resin, like what will be used in production.	



Recheck your residual times in the barrel to ensure good parts can be made in production.



Remember to dry the resin. Hydrolysis can cause breaking or cracking of parts during shipping & handling.



For hot-runner systems proceed with CAUTION. Use small amounts to ensure the molder does not plug. DO NOT push OPTIX Purge through the sprues.

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee, as conditions and methods of use are beyond our control. We recommend that the prospective user determines the suitability of our materials and suggestions before adopting them on a commercial scale.

© 2023 PLASKOLITE, LLC 032023  
OPTIX® is a registered trademark of PLASKOLITE LLC

## PLASKOLITE

400 Nationwide Blvd, Suite 400  
Columbus, OH 43215  
800.848.9124 • Fax: 877.538.0754  
plaskolite@plaskolite.com  
www.plaskolite.com

TIM002\_OP\_PURGE\_Injection