
EASYPURGE

General usage procedure (CT101 / CT301 / CT401 Clear)

1) Prepare the purging blend (first)

- Prepare a 30-50% purging blend (CT concentrate + next virgin material or regrind).
- Prepare enough blend for at least 2 machine doses (in case one dose is not enough).
- Normal color changes: 30-40%.
- Material changes or severe cleaning: 40-50%.
- **Do not use undiluted products.**

2) Prepare the machine

- Empty the previous material.
- Remove fine filters or meshes if present.
- Keep hopper dry and clean.
- Adjust temperatures within the working range of the compound (170-300 C, depending on the polymer).

3) Purge

- 1 At the barrel temperature of the resin currently inside the barrel, load the purging blend.
- 2 Free purge through nozzle or open mold until the outlet is clean or translucent.
- 3 Alternate high/low screw rpm with medium-high back pressure.
- 4 Introduce the target resin and make 2-3 sweeping shots.
- 5 Repeat if there are still residues or shadows.

Dosage tables

Extrusion dosage

Diameter	Amount of purging blend
40 mm	1,0 kg
50 mm	1,5 kg
60 mm	3,0 kg
70 mm	5,0 kg
80 mm	7,0 kg
90 mm	10,0 kg
100 mm	12,0 kg
120 mm	20,0 kg

Injection dosage

Machine size	Amount of purging blend
50 T	0.3 kg
100 T	0.5 kg
200 T	1.0 kg
400 T	2.0 kg
800 T	4.0 kg
1000 T	5.0 kg
2000 T	10.0 kg

Compatibility (guide)

CT101: compatible with LDPE, LLDPE, HDPE, PP homopolymer, PP copolymer, EVA, EMA, EBA, TPO, SEBS (TPE-S), SBS, PS, HIPS, SAN, ABS, PMMA, PETG, TPU (short use), PA6 (short use), PBT (short use <= 255 C), EVOH (residual layers).

CT301: compatible with PP, PE, ABS, SAN, PS, PC-ABS, PA6, PA66, PET, PMMA, PC, EVOH.

CT401 Clear: designed for transparent materials; compatible with PC, PMMA, PC-ABS, ABS, SAN, PS, PA6, PA66, PA12, PETG, PBT, PET (quick spindle/nozzle cleaning only).

Precautions

- Do not leave purge in the screw during stops.
- Avoid use on PVC, POM or fluoropolymers.
- Wear gloves, goggles, and a dust mask.
- Store dry, between 5 and 35 C, in a sealed container.