



# KANDUI INDUSTRIES PVT. LTD.

## Product Specification

AddKan Masterbatch

**PURGING MASTERBATCH**

**PG/01/0002**

This compound is designed to minimize down time and increase productivity and reduce generation of scrap and wastage of virgin material. This compound also expunge a colour, resin or formulation before change over or shutdown. This purging compound is suitable to run in both cases - online and off line of machine. It does not cause wear on machines. It is safe for operators and safe for disposal.

Typical Properties	Typical Values	Units
Bulk Density	0.7-0.95	Gms/ml
Moisture Content	<0.1	%
Melt Flow Index	110+/-10	Gm/10min
Pellets/Gram	35+/-5	Nos
Carrier Resin	LLDPE/HD	
Heat Stability	Thermally stable under normal processing conditions	
<b>Applications for grade :</b>		
Injection Moulding /Blow Moulding and all Extrusion Applications		

### Purging Instructions for Injection Molding :-

1. Check that all zones are in the proper Temperature range for the grade of being used.
2. Retract the injection unit. Run the barrel empty using maximum back pressure. Wipe the hopper and feed throat.
3. Feed the required amount of Purging compound into the hopper. About one to Two barrel capacities of Purging compound is required for purging a typical injection molding machine. The actual amount required depends on the difficulty of the application and the condition of the equipment. Start with about one barrel capacity.
4. With the screw completely forward, increase the back pressure to the maximum level.

**OFFICE:** Plot No.112, Minerva Industrial Estate, P.K.Road, Nr Hercules Hoist, Mulund (W)

Mumbai-400080, INDIA Tel: 022-61510500 Fax: 022-25916269

E-mail : [masterbatchinfo@kandui.in](mailto:masterbatchinfo@kandui.in) URL: [www.additivemasterbatches.com](http://www.additivemasterbatches.com)

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5. After purging compound begins coming from the nozzle, increase the screw speed to the maximum safe level.
6. Drop the back pressure after the purging compound coming from the nozzle is almost clean.
7. Retract the screw and perform short, high-velocity injection shots.
8. Repeat steps 1 through 7 if contaminants are still visible.
9. The machine is clean and purging is complete when purging compound coming from the machine is visibly free of contamination.
10. Displace the purging compound remaining in the Machine with the next resin, again, at the maximum back pressure and maximum safe screw speed with the screw completely forward.

## **Purging Instructions for Blow Molding :-**

Follow instructions for extrusion or injection depending on the type of blow molding performed:

1. For machinery with accumulators, introduce additional purging compound (add enough additional purging compound to fill each or all the accumulators).
2. More purging compound will be required if any additional auxiliary equipment is present or if the machine has heavy deposits.
3. If a piston is present in the accumulator, an up and down "jogging" motion of the piston may help loosen stubborn deposits.
4. If the accumulator is heated, raising temperatures up to 50°F in the accumulator may also help loosen deposits.

## **Cleaning of Screw for Extrusion :-**

1. Check that all zones are in the proper temperature range for the grade of purging compound being used. Purging compound is effective within the entire service temperature range. It is not necessary to adjust the extruder temperatures if the temperatures are within the service range.
2. Run the barrel empty. Wipe the hopper and feed throat.
3. For unfilled grades of PG/01/0002, screens and dies may be left in place for purging. If the machine is heavily contaminated and remove the screen pack to prevent plugging. Remove the die as well if necessary.

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4. Feed the required amount of purging compound into the hopper. About one to two barrel capacities of purging compound is required for purging a typical extruder. The actual amount required depends on the difficulty of the application and the condition of the equipment. Start with about one barrel capacity.

**NOTE:** For twin-screw extruders, feed purging compound into the barrel at a rate which allows for filling the flights of the screws as best as possible.

5. Start purging at low screw speed; after material begins coming out from the head, increase the screw speed to the maximum safe level. Periodically stop the screw and allow the purging compound to sit for about a minute (a few minutes if possible). Resume screw rotation at maximum screw speed.
6. Continue until most of the purging compound is purged from the barrel.
7. Visually inspect the purge pile. The machine is clean and purging is complete when purging compound coming from the machine is visually free of contamination.
8. Repeat steps 4 through 7 if contaminants are still visible.
9. Displace the purging compound remaining in the machine with the next resin, again at the maximum safe screw speed.

Purging compound does not work by chemical reaction. No soak time is required for an effective purge.

For maximum performance, purging compound should not be diluted with other materials.

Purging compound is most effective when pressure within the barrel is maximized.

All the above values are obtained under standard conditions with our testing facilities, may vary under different conditions and depending upon the accuracy and efficiency of the man and the machine. So it's recommended to test the above properties to finalize the use of the product for specific and particular applications. The information regarding the minerals is based on the test results and reports provided by the supplier

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