

HOW TO USE BAKELITE® DFD 0964 NATURAL "7" PURGING COMPOUND

The use of Bakelite® DFD 0964 Natural 7 Purging Compound in Uniloy blowmolding machines has been found to be a very effective method for cleaning contamination from the equipment, as well as making it easier to remove the screw from the barrel. The following procedure has been found to obtain the best results.

1. Natural 7 is a very stiff material. Due to this stiffness, high pressure will be generated when it is in the machine. Consequently, at no time should the charge button be depressed during this procedure. Any accumulated shot, upon release, could cause damage to the heads.
2. Turn off the resin supply, empty the hopper and run the screw dry. Do not overrun with a dry screw.
3. Open dies about 2 turns to prevent damage to heads due to excess pressures.
4. Put 25 pounds* of Natural 7 in the hopper and run the extruder until the purge compound comes out of the dies. (*This amount is for a 3 1/2" screw. For 2 1/2" use 15 lbs, for 4 1/2" use 50 lbs.)
5. Shut the machine down and let it sit cold for at least 8 hours.
6. Turn the heats back on. Reset the temperature controls to 250° to 260°F.
7. Run the motor at low speed, do not exceed 90-95% maximum.
8. Purge until empty.
9. Turn the heats back up to operating temperatures.
10. Fill the hopper with virgin resin, run until the purge is gone.
11. Turn on regrind, reset the dies and put the machine back in operation.
12. We would recommend this procedure approximately every 30 days.