TROUBLE SHOOTING TIPS

PROBLEMS	ROOT CAUSE	PROBLEM SOLVING
After purging with PurgeMax, there is further contaminants noticable in the melted plastic or in the next production lot	Excessive stubborn contamination which caused by carbon or highly loaded color pigment	Repeat purging according to the PurgeMax cleaning procedure guidelines. The best purging material to use is HDPE or PP with PURGEMAX. However, any crushed or prime material would also fine.
	Damaged screw (E.g. Grooves, Pockets, Porous sections)	Dismantle screw for one time cleaning and then regularly use PURGEMAX for each time cleaning.
	Damages on inner wall of cylinder (E.g. Grooves, Cracks, Indentations)	Rework the cylinder of new screw replacement
	Sudden significant peak in temperature from 1800C to 3100C	Changes of raw material with different processing temperature required a purging mix with an intermediate raw material such as HDPE or PP to ensure the optimum purging result
	Unfavorable flow characteristics in head, nozzle, and tooling area which were due to construction or through wear.	Repair or exchange parts that are producing unfavorable flow characteristics with better constructed parts
Hot runner system cannot be cleaned	Unfavorable flow characteristics in hot runner system (E.g. Pocket, hole, undercuts, misalignments)	Change construction of hot runner system or raise the temperature of hot runner system (depends on tooling)
Face charging issue after toss the packet with purging material	Too small screw diameter	Reduce the PurgeMax proportion in the purging mix, speed up screw revolution a little.
	PurgeMax over dosage	Keep the exact proportion of PurgeMax (refer to dosage chart). To prevent over dosage, pour half packet of PurgeMax into hopper throat initially by feeding a little purging material. If there is no charging problem, pour the rest PurgeMax and feed the purging material.