Purgemax Purge Resin Selection Guidelines

Purge and shutdown compounds are generally used to reduce changeover time and start up yield loss for injection molding and extrusion lines. These products combined with Purgemax help speed the turnaround, reduce start-up scrap, increase productivity and free up capacity when there is a color or material change on your lines.

Product	Purge Recommendations
ABS	Cast Acrylic, HDPE, PS, SAN
ABS/PVC Alloys	Cast Acrylic, PS, HDPE
Acetal Copolymer	HDPE, PP, PS (Do not contact with PVC)
Acrylic	Clean Acrylic Regrind
ASA Blends	Cast Acrylic, HDPE, PP
Flame Retardant Compounds	Immediate purging with natural non-FR resin
Fluoropolymers	Cast Acrylic followed by HDPE
Filled Reinforced Resins	Cast Acrylic
Isoplast	GPPS, HIPS, SAN, ABS
LCP	PP
Nylon PBT	HDPE, PP
PBT	PS, HDPE, Next material to be run
PC / PBT Alloys	HDPE, PS, Cast Acrylic
PC / ABS	Natural ABS, SAN, PS, Cast Acrylic
PEI	HDPE, Glass reinforced PC
PET / PETG / PCTG	Cast Acrylic, ASA, HDPE
Polycarbonate	Cast Acrylic, ASA, HDPE, PS
Polylefins	HDPE
Polystyrene (PS)	Cast Acrylic, PS, AS, ABS
Polysulfone	Reground Polycarbonate, extrusion grade PP
Polysulfone / ABS	Reground Polycarbonate, extrusion grade PP
PPO / PPE	Cast Acrylic, PS
PPS	Acrylic, LDPE, HDPE
PPS	HDPE
PVC - Flexible	HDPE
PVC - Rigid	General Purpose, non-FR ABS, Acrylic, PS
Polyester Alloys	HDPE
TPE	HDPE, PP
TPU / PU	HDPE, PP, non-FR ABS
PP	HDPE

Notes

1) Run barrel dry and leave the screw forward if resuming with the same material after shutdown.

2) CAUTION! Do not combine acetal and PVC in the barrel for any reason!

3) Remove nozzle when purging with cast acrylic.