

It's About Time!

Bamberko[®]



Purging Compound

- The industry leader for *over 50 years*.
- Its fast action cuts your *downtime by 75%* – and with a minimum amount of compound.
- It's used in *time zones across the world*.
- Ready for *immediate shipment*.

CLAUDE BAMBERGER MOLDING COMPOUNDS CORP.

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GOOD RIDDANCE!

*That's what our customers want —
to prevent blockage and to keep waste,
black specks, color remnants and gels,
as far away from their machinery
as they possibly can.*

Bamberko Purge 9016 is formulated to flow through injection cylinders and extrusion barrels without scratching. They are recommended for use in swift color and resin changeover and to clean machines of carbonized residue.

Bamberko Purge 9016 will not melt completely and is excellent for difficult purging jobs and suited for all thermoplastic molding materials. It will clean equipment quickly and efficiently without the need to change temperature settings.

Bamberko Purge 9016 is formulated to purge engineering materials, but will also work on *all types of thermoplastic materials*. This basic compound, produced by us since 1953, has been universally proven to be the most effective, economical and widely used purging compound sold on a world-wide basis.

RECOMMENDED USAGE	Cellulosics Polyolefins Styrenics & PVC Resins	ABS, Nylon, Polycarbonate PET and other high tempera- ture Engineering Plastics
TEMPERATURE	350°-450° F (176°-230° Cels.)	400°-550° F (204°-287° Cels.)

AND FOR OUR FRIENDS OUT THERE ON THE WORK FLOOR . . .

SUGGESTIONS FOR PURGING EXTRUDERS

1. Remove die, adapters, clamp rings, breaker plate and screen pack. OPENING MUST BE FREE OF RESTRICTIONS.
2. Clean out all polymer from hopper.
3. Keep barrel temperature at normal for purging polymer. Raise the extruder temperatures to 450° F. Use 450-550° F when purging ABS, nylon, polycarbonate, PET or other high temperature resins.
4. Feed **BAMBERKO PURGING COMPOUND** into barrel, a small quantity at a time. Run screw slowly. Do not use stuffer but allow compound to enter equipment by gravity feed. If it doesn't feed smoothly, raise temperature in increments of 10° F until it does. Total purging compound should not exceed two pounds per inch of screw diameter.
5. When purging compound begins to drool out, increase speed of screw to maximum.
6. Minimize possible smoke and odor by purging in water.
7. Continue adding purging compound until all polymer has been pushed out of the equipment.
8. Clean out all purging compound from hopper. Run screw dry. Slow screw down.
9. Clean end of screw and end of barrel.
10. Remove screw from barrel. Screw can now be cleaned completely by wiping with conventional means without scrubbing.
11. Make sure all material is out of the equipment before actual shut down.
12. Reassemble extruder.

SUGGESTIONS FOR PURGING INJECTION MACHINES

1. Remove nozzle. Nozzle opening should be at least 3/16" or remove nozzle.
2. Clean out all polymer from hopper.
3. Keep cylinder temperature at normal setting for the polymer being purged. Nozzle temperature should be left somewhat higher to avoid resistance flow.
4. Reduce injection pressure to a minimum and increase as required.
5. Feed small amount of **BAMBERKO PURGING COMPOUND** into cylinder, allowing material to go through equipment by gravity feed. If it doesn't feed smoothly, raise temperature in increments of 10° F until it does. Normally, no more than one cylinder full of purge material is sufficient to purge out old material and complete the cleaning process.
6. Minimize possible smoke odor by purging into water.
7. Continue adding purging compound until all polymer has been pushed out of the equipment.
8. Clean out all purging compound from hopper.
9. Now feed the next polymer. Set the temperature at normal for this molding powder.
10. Cycle slowly for first shot of this polymer. Then cycle rapidly to eliminate purging compound completely from cylinder.
11. Make sure all material is out of the equipment before actual shut down.

Make sure workplace is well ventilated. Odors and fumes are not toxic or harmful even if unpleasant to some.

BUT DON'T TAKE OUR WORD FOR IT . . .

"We have been using Bamberko Purge for over 20 years. We wouldn't know what to do without it!" — prime resin producer, USA

"It used to take hours to make color matches. Today, with Bamberko Purge, I can do 70 color matches a day!" — lab technician, Sweden

"It's an indispensable super-scrub!" — coating resins extruder, USA

"We were down for three days when I saw your website and ordered a bag. Within an hour, we were back in production!" — injection molder, Mauritius

"No matter how hard we tried, we lost many hours of machine time during color changeover. Now with Bamberko Purge, it takes only minutes." — sheet extruder, Bombay, India



For
the royal flush
you need
on the job . . .



... go to people who will give you
the best deal.



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