



SUGGESTED PURGING GUIDELINES- FOR Shutdown and Start-Up

Product:	iD QuickShots™
Description:	Super Concentrate
Process:	Blow Molding/Extrusion/Injection Molding
SHUTDOWN:	QuickShots™ - PURGING GUIDELINES

- ✓ Typically there is NO Need to Modify the Back Pressure or Temperature Settings on the Process Equipment;
- ✓ Empty the Barrel and Clean the Feed Throat;
- ✓ Once the Machine is Empty- Place a Small Amount of Resin in the Feed Throat (depending on the size of the machine- just enough resin to cover the top of the screw);
- ✓ Insert the Entire **iD Quick Shots™** Package directly into the Feed Throat (Again, depending on the size of the machine- divide the suggested dose by four and complete this process until the entire barrel is charged- See DOSING Instructions Below);
- ✓ Once the Barrel is Completely Charged with Resin/Purge- Shut the Process Equipment down using normal shut down procedures.

START-UP:

- ✓ Turn Machine power On and raise the operating temperature to 350-375°F;
- ✓ Follow any additional Start-up procedures necessary for the process;
- ✓ Once the operating temperature has been reached, slowly rotate the screw- do not rotate screw at full speed;
- ✓ If the purge coming out of the machine has any contamination, introduce more of the iD Purge mixture and flush the system until thoroughly clean;
- ✓ Using the resin required for the next production run, flush out remaining purge;
- ✓ Make necessary adjustments to the machine and begin production.