

# ASACLEAN™ NCH GRADE EXTRUSION PURGING INSTRUCTIONS

**For Resins 175°C – 360°C (345°F – 680°F)**

1. Empty the system of the production resin, and make sure the feed areas are clean. Do not remove the die.
2. If the changeover or cleaning is known to be difficult, flush the machine by running 1-4 system volumes of clean, natural extrusion grade HDPE.
3. Add ASACLEAN NCH at normal screw speed until the purge begins to extrude uniformly from the die.
4. With the screw turning at minimum controllable rpm, allow for a 5-minute heat soak. ASACLEAN NCH is heat activated, so expansion will occur during the heat soak (if sealing, turn off all heaters with the system full of ASACLEAN NCH).
5. Purge the machine of the ASACLEAN NCH.
6. If contamination is observed as the last of the ASACLEAN NCH leaves the system, repeat steps 3-5.

**If increased effectiveness is required, increase temperatures downstream of the extruder and/or increase soak time up to 30 minutes. Do not exceed 360°C (680°F).**

7. If heats have been raised, set temperature profile to the next resin process conditions and, when safe, displace the ASACLEAN NCH with the next resin.
8. Begin production under normal processing conditions.

## Technical Questions?

**To request detailed technical bulletins or technical support, contact us at Asahi Kasei Asaclean Americas Inc.**

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