

*** Please use temperature profile appropriate for each resin as per recommendation from data sheet or your resin supplier technical advisor.

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Changeover procedures from "PE" to "resin":

- 1) With "PE" still in the machine, **reduce the temp profile to "resin" conditions if the "resin" runs at a lower temperature profile. (Raise the temperature profile for resins such as PA (nylon), PET, or EVOH.)**
- 2) When the machine is fully normalized to the new resin material temperature profile, then empty all of the PE from the hopper and replace it with the "resin".
- 3) Run RPM to about 50% of max RPM until the new resin starts to appear coming out of the die, displacing PE. Then, start Disco Purge.
- 4) Use the Disco Purging procedure to purge out PE for **2 "cycles" of 10 minutes each.**
Inspect the web. If it is clear and free from gel and other impurities then start to run the production.
- 6) **If the web is not clear, repeat another 10 minute cycle of Disco Purging.**

Changeover procedures from "resin" to "PE":

- A) Empty all the "resin" from the hopper and replace it with "PE" resin. ***** Keep temperature profile at "resin" conditions.**
- B) Run about 50% of max RPM until you see the PE start to come out of the die.
- C) Carry out Disco Purging, **for at least 2 cycles** of 10 minutes each. **Often three cycles are needed for purging out of specialty resins back to PE or PP.**
- D) Inspect the web. If impurities still exist in the layer being transitioned, repeat another 10 minute Disco Purge cycle. Inspect again, and repeat as necessary.
- E) Once the web looks good, and all "resin" is out, then raise temperature profile to "PE" conditions. (Or lower temperatures to PE conditions if you have been processing a hotter running polymer such as PA, PET, and EVOH.)
NOTE: The web may start to look good after one disco cycle, but there will still be a thin layer of copolymer on the metal surfaces. You need to go through the disco cycle at least twice at the lower temperatures to help clean the thin layer of copolymer off of the inner metal surfaces.

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Precautions :

Keep feed zone temperature low to avoid bridging.

Use 35C to 60C cooling water in the hopper feed section jacketing around the barrel. Avoid chilled water, as this could lead to condensation forming in the hopper feed throat area.

Also use 35C to 60C cooling water in the "screw root cooling" lance if the extruder is so equipped.

NEVER shutdown the extruder with a specialty "polymer" in the machine. Always change over to PE using the Disco Purge Procedure, and shutdown the extruder with only PE in the machine. (PP can also be used for shutdown when appropriate.)

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