

## AURUM<sup>®</sup> Purging Method

### Ending Operations

1. At the time of ending the molding operation, continue to injection-mold or extrude AURUM<sup>®</sup> until AURUM<sup>®</sup> in the cylinder is not discharged any longer.
2. Clean the inside of the cylinder with polyether imide (Natural Grade #1000).
3. When the contents of the cylinder has been replaced with polyether imide completely, set the temperature to 350°C.
4. Clean the inside of the cylinder again with polyether imide when the set temperature has reached 350°C, and then clean the inside with commercially-available general purging resin or the like. After that, disassemble and clean the cylinder and the screw.
5. If the equipment is used again for molding AURUM<sup>®</sup>, clean the inside of the cylinder with polyether imide by carrying out the step described in 4. above, set the temperature to the AURUM<sup>®</sup> molding temperature, and turn off the power supply.

### Starting Operations

1. Be sure to disassemble and clean the cylinder and the screw before using the molding equipment if the molding equipment has been used with another resin.
  2. If the molding operation has been stopped by carrying out the ending step described in 5. above, raise the temperature to 350°C, clean the inside with polyether imide and set the temperature to the AURUM<sup>®</sup> molding temperature.
- \* With polyether imide as well as AURUM<sup>®</sup>, make sure that the residence time at the AURUM<sup>®</sup> molding temperature is within 30 min.
- \* The purging resin polyether imide needs to be dried beforehand at 150°C for 5 hrs.

The information contained herein is based on the information and data available at this moment, but none of the data or evaluation results contained herein provide any warranty whatsoever.