



Product Use Guidelines

INGENIA POLYMERS 1850 SHUTDOWN PURGE COMPOUND

- Ingenia 1850 Purge is a pellet formulation containing purge agents.
- Ingenia 1850 shutdown purge is used to reduce the oxidation of Polyethylene left in the processing equipment during shutdown and start ups.
- 1850 is designed to protect the equipment during shutdowns and start ups
- 1850 will minimize problems such as cross linking, gel formation and carbonization.
- Designed for use in LDPE, LLDPE and HDPE applications
- 1850 can be used in variety of applications such as Blown and Cast Film, Injection molding and Blow molding.
- Ingenia 1850 shut down purge is typically used after purging your process equipment with Ingenia 1851.
- It is recommended that Ingenia 1850 be used at 100% for optimum results.

Procedure

Shutdown

1. Lower your heats to 120C/250 F on barrel and rest of zones.
2. Put enough 1850 purge in hopper to fill barrel and rest of machine and continue to run until the purge material comes out of the die.
3. Lower the extruder speed to about 20 rpms and continue to run until the amps and pressure rise close to the limits allowed to make sure that you had temperature low enough to not burn the material that is in the machine.
4. Shutdown all the heats on the line making sure that you have enough purge in the hopper to cover the screw.

Startup

1. Turn heats on entire line to normal operation temp.
2. Set up hopper to run IP1851 purge for 10 min or so to help push out 1850 faster
3. Fill rest of your hopper with the material you will be running.
4. Start extruder at a low idle and make sure to watch the amperage and pressure and if either reach the set limits for your line stop the extruder. Wait 10 or 15 min and try again. (If you can get the polymer moving before it has a chance to cook you can avoid some of the crosslinking that occurs on startup).
5. Then slowly raise the rpms and when possible you can start your bubble (Film Extrusion) even with the purge material.
6. Start production when you get the clear material running from line.

TYPICAL VALUES:

Specific Gravity:	1.4
Pellet Size:	30 Pellets/g
Carrier Resin Type:	LLDPE
Carrier Resin Melt Index:	2g/ 10-min. (I2)
Moisture Content:	0.05%

FORM: Pellets

PACKAGE TYPE: Gaylord Boxes

Disclaimer

The information and statements herein are believed to be reliable but are not to be construed as a warranty or representation for which we assume legal responsibility. Users should undertake sufficient verification and testing to determine the suitability for their own particular purpose of any information or products referred to herein. No warranty of fitness for a particular purpose is made.

July 26, 2005