

James Walker	Iddon Extruder Clean Down Procedure	Date: Feb 17, 2020 Reaffirmed 2023	Rev: 3	Page: Page 1 of 1	Document No: OPI 69A  Approved by: Extrusion Manager
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**REASON FOR UPDATE:** Document Review

**ASSOCIATED DOCUMENTS:** n/a

# **1. PURPOSE**

**1.1** To provide a procedure for the clean down of an Iddon Extruder.

# **2. SCOPE**

**2.1** This document applies to all those involved with the clean down of an Iddon Extruder.

# **3. RESPONSIBILITY**

**3.1** The Extrusion Manager is responsible for updating and communicating the details within this procedure.

# **4. PROCEDURE**

1. Check that previous user has adhered to cleaning procedure and that machine is clean and ready for use.
2. Under no circumstances should pharmaceutical grade compounds (eg: Elastopure EP 75 Black) have any contact with other polymers during manufacturing process
3. Make sure machine has extruded all remnants of last run and screw is stationary.
4. On the first production run following any clean down, approximately 200mm of compound must be dispatched into waste bin to purge any remnants of previous run.
5. After compound has been extruded from production run, clean die head area and all visible parts: die, cone, strainer, front of screw and visible part of barrel with scotch-brite pads and brass bar if strainer has compound in it.
6. Next disassemble screw feed area and clean with Scotch-brite pads removing all traces of previous run within screw feed area. For any stubborn residues, Amberklene can be used in conjunction with Scotch-brite pads (Use appropriate PPE whilst working with solvents!). Take particular care to ensure rubber roller area between roller and roller scraper is clean.
7. For compounds that are prone to sticking to tooling, masticated raw rubber may be used to enhance the cleaning of the non visible part of the extruder barrel and screw flute areas. Repeat steps 2 and 4 after this process.
8. The vacuum box must be cleaned every 2 months, to prevent blockages inhibiting the vacuum capability of the machine. The front plate has either screw or allen bolt fixings. Remove these and lift off the plate. Then remove all compound deposits and replace the plate.
9. Make sure die front holder has no rubber in threads and apply Copperite once a month to keep threads from damage (Never attempt to attach a cold die holder to a warm machine – Use the pre-warmer or machine head to warm up to temperature before fitting).
10. Prior to operator finishing his/her shift, all machine tools must be re-located onto shadow board and machine area needs to be swept up and bins emptied in accordance with local 5S standards.