

Help & FAQ

Here you can find frequently asked questions and assistance as well as helpful tips for purging with CORATEX. If you have any further questions, please do not hesitate to [contact us](#).

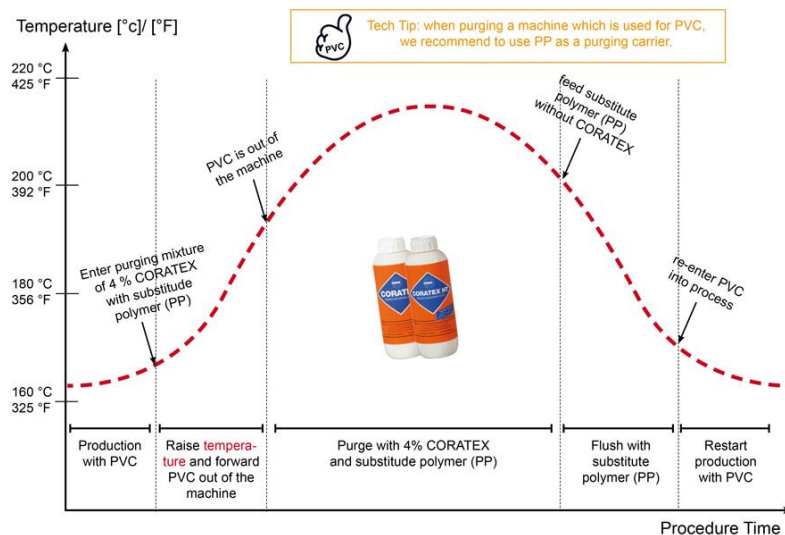
1. For which plastics can CORATEX / CORATEX HT be used?

For all available plastics granulates with a maximum temperature of 400 degrees Celsius; in addition to this specification, CORATEX HT can also be used for manual purging and polishing of tools, moulds, and stainless steel surfaces

2. Can CORATEX/CORATEX HT be used for CPVC?

Yes, CORATEX/CORATEX HT can be used for this kind of plastics; if the extruder or injection moulding machine used for PVC is to be cleaned, it is recommended to use PP as the purging material carrier. This enables you to reach a temperature window from 200° up to 220°. When rinsing with pure PP, temperature will be reduced to 165° to 185°. The equipment will then be ready again to operate with PVC. For PVC operations we recommend to observe following steps:

1. Remove the nozzle and clean it manually,
2. Insert the purging compound of PP nature and 4 % Coratex,
3. Operate with this compound until only remainders of PVC are leaving,
4. Increase temperature up to 200° to 220° and carry out the purging operations,
5. Rinse with a small quantity of pure PP while setting the temperatures as necessary for the production process of the new raw materials.



3. Which plastics granulate should be used as base polymere if a high quality plastics granulates, e.g. PSU (polysulphonate) or PC (polycarbonate) will be used for production?

If a high quality plastic granulate will be used for your production, you can use a compound of PP nature oder PP [Crystal clear] plus 3 % CORATEX / CORATEX HT in order to minimize expenses with good results. PP is stabile up to 320°, and can therefore be used for purging as a substitution for almost all plastics granulates.

4. Is it correct to have a MFI (Melt Flow Index) of 0.2 to 0.3 when mixing the CORATEX / CORATEX HT cleaning emulsion?

A low MFI of 0.2 to 0.3 is considered stiff material. It will surely bring out most of the material.

5. What are the procedures of ABS moulds?

Recommended procedure:

remove the nozzle from the machine and cauterize the plastics, in other words, increase the barrel temperature to approx 250° and apply only 2-5 % pressure. ABS moulding at higher temperatures will cause more purging problems.

- The nozzle will best be purged by cauterization with a gas flame and by manual cleaning.

6. What can be done if contamination is still observed in the subsequent plastic after cleaning?

Particularly stubborn contamination

Repeat cleaning according to standard procedure, further reduce temperature in extruder

Severe damage to the screw (e.g. grooves, break-outs, porous spots)

Replace screw

Damage to the barrel inner wall (e.g. cracks, scores, pits)

Rework cylinder

Unfavourable flow conditions in the head, nozzle and tool areas (due to design or wear)

Repair parts with unfavourable flow conditions or replace them with parts designed with favourable flow conditions.

7. What can cause hot runner systems not to become clean?

Cause

Hot runner system with unfavourable flow (e.g. blind holes, undercuts, angular passages),

Hot runner temperature too low

Remedies

Change the design of the hotrunner system,

Increase the temperature in the hot runner system up to the maximum temperature (depending on the mould).

8. What can be done against extreme soiling or very stubborn paint streaks, e.g. caused by soot or after the unit has been shut down?

Generally, switch off the screw for approx. 15 minutes and allow the granulate-CORATEX HT mixture to act in the extruder and hot runner.

9. What should be considered when using high-quality plastic?

If high-quality and expensive plastics are used, a cleaning granulate made of "PP natural" or "PP crystal clear" and 3% CORATEX can also be used with good results - to further reduce cleaning costs. (PP is resistant up to temperatures of 320°C and can therefore be used with almost all plastics).