



Transforming
surfaces
...and beyond

SIMPLY BETTER PURGING.



PURGING EMULSION FOR PLASTIC PROCESSING MACHINES

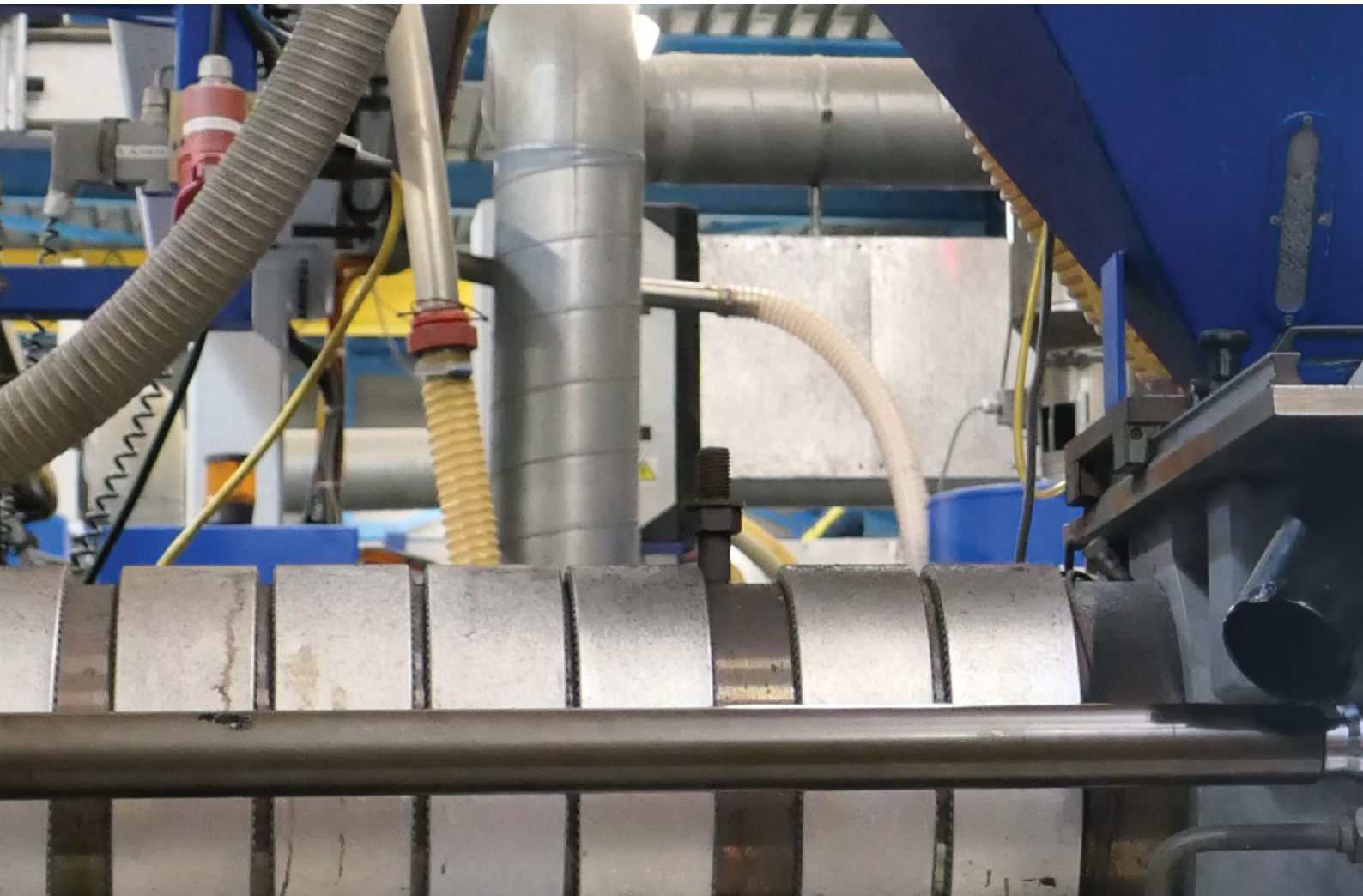




CORATEX® & CORATEX® HT

REDUCE DOWNTIME, ACCELERATE CHANGEOVERS, AND IMPROVE PRODUCTION EFFICIENCY.

CORATEX® is a high-performance purging emulsion for injection moulding and extrusion applications. It effectively removes contamination, oxidation traces, carbon residues, and black specks, helping to maintain consistent product quality while reducing cleaning time and purging costs.



KEY BENEFITS

- ▲ Fast and efficient machine cleaning during operation
- ▲ Reduced downtime and increased productivity
- ▲ Low purging costs and easy handling
- ▲ Compatible with most common thermoplastics
- ▲ Supports preventive maintenance

IDEAL FOR:

- Colour and material changes
- Preventive maintenance programs
- Machine start-up after shutdowns
- Removal of black specks and carbon deposits

SUITABLE FOR:

- Injection moulding machines
- Extruders
- Hot runner systems
- Screws, barrels, nozzles and extruder heads

MATERIALS:

ABS • CA • PMMA • PA • PC • PET • HDPE • LDPE • PEEK • POM • PP • PS • PSU • PVC • PVDF • SAN • TPU and many more

WHY PROCESSORS TRUST CORATEX®**QUALITY**

Certified quality.
Proven performance.
Reliable results for decades, manufactured under strict quality standards in Germany

EFFECTIVE

Maximum cleaning efficiency.
Removes contamination, carbon residues and black specks while reducing downtime and changeover times.

VERSATILE

One product. Multiple applications.
Compatible with most common polymers and suitable for both machine and manual purging processes.

AVAILABLE PRODUCTS

DESCRIPTION	CONTENT		ART. NR.
CORATEX®	800ml	10 bottles	66261030130
CORATEX® HT*	800ml	10 bottles	66261030549

* VOC- and ammonia-free with a pleasant orange scent.
Safe to use as directed and ideal for hand polishing individual machine components.



**SIMPLY
BETTER
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EFFECTIVE CLEANING THROUGHOUT THE ENTIRE PROCESS

CORATEX® is mixed with a carrier polymer and passes through the complete processing system. During the process, contamination, colour residues, oxidation products and carbon deposits are loosened and removed from critical machine components.

PROVEN CLEANING PERFORMANCE

RESTORED TO OPTIMUM CONDITION

Effective removal of contamination from screws and processing units.

BEFORE



AFTER



PROVEN RESULTS

- ▲ Removes black specks
- ▲ Eliminates carbon deposits
- ▲ Cleans screws and barrels
- ▲ Improves product quality
- ▲ Reduces downtime

BLACK SPECK REMOVAL

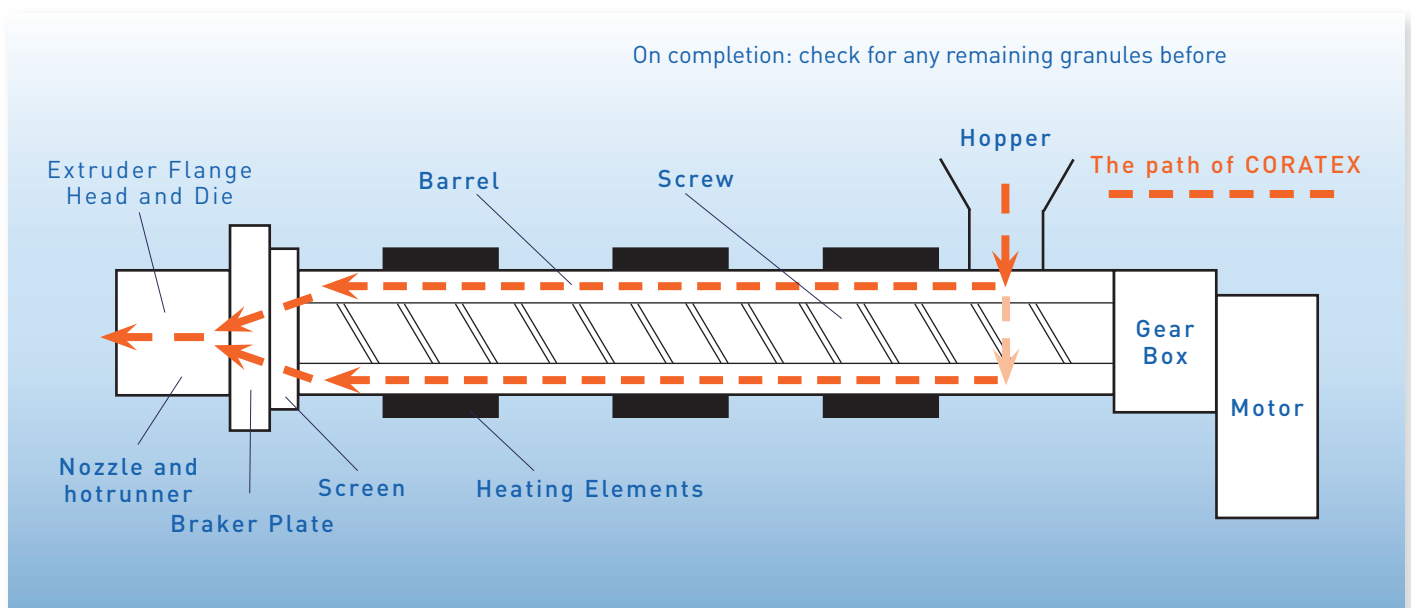
PMMA before and after cleaning with CORATEX®.



CORATEX® effectively removes black specks, degraded material and carbon deposits, helping restore production quality and minimise rejects.

HOW CORATEX WORK?

From hopper to die, CORATEX® cleans the entire flow path.



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7 STEPS FOR OPTIMAL PURGING

Follow these seven proven steps to achieve maximum cleaning efficiency, minimise downtime and optimise production performance. Proper preparation, processing and flushing are essential for the best results.



The following procedure has been developed to maximise cleaning efficiency and ensure consistent purging results.

PREPARATION

1



- Ensure free and unrestricted access of the CORATEX® purging mix into the machine hopper.
- Remove dryers, dosing equipment and material feeding systems from the hopper whenever possible.
- Check that the screw can freely intake material.
- Remove any residual material from previous production runs.
- Verify the machine's process settings before starting.

Unrestricted material flow allows the CORATEX® mixture to move evenly through the entire processing unit, ensuring more effective cleaning of the screw, barrel, nozzle and hot runner systems

RECOMMENDED PROCESSING TEMPERATURE

2



Set the processing temperature to approximately 10–20% below the normal processing temperature of the polymer (see Temperature / Ratios Table - page 8)

- Alternatively, use a polymer with a lower melt flow rate as the carrier material to maintain standard processing temperatures.
- Keep the mould temperature unchanged.

Lower processing temperatures enhance the cleaning effect of CORATEX® by improving its adhesion to contamination, oxidation traces and carbon residues. This makes deposits easier to remove from screw and barrel surfaces, resulting in more effective cleaning and improved purging performance.

PREPARING THE PURGING MIX

3



- Shake CORATEX® well before use.
- Add 18–36 ml per kg of polymer granules.
- Mix thoroughly until all granules are evenly coated.

Uniform coating ensures optimum distribution of the cleaning agents throughout the process, delivering consistent cleaning results and maximum efficiency.

Important: Do not overdose CORATEX®. Excessive amounts may cause hopper bridging and feeding problems without improving cleaning efficiency.

PURGING PROCESS

4



- Verify that the recommended purging temperatures have been reached.
- Reduce screw speed to approximately 50% of the normal operating speed.
- Feed the prepared CORATEX® purging mix gradually into the machine.
- Allow the cleaning compound to pass through the entire system.

During this stage, CORATEX® removes colour residues, contamination, oxidation products, burnt polymers and black specks, carrying them out of the process together with the carrier polymer.

FLUSHING

5



- After the purging compound has passed through the machine, resume production using clean plastic granules.
- Use approximately 30% of the amount of cleaning compound used during the purging process.
- Continue processing until the system is completely flushed.

This step removes residual CORATEX®, loosened contaminants and remaining cleaning compound from the system. It ensures the machine is fully prepared for the next production run and helps prevent contamination of the new material.

EVALUATE THE RESULTS

6



- Inspect the material exiting the machine after flushing.
- Check for black specks, colour contamination, streaking, burnt material or other processing irregularities.
- If contamination is still visible, repeat the purging process (Steps 2–5).

In most cases, a second cleaning cycle will remove any remaining contamination and restore clean processing conditions.

READY FOR PRODUCTION

7



- Remove any remaining coated granules from the feed section.
- Return all temperatures to standard production settings.
- Check the material feeding system and confirm correct resin flow.
- Resume production.

A clean machine is the foundation for consistent product quality and efficient processing. Regular preventive cleaning helps reduce downtime, minimize rejects and maintain peak machine performance.

APPLICATION GUIDELINES

TECHNICAL DATA: TEMPERATURES & PROPORTIONS

TYPE OF PLASTIC		PROCESSING TEMPERATURE RANGE (°C)	PURGING TEMPERATURE RANGE (°C)	CORATEX PROPORTION IN THE PURGING MIX			
				SCREW DIAMETER < 60mm Ø		SCREW DIAMETER > 60mm Ø	
				ml/kg	in g/kg	ml/kg	in g/kg
ACRYLONITRILE-BUTADIENE-STYRENE COPOLYMER	ABS	200 - 250	170 - 190				
ACRYLONITRILE-COPOLYMER	SAN	200 - 220	180 - 200				
CELLULOSE-ACETATE	CA	220 - 260	190 - 230				
PEEK	PEEK	370 - 390	340 - 360				
POLYAMIDE	PA	250 - 280	220 - 230				
POLYCARBONATE	PC	280 - 330	230 - 280				
POLYESTER (AMORPHOUS)	PET	180 - 220	150 - 200				
POLYESTER (LINEAR)	CPET	230 - 300	200 - 250				
POLYETHYLENE	HDPE/ LDPE	180 - 250	150 - 190	18-25	25 - 35	25 - 36	35 - 50
POLYMETHYL-METHACRYLATE	PMMA	210 - 230	180 - 200				
POLYOXYMETHYLENE	POM	170 - 210	140 - 170				
POLYPROPYLENE	PP	200 - 250	170 - 200				
POLYSTYRENE	PS	200 - 270	170 - 210				
POLYSULPHONATE	PSU	350 - 400	320 - 350				
POLYVINYLCHLORIDE*	PVC	160 - 180	140 - 160				
POLYVINYLIDENE FLUORIDE	PVDF	200 - 220	180 - 200				
THERMOPLASTIC POLYURETHANE	TPU	200 - 220	180 - 200				

When purging a machine used for PVC, we recommend using PP as the purging material carrier; refer to our special application guide for more information. Volume of the cap (on the bottle) = 30 ml



The recommended quantity of CORATEX® depends on screw diameter, machine size and degree of contamination. The table below provides indicative dosing guidelines for optimal cleaning performance.

QUANTITY REQUIRED FOR PURGING MIX WITH CORATEX® & CORATEX® HT

SCREW Ø (in mm & inch)	20 - 40 0.75 - 1.5	40 - 50 1.5 - 2	50 - 60 2 - 2.5	60 - 80 2.5 - 3	80 - 100 3 - 4	100 - 120 4 - 4.5	120 - 150 4.5 - 6	150 - 175 6 - 6.5	175 - 200 6.5 - 8
RECOMMENDED* (in kgs)	0,5 - 1	1 - 3	3 - 5	5 - 10	10 - 25	25 - 35	35 - 70	70 - 90	90 - 150

* Approximate values; depending on screw configuration and degree of contamination. Suitable for all known commercially available polymers and processing temperatures up to 400°C / 750°F.

CORATEX® HT ADVANTAGES

CORATEX® HT can be as valuable for manual cleaning as it is for purging. CORATEX® HT is also extremely suitable as a polishing agent for tools, moulds and stainless steel surfaces.

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QUICK SOLUTIONS FOR COMMON PROCESSING CHALLENGES



BLACK SPECKS STILL VISIBLE?

Possible causes

- Stubborn carbon deposits remain in the screw or barrel.
- Previous material residues were not fully removed.
- Purging cycle was too short or flushing was insufficient.

Recommended action

- Repeat the CORATEX® purging cycle.
- Increase residence time where possible.
- Lower processing temperature slightly.
- Inspect screw, barrel and tooling if contamination persists.

COLOUR CONTAMINATION AFTER CHANGEOVER

Possible causes

- Residual colour remains in the flow path.
- Insufficient flushing after purging.
- Contamination in hot runner systems, nozzles or dies.

Recommended action

- Repeat the purging cycle.
- Increase the flushing phase.
- Check hot runners, nozzles and tooling.
- Ensure the complete material path has been cleaned.

HOT RUNNER NOT PROPERLY CLEANED?

Possible causes

- Restricted flow through the hot runner system.
- Incorrect processing temperature.
- Heavy contamination in gates or nozzles.

Recommended action

- Increase hot runner temperature within safe limits.
- Perform an additional CORATEX® cleaning cycle.
- Inspect hot runner components and nozzles.
- Allow sufficient exposure time before flushing.

EXTREME CONTAMINATION OR COLOUR STREAKS?

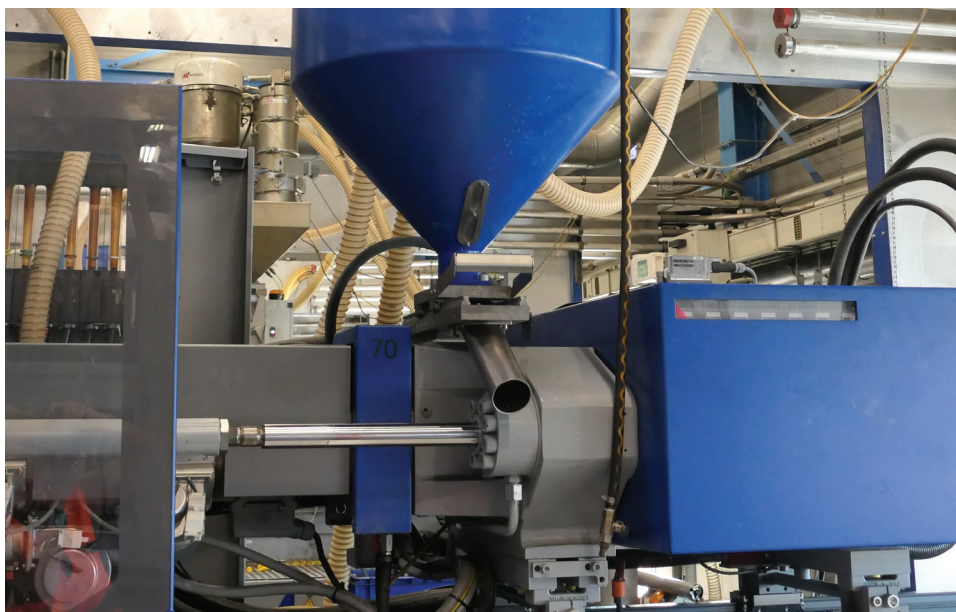
Possible causes

- Severe carbon build-up.
- Long machine downtime.
- Material degradation within the processing unit.
- Multiple colour changes without preventive cleaning.

Recommended action

- Stop screw rotation for approximately 15 minutes after introducing the purging mix.
- Allow CORATEX® sufficient time to dissolve contamination.
- Resume the full purging and flushing procedure.
- Repeat the cleaning cycle if required.

SPECIAL APPLICATIONS



SMALL SCREW DIAMETERS (< 30 MM)

Recommended approach

- Follow the standard CORATEX® dosage recommendations.
- Ensure thorough mixing with the carrier polymer before feeding.
- Increase residence time whenever possible to maximise cleaning efficiency.
- Reduce screw speed slightly to improve cleaning performance.

TEMPERATURE CHANGE (PVC → PC / PA)

Recommended approach

- Use natural PP as an intermediate carrier material.
- Perform a complete CORATEX® purging cycle before introducing the new polymer.
- Ensure all PVC residues have been removed from the processing system.
- Resume normal processing temperatures only after the transition is complete.

HIGH-VALUE POLYMERS

Recommended approach

- Use natural or crystal-clear PP as the carrier material.
- Add 3% CORATEX® by weight to the carrier polymer.
- Compatible with most engineering and high-performance polymers.
- Minimise material loss by reducing unnecessary flushing.

SYSTEMS WITH DEGASSING ZONES

Recommended approach

- Reduce processing temperature where possible.
- Keep the degassing zone active during the cleaning process.
- Follow the standard CORATEX® purging procedure.
- Use additional feeding material where required to maintain consistent flow.



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