**Mat Process and Storage - recommendations**

**Desanding / Mat Shaker / Mat Beater** Removing dirt and debris prior to washing can be beneficial to the wash process. The dry solid matter is also more easily disposed of.

**Washer Extractor** Do not use dry cleaning machines, dishwashers or ozonated water systems. Do not use machines for carpet cleaning.

Partition - Y or Open Pocket Yes

Centrifuge – G force G-Force more than 600 is not allowed, we recommend a max G -Force of 400. When using G-Force more than 250 we recommend a stop for ca 30-60 seconds after reaching 250-300 to give the water a chance to rinse off and to avoid water pockets

**Tunnel Washer**

Centrifuge - G force: G-Force more than 600 is not allowed, we recommend a max G -Force of 400. When using G-Force more than 250 we recommend a stop for ca 30-60 seconds after reaching 250-300 to give the water a chance to rinse off and to avoid water pockets

**Membrane Press** Kleen-Tex does not recommend the use of membrane presses for processing mats

**Tumble Dryer** Do not over dry mats. As a general guideline, moisture weight should be 5 to10% of the fabric weight

Gas or steam yes

Infrared controlled yes

Inlet temperature Max 120°C

Outlet temperature Max 80°C

Mat temperature Recommended between 25°C and 35°C after Cool Down

Drying Time Between 12 and 30 minutes up to 5 – 10% residual humidity,

Cool Down Process? Yes, we recommend ca 5-10 min Cool Down

**Storage Conditions** Mats should be removed from the dryer promptly upon completion of the dryingcycle and laid flat until cooled to at least 30°C before storage.

Flat Yes

Rolled Yes

Folded not recommended/only for transport to and from customer

Rolling Machine? Yes

**Detergent** Some detergents can be detrimental to mats. The easiest way to avoid this isusing washing liquids/powders recommended by producers for mat washing

Specific Mat Detergent Yes

pH Value 6 - 10

Additional Booster Agents Fat removers are OK to use in prewash if not exceeding pH 10

Optical Brightening Agent? Not allowed

Chlorine? Not allowed

Oxidizing Bleach Not allowed

**Washing Process** Can be determined with machinery provider

Washing temperature max 60 C. Usually it is enough to wash light soiled mats with 30 C, heavily soiled mats 40/60 C

Rinses

Clean or Recycled water? Kleen-Tex recommends the use of fresh water. The use of recycled water must not result in wash or rinse bath with a pH below 6 and above 10. When using recycled water check parameters of pH and detergent content.

OBA, Chlorine, Oxidizing Bleach in

recycled water? Not allowed

**Chemical Damage to Mats** Chemical damage to mats may not show effects immediately. They can sometimes take months or years to have a detrimental effect. Below is a list ofspecific chemicals to avoid.

Acids - such as acetic acid, formic acid, peracetic acid and sulphuric acid should not be used. Especially where this results in a wash or rinse bath with a pH below 6. These acids should not be used as spotting agents. Other acids are on the list so please check before exposing mats to them.

Chlorinated hydrocarbons - as such agents at higher temperatures may damage the mats.

Vegetable or Biodegradable oils - these oils may affect the rubber and damage the mats by causing dimensional instability

Solvents such as ozone, ketones, esters, aldehydes, chlorinated and nitro hydrocarbons, aromatic and aliphatic hydrocarbons, as these will cause damage to the rubber