



Kleen-Tex mats can withstand most normal processing, handling, storage and end customer use conditions but they are not indestructible and can become ripped, cut or torn. Cuts and tears are usually the result of customer damage/abuse or may occur during processing and handling. Mats that have not been seriously damaged can be repaired.

Kleen-Tex are able to offer a Repair and Refurbishment service for damaged mats. Please consult with your account manager for further information on this service.

In addition you are able to carry out your own repairs using one of the many heat seal presses available today. Repairs can last as long as 50 washes if carried out correctly. The type, setup and effectiveness of heat seal equipment can vary widely depending on the available air pressure and the heat produced by the individual machine. Because of this, we recommend that you thoroughly check the equipment to be used and then make some tests using the information below as a guide. It is also recommended you carry out wash test to evaluate the results before undertaking a large project.

Hot Plate Heat Seal Mat Repair Process

Required Materials:

- Suitable hot plate repair press
- Grinder with coarse disc or electric drill with wire brush/sanding attachment
- PTFE/Teflon coated fabric
- Uncured repair rubber 35 mm wide – available to purchase from Kleen-Tex
- Scissors
- Gloves
- Face Shield
- Dust Mask

Repair Procedure:

- Inspect mats to ensure suitability for repair. Discard mats with numerous tears, excessively large tears, long tears that are in the centre of the mats etc.
- Use grinder or drill to clean the rubber surfaces around the cut/tear so you have a rough rubber surface. If the mat is kleeted, be sure to remove all kleeted. Even with smooth backed mats it is also necessary to buff the surface to improve the bond with the new rubber. Be careful not to be too aggressive during grinding as you may grind through the rubber backing, damaging the mat.
- Set the timer to 6 - 10 minutes. Temperature should be minimum 160 °C and not exceed 200 °C. Pressure should be min. 3 bar.
- Cut rubber to size of clean area. Remove polythene backing.
- Apply rubber to repair area.
- Place mat in heat seal machine. Cover repair with PTFE/Teflon fabric. Be sure rubber side of mat faces the hot plate. If you have double sided heated elements please test time and temperature thoroughly first.
- Close press.
- Allow repaired mat to cool.
- Trim Excess Rubber from edge of mat.