

Cleaner with Chematic™

Technical Brief for : CLEANING OF COATING PANS

Date : November 2007

Subject : Colorcon Opadry® Coating Removal with
Chematic® 410 and Chematic® 405

| Opadry® Color | Wash Step 1 – 30 Minutes | | | Wash Step 2 – 30 Minutes | | | Rinse – 10 Min. |
|---------------|--------------------------|-----------|---------|--------------------------|-----------|---------|-----------------|
| | Conc. | Detergent | Temp. * | Conc. | Detergent | Temp. * | Temp. * |
| White | 5% | CMT 410 | 30°C | 5% | CMT 410 | 37°C | 37°C |
| Gray | 5% | CMT 410 | 30°C | 5% | CMT 410 | 37°C | 37°C |
| Yellow | 5% | CMT 410 | 30°C | 5% | CMT 410 | 37°C | 37°C |
| Brown | 5% | CMT 405 | 33°C | 5% | CMT 405 | 37°C | 37°C |

* Temperatures provided are minima to be achieved with a range of +5°C.
Temperature specified to minimize foaming and promote effective removal.

Coating Pan Cleaning Cycle Recommendations

When using Chematic® 410 or 405 to clean coating pans the recommended procedure is a two-step detergent cleaning process.

Wash Step 1 uses the spray nozzles of the coater at cool temperatures, with a minimum temperature of 30°C (33°C for Chematic® 405). The air going into the spray nozzles should be adjusted so that the optimum amount of impingement can be achieved with the spray nozzles. During Wash Step 1, the detergent solution should be sprayed to drain until the heavy layer of coating is removed from the coating pan surfaces.

Wash Step 2 collects the detergent solution in the coating pan until the perforated drum can rotate through the detergent solution collected in the bottom trough. After filling the trough to the appropriate level, the speed of the drum should be increased, creating greater agitation on the surface of the drum. Throughout Wash Step 2, the detergent solution should continue to be sprayed through the nozzles. This step is best performed at a slightly elevated temperature (minimum temperature of 37°C).

Rinse may be performed in one step if draining is occurring while spraying. Two steps are required if bed is to be recirculated through the trough prior to draining. Maintain temperatures to prevent redeposition until fully rinsed.

Note: Times may vary depending on the number of layers of coating applied to the pan and the amount of impingement provided by your spray devices.



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