



## Loes Enterprises, Inc

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### RECIRCULATING DIP TANK HINTS & DIAGNOSTICS

1. Tank may be stationary or raised and lowered hydraulically. Therefore, the molds on the conveyor line, if one is employed, can be lowered into the dip tank or the tank raised to meet the parts. Raising or lowering the tank while the conveyor is stationary is much easier and more practical in most application.
2. Recirculating pump should not run when parts are being dipped. This will cause an uneven coating or thin parts on pump inlet end.
3. Dip parts on flat side to prevent running and sagging of plastisol to middle or the low spot on the part. After dipping, the part can hang 2-5 minutes over a drip pan before entering the oven. Drippings can be added back into the dip tank.
4. Parts can be inverted immediately after they gel over the drip pan or hung vertically through the cure cycle. This can reduce the post gelation dimple at the bottom of the mandrel and the sagging through the cure cycle.
5. Dip tank should be kept at 95° to 104°F for optimum processing. Cold plastisol affects build, air release and pumpability. A hot dip tank temperature (more than 105° F) can cause thickening and eventual gelation of the plastisol. Gelled plastisol can not be completely reconditioned and hold its original processing characteristics. The best solution to gelled plastisol from over-heating is dilution with cold prime plastisol require lower dip tank temperatures for stability. Consult a Loes Enterprises representative if you have any comments or questions on the above.
6. For even build, especially with high build plastisols on large and/or oblong parts, dip mandrels into the tank as quickly and as smoothly as possible without trapping air. This will help in minimizing overheating of plastisol at the top of the dip tank where the hot mandrel enters and remains the longest in the dip tank. This uneven heating or layering of temperature will cause more build at the top of the part than the bottom.

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