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### FOUR PART RECIRCULATING DIP TANK

1. **DIP TANK:** Holds an adequate volume of plastisol, depending upon the part size.
2. **OVERFLOW CHAMBER:** Catches plastisol overflow from main dip tank and allows for the addition of fresh plastisol from a drum. Add about the same weight of material into the reservoir as is extracted by the part being molded. Plastisol is 100% solids and without weight shrinkage. Convert pounds solid to a volume factor by a pounds per gallon coefficient (ie. @10 lbs/gal) For example: Six parts weighing three pounds total converts to 38.4 fluid ounces or 1.2 quarts. This amount of plastisol should be added to the priming tank while the dip is in progress.
3. **RECIRCULATING LINE:** Pump is not shown. Pump recommendations: Diaphragm model or substitute. It is important to use a pump which will not inject air into the plastisol.
4. **PRE-DIP CHAMBER:** Collects air bubbles which may not have been broken in the overflow chamber. A baffle allows for plastisol to flow evenly by varying hole size and placement. Air Bubbles collect at the top of the chamber.
5. **DIP TANK DESIGN:** Modifications to the above can be made as the designer sees fit. For example: the overflow reservoir does not have to be attached directly to the dip tank. Instead the two can be connected by a trough.
6. **SCREENS:** For filtration it can be submerged at the bottom of the overflow reservoir, preferably in front of the baffle. The screen filters out gelled lumps of plastisol and contaminating particles which may fall into the dip tank.