

CARTRIDGE DISPENSING AND STATIC MIXING LIST OF DO'S AND DON'TS

DO:

Storage:

Systems without fillers – store nozzle up, temperature not very critical..

System with fillers – store in a cool place on their side to minimize settling and allow any settling to be consistent through the length of the cartridge.

Set up:

Use a new mixer with every cartridge.

Attach mixer in a vertical position and try to dispense a small quantity into the mixer before using so any air in the cartridge is minimized.

Pre-bleed least a 3" bead of material or until a uniform color is obtained.

Maintain adequate dispensing velocity.

Mixer Selection:

Use the narrowest possible mixer which gives adequate flow rate. If mix is still insufficient continue to use longer mixers (more elements). Wide mix ratios and/or viscosity differences usually require longer mixers. If mix is still insufficient flow rate should be increased by higher pressures and/or warming the material.

Cartridge Selection:

Thick walled cartridges such as Mix-Pak or TAH give very little lead / lag when cartridge is pulsed. Larger thin walled cartridges such as Ratio-Pak and Systems II give more lead/lag mix quality trouble when pulsed unless used in the DTI EZ Mix.

DON'T:

Storage:

Do not store over 80F, avoid temperature fluctuations which aggravate epoxy crystallization.

Set up:

Transfer used mixers from cartridge to cartridge. Allow air bubbles or pockets to remain inside a barrel.

Mixer Selection:

Don't assume one mixer will work the same for the same product under all conditions.

Cartridge Selection:

Don't expect large / thin walled cartridges to give a consistent mix when pulsed.