



TECH TIPS

a technical bulletin by the experts at Gaco Western

Important Factors

When Using Air Mixers in Drums

The thicker the resin the tougher it is to get a swirl of material in the drum. Most resins are anywhere from 500 centipoise and half pound density all the way to 2 pound at around 1,000 centipoise and 3 pound density at 1,200-1,300 centipoise. GacoFireStop2 is around 4,000 centipoise. It is very thick and needs to be mixed thoroughly. Below are the key elements to successfully mixing your resin:

PROPER DIRECTION

There are many styles of drum mixers, and only one mixer (the electric Grovac mixer) runs in a single direction. This means that for the majority of options available to you, you must be aware of inputs and outputs to be sure your mixer is operating in the proper direction. A brand new mixer comes with the muffler and air inlet valve. The unit must be assembled by the customer who has purchased it. A used mixer may have been incorrectly assembled leaving confusion for the new owner as to what is input or output. If you run air into the mixer through the wrong port, the mixer will operate in the wrong direction.

LET'S COMPARE TWO MIXERS GRACO Mixer and the IPM Mixer.

As you can see, they look similar to each other but that doesn't mean they are exactly the same or that they have interchangeable parts. I have seen paddles from the IPM Mixer mounted on the GRACO unit which may seem like it wouldn't make a difference.

WHAT DIFFERENCE DOES IT MAKE?

If the paddles have the opposite pitch, the mixer will run in the opposite direction. If you are having trouble or are not sure if your mixer is running in the right direction, try switching the paddles.



GRACO Mixer

IPM Mixer

Having trouble with foam? Just pick up the phone!

Gaco Western's Tech Hotline: **855 639 4649**

8am - 8pm CST, Mon-Sun

Ideas, suggestions or questions?

techtips@gaco.com



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(Continued)

AIR PRESSURE

Another potential issue with mixers is AIR. Air mixers use a lot of air and need a big supply line. I recommend a 1/2" line. If you are running a different air compressor to run the mixer and you're running a long hose to feed the mixer you will experience pressure loss due to the length of the air supply line.

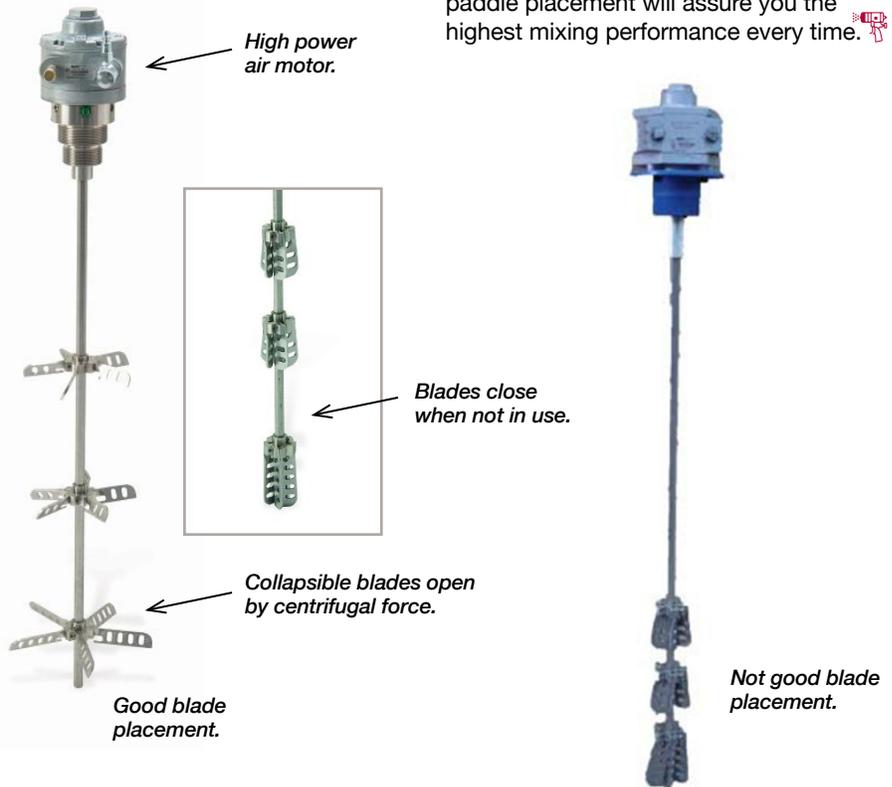
LUBRICATION

Air mixers also need oil in order to get longevity and success out of the unit. There should be an automatic oiler on the air supply line that is feeding the mixer.

BLADE DIRECTION

Correct location of the expandable blades on the mixer shaft is paramount to proper performance. Spacing becomes increasingly more important as resin thickness increases. If blades are not spaced correctly, the top material will not be properly mixed with the bottom which can affect installation and performance. Many mixers come from the factory with blades set at the bottom shaft as pictured.

In summary, the thicker the resin you are mixing, the more important it is to make sure your mixer is well-maintained and functioning properly. Checking the direction, air pressure, lubrication and paddle placement will assure you the highest mixing performance every time. 



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