

Sizing Cages



In the blown film extrusion process, the sizing cage (aka, sizing basket, calibration cage or calibration basket) is used to stabilize the blown film bubble directly over the die and air ring. Keeping the bubble stable over the die and air ring improves film quality by ensuring the air ring and internal bubble cooling effects are uniformly applied to the entire circumference of the bubble.

As production rate increases, and in particular, when internal bubble cooling is used, the sizing cage is a required feature. The higher production rates require more air flow on the bubble which results in bubble movement and sometimes complete instability. A sizing cage provides an excellent bubble stabilizer.

Sizes Available

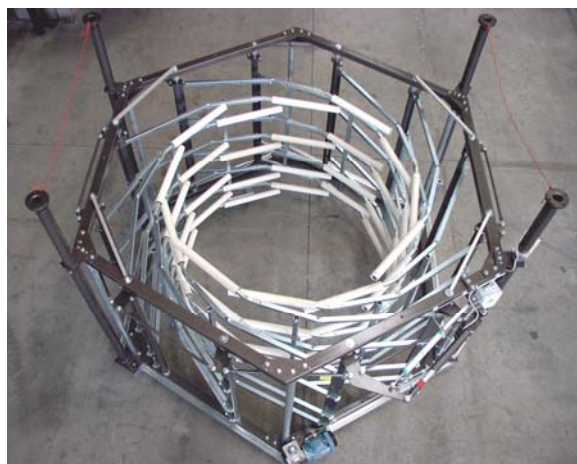
D.R. Joseph offers sizing cages in two size ranges. The cage pictured to the left comes with 3-5 levels, 8 arms on each level in a size range of 800-2950 mm (32-116 inches). The cage pictured below comes with 3-5 levels, 12 arms on each level in a size range of 3300-5000 mm (129 -196 inches).

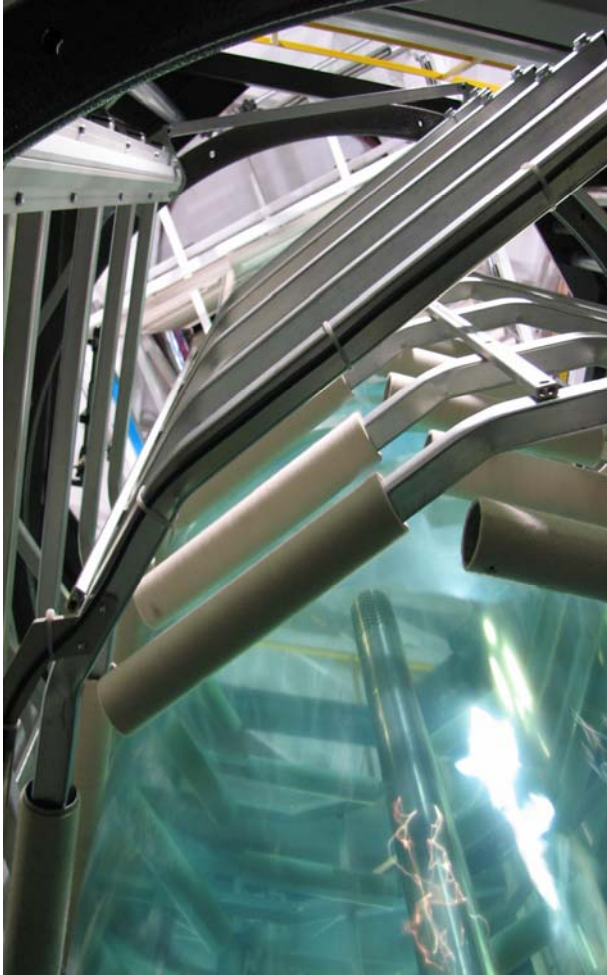
Options

- ⦿ Speed Regulation Control
- ⦿ "X-Y" Axis Adjustment for Centering the Cage
- ⦿ Vertical and Diameter Adjustment
- ⦿ Sensor Bracket for DRJ IBC Sensors

IBC Compatible

Sensor brackets for D.R. Joseph IBC sensors can be provided to move the IBC sensor with the cage so the sensor always points towards the vertical centerline of the bubble (+/- 6 inches) for all bubble sizes.



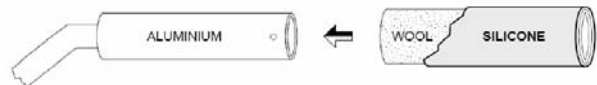


Single Rotating Cylinder Arms

These sizing cages have arms with special insulated coverings. These coverings protect against heat transfer from the blown film bubble and provide a soft, insulating contact with the film. This solution has been developed with the support of several film makers to assure consistent field test feedback. The standard cover is composed of special wool felt sockets that can be replaced or re-used after washing, if necessary. One additional set is included with the cage as a spare part.

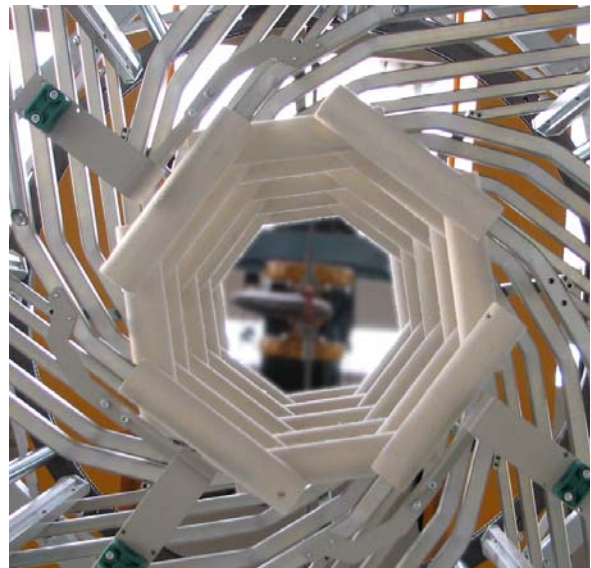


To achieve a better surface in contact with the bubble, another option has been developed. This option binds together a standard wool socket with an additional silicone cover characterized by a homogenous and smooth surface. This option reduces maintenance and cleaning, and satisfies the requirements of food and medical applications. It is possible at anytime to remove the silicon cover and use the standard wool socket alone. If this combination is ordered, spares can be purchased separately.



Performance and Benefits

- ⦿ No Scratches or Markings
- ⦿ No Film Thickness Variation
- ⦿ Brilliant Film Transparency
- ⦿ Even Gauge
- ⦿ Protects Against Heat Transfer From Bubble
- ⦿ Increased Bubble Stability
- ⦿ Faster Extrusion Speed
- ⦿ Easy Installation of Covers
- ⦿ Covers Cleaned or Replaced Easily
- ⦿ Great with Soft or Tacky Films
- ⦿ Significant Reduction in Maintenance



D. R. Joseph

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2125 S. Great Southwest Pkwy, #101, Grand Prairie, TX 75051 USA Email: sales@drjosephinc.com
 Website: www.drj1.com Phone: 972-641-7711 Toll Free Number: 800-767-4470 Fax: 972-641-8747