

# D.R. Joseph Blown Film Lab and Seminar Center

## MONO LAYER

The DRJ Blown Film Lab is a versatile R&D environment, which houses a mono-layer blown film line (with 80 or 33mm die), accompanied by a variety of state of the art quality assurance equipment. DRJ offers the lab space and equipment for rent to customers interested in R&D development on a economical scale, avoiding the costs related to full size production testing. All equipment is separately metered, and conveniently maintained on an isolated, secure server. The DRJ Blown Film Lab is an ideal setting for:

- Establishing Processability
- Product development
- Testing new formulations
- Short prototype runs

### Line features & spec's:

- 1.77" (45mm), 30:1, Feed screw with ambient water cooled feed throat
- Inverter Controlled Dual lip Air Ring with Low Melt Strength Lip Set for Biomaterials and TPU
- Regulated chilled cooling air via Eurochiller ABFevo
- Auto Width Control & Auto Calibration for fast startups via DRJ LF-Sizer
- Gammatec Soft Silicone Roller Bubble Cage
- Adjustable tower height: 78-92" (air ring to nip)
- Gusseting boards
- Pearl Edge slitters
- Surface Winder – Torque or Dancer Tension Control
- Max production: 65 lbs./hour (29.5 kg/hr)
- Max Line Speed: 270 feet/minute (82 mpm)
- Formulation Change-Over Time: 10-15 minutes

Die Dia.	Die Gap 1	Die Gap 2
3.15" 80mm	.047" 1.2mm	.090" 2.3mm
1.30" 33mm	.047" 1.2mm	

Experienced personnel are on hand to aide running the blown film line. Extrusion services are offered on an hourly basis, with additional services available such as resin drying, and film property testing (see reverse side for more info). For rental inquiries, contact us at [drjlab@drjosephinc.com](mailto:drjlab@drjosephinc.com)



### Available Roll Formats (3" Core):



Layflat Tubing



C-Fold



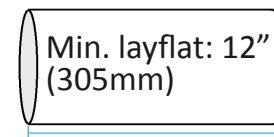
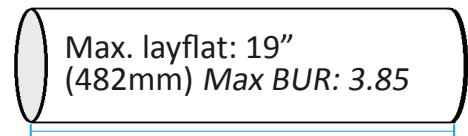
Gusseted Tubing



Single-Wound Sheeting



Double-Wound Sheeting



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# Available QC Equipment

The QC equipment includes:

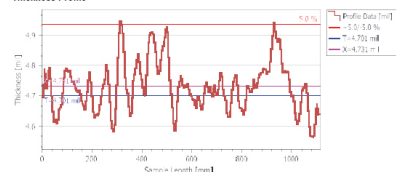
- Offline thickness measurement ISO Cert.
- Tensile and peel strength ASTM D882, D3354
- Elmendorf tear ASTM D1424, D1922, D689, TAPPI T414, ISO 6383-1, 6383-2, 1974
- Dart impact testing ASTM D1709
- Haze/gloss light transmission ASTM D1003, D1044
- Coefficient of friction ASTM D1894
- Color spectrography ASTM D2244, E308, E1164, ISO 7724, 5036, 6174  
Gloss: ASTM D2457, D523 7668 DIN 67530, JIS 8741 DIN 5033 ISO 2313
- Burst tester (2 types) ASTM D1922, D1424, D689, TAPPI T414, ISO 6383-1, ISO 6383-2, ISO 1974
- FLIR infrared camera
- Fiber optic inspection camera
- Oven for heating samples (max temp. 518°F / 270°C)

KUNDIG CONTROL SYSTEMS  
The Group Manufacturer for Film Extrusion

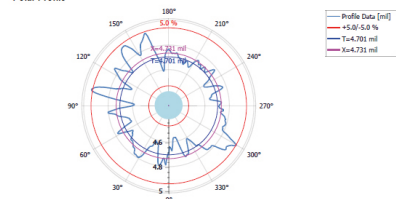
## Quality Report

Customer	D.R. Joseph	Length	1114 mm
Order Number	test sample	Square Meter Weight	110.502 gsm <sup>2</sup>
Production Line	1	Target Thickness	4.700 mil
Timestamp	4/7/2022 8:53:35 AM	Average Thickness	4.731 mil
Work Shift	Morning	Min Value	4.563 mil
Operator	mp	Max Value	4.945 mil
Roll Number	1	2s	0.163 mil
Recipe	LDPE	2s	3.5 %
Density	0.920 g/cm <sup>3</sup>	Comment	

## Thickness Profile



## Polar Profile



## Sample Gauge Profile Report

A technician is available to perform quality assurance tests with the available equipment, and produce the respective QC data reports. While reliable and repeatable QC data can be furnished with testing, please note that DRJ labs is not currently an accredited lab, and testing / results are supplied on an as-is basis.



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