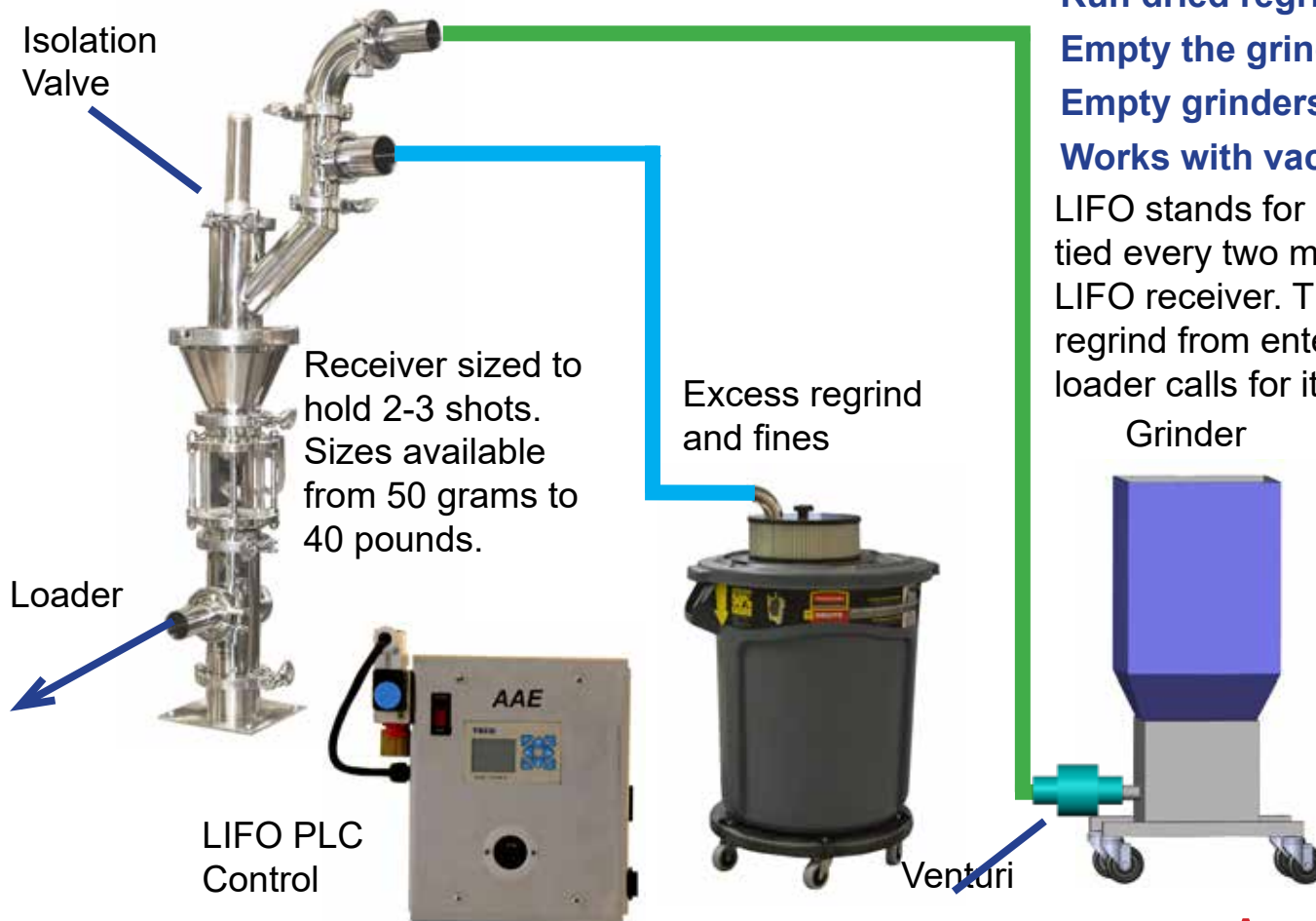


## Advanced Regrind Management

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**By-pass excess regrind**

**Run dried regrind without moisture regain.**

**Empty the grinder every two minutes.**

**Empty grinders do not clog.**

**Works with vacuum or compressed air loaders.**

LIFO stands for last in first out. The grinder is emptied every two minutes. Regrind is blown into the LIFO receiver. The isolation valve prevents the regrind from entering the material stream until the loader calls for it. Once the LIFO receiver is full

the excess regrind is by-passed to the filtered container. When the material switch calls for material the LIFO valve opens allowing regrind to drop to the receiver. Regrind is returned to the process within two minutes before it can regain moisture. The LIFO grinder unloader will work with either a vacuum or compressed air loader.

**Amazing Quality!**

## Advanced Regrind Management



### Load blenders and regrind feeders.

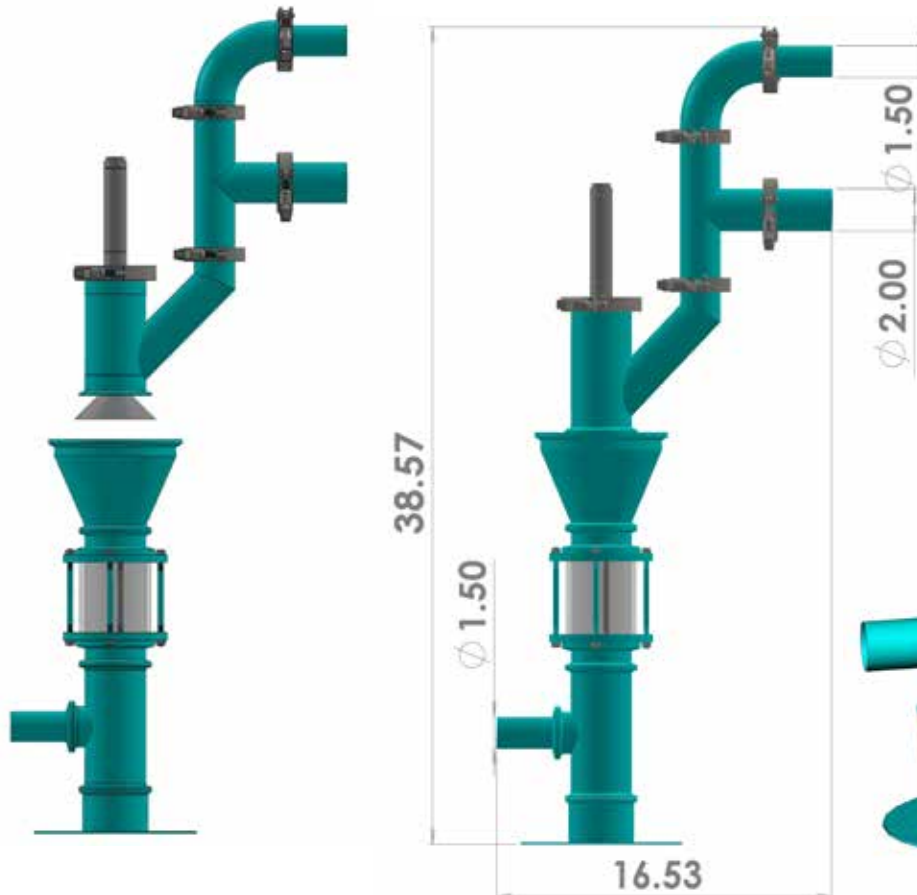
LIFO hopper loaders can be used to load blenders and regrind feeders. The material switch should be mounted in the hopper as low as possible or at a level equal to 2 to 3 shots of material. Two minutes of residence time for extrusion. When the material switch calls for material the isolation valve will open delivering fresh dry regrind to the process.

The LIFO PLC control should be set to empty the grinder on a regular basis. The cycle is normally set to unload for two to four seconds and delay for two to three minutes.

For higher rates shorter unload and delay times may be needed to supply adwquet regrind to the process. The grinder is not unloaded when the isolation valve is open.

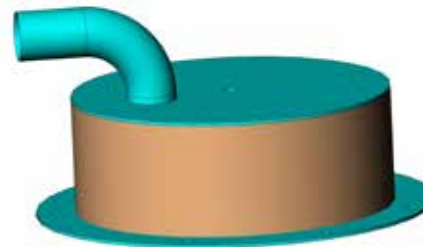
**Amazing Quality!**

## Advanced Regrind Management



### Size the correct LIFO grinder unloader for your application.

In general you should have the capacity for 2-3 shots in both the LIFO receiver and the holding hopper. If you are using a LIFO hopper unloader the sensor should be at the level for 2-3 shots or as low as possible. If the LIFO receiver is smaller than 3 shots you can increase the rate by running shorter delay times. Typical time settings are 2-4 seconds on and 120 seconds off.



Base dimensions  
O.D. 12"  
Cut-out 8" I.D.  
Bolts, 6-3/8", 11" circle