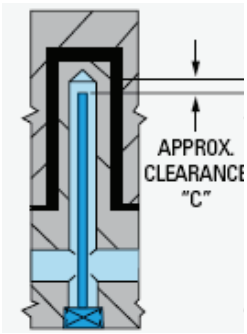
Drawing No: ME-0615-PS-018(D)
Catalog No: PBF-9999

TURBULANT FLOW PLASTIC BAFFLE
Installation Data

42827 Irwin Drive
Harrison Twp, MI 48045 USA
US 800-656-6656
CANADA 800-387-6600
www.dme.net

Baffle Catalog No.	NOMINAL PLUG SIZE [inches]	**S** HEX SIZE [inches]	**L** NOMINAL LENGTH [inches]	**T** BAFFLE THICKNESS [inches]	**W** BAFFLE WIDTH [inches]	DRILL SIZE [inches]	**C** +0.03 -0.00 [inches]	Recommended Torque [ft-lbs]
PBF0125-04	1/8	3/16	4	1/16	5/16	5/16	.12	4-5
PBF0125-08	1/8	3/16	8	1/16	5/16	5/16	.12	4-6
PBF0250-05	1/4	1/4	5	3/32	7/16	7/16	.17	4-6
PBF0250-10	1/4	1/4	10	3/32	7/16	7/16	.17	4-6
PBF0375-06	3/8	5/16	6	3/32	9/16	9/16	.21	8-10
PBF0375-12	3/8	5/16	12	3/32	9/16	9/16	.21	8-10
PBF0500-08	1/2	3/8	8	3/32	11/16	11/16	.26	20-25
PBF0500-16	1/2	3/8	16	3/32	11/16	11/16	.26	20-25
PBF0750-12	3/4	9/16	12	1/8	15/16	15/16	.35	28-35
PBF0750-24	3/4	9/16	24	1/8	15/16	15/16	.35	28-35
PBF1000-12	1	5/8	12	3/16	1 1/8	1 1/8	.35	40-43
PBF1000-24	1	5/8	24	3/16	1 1/8	1 1/8	.35	40-43

PRODUCT APPLICATION



- Baffle is intended to be used with plastic injection molds.
- Baffle is intended to be used with water or glycol-based coolant.
- Baffle is installed in standard gun-drilled cooling line and CNC-standard NPT-F threaded holes.

⚠ CAUTION

- Surface of mold or plate may be hot. Coolant may be hot enough to burn skin.
  Hot coolant may be under pressure while in use or prior to servicing. Relieve pressure in system prior to servicing or replacing baffle. Wear protective clothing, safety goggles with side shields and protective gloves when servicing baffle or working around mold.
  Failure to follow these instructions may cause burns or injury.
- Do not exceed a coolant application temperature of 100 °C (212 °F).
- Do not use baffle with oil or oil coolant.
- Do not expose the baffle to flame cutting.
- After installing baffle, check thread area for coolant leakage. If leakage present, replace plastic flow baffle. Prior to installing replacement baffle, check installation for proper machining.
- Failure to install the baffle properly may result in coolant leakage under pressure, burns or injury.

INSTALLATION INSTRUCTIONS

- Recommended diametrical tolerance for cooling hole is +/- 0.002" (+/- 0.05mm).
- Baffle is dimensioned with one inch increments. Select desired length of baffle and cut to the desired length. Clearance is required between the end of baffle and the end of coolant hole to provide adequate coolant flow. Recommended clearance dimension "C" is provided in table above. Smooth cut edge of baffle with file or sand paper.
- Plastic baffle has a molded wiper located along the full length of each long edge of the baffle. Wipers are intended to come into contact with inside wall of coolant hole, and are designed to reduce coolant flow past long edges of baffle. Wipers may require smoothing via a file or sand paper, however if smoothing is required, take care not to remove wipers entirely.
- If replacing existing baffle with new baffle, some corrosion or scale may be present on inside wall of coolant hole. Additional smoothing of baffle wipers may be required prior to installation.
- Check thread seal tape to ensure tape is not damaged. If tape is damaged, add pipe tape to thread area of baffle.
- Insert lead cut edge of the baffle into the coolant hole first. As baffle is inserted, continually turn baffle clockwise. Do not drive baffle into coolant hole using hammer or similar tool.
- Take care not to damage hex on head of baffle during installation. If hex is damaged and baffle needs to be removed, a hand drill may be used to remove baffle. Take care not to damage coolant hole or thread area during baffle removal.
- Once baffle is installed, use recommended torque (see chart) to tighten the baffle into the threaded installation. Do not thread and unthread baffle, as this may diminish thread and wiper seal and performance.
- It is not recommended to use torque setting that exceeds the recommended torque value provided in chart.
- If corrosion or scale is present in coolant hole, additional smoothing of wipers may be necessary prior to installation. Failure to do so may require higher torque to install baffle into coolant hole than torque value provided in chart.
- If baffle needs to be removed from the coolant hole, it is recommended to replace the baffle.