



MOULDING TRIAL REPORTS: Summary

MATRIX F1-G

SL. NO.	PRODUCT DETAILS			RAW MATERIAL		MACHINE TONNAGE	PROCESSING PARAMETERS				CYCLE TIME REDUCTION	
	Name	Total Shot Wt gms.	No. of Cavities	Type	MFI		Before MATRIX F1-G		With MATRIX F1-G		Sec's	%
							Cooling Time	Cycle Time	Cooling Time	Cycle Time		
1	Cosmetic Container	14	4	PP	10	200	5	15.27	2	12.27	3	19.65
2	Housing	36	4	PBT 20% GF	-	160	8	30	6	24	6	20
3	Pen Barrel	47.84	16	PP	20	85	26	36	19	28.8	7.2	20
4	Pen Cap	51.2	32	PP	20	85	17	28.3	10	21.3	7	23
5	House Ware	448	8	PP	-	430	23	54.5	18	44.6	9.9	18.2
6	Cold Cream Cap	24.5	4	PP	10	150	7	18.8	4	15.8	3	16
7	Brush Handle	474	12	PP	-	400	20	43.4	10	33.8	9.6	22.2
8	Lip Stick Cap	49.6	16	PP	10	150	14	27.55	8.5	21.72	5.83	21.16
9	18Lts. Paint Pail	735.5	1	PP	10	450	15	32.5	12	29	3.5	11
10	Rack Tray	370	1	PP	10	350	11	37.5	11	32.4	5.1	13.6
11	Chair	1908	1	PPCP	5	750	35	62	30	55.5	6.5	10.5
12	Auto.Component	-	2	Nylon GF30%	-	120	40	60	20	40	20	33.33
13	Auto.Component	-	2	Nylon GF30%	-	85	30	71.6	15	56.6	15	21
14	Auto.Component	-	2	Nylon 6	-	50	9	19.5	3.5	13	6.5	33.33
15	Handle Grip	80	1	PVC Compound	-	150	45	85	25	65	20	23.5

Note: Sr.No. 1 to 8 used 2% dosing of MATRIX F1-G and from Sr. No. 9 to 15 only 1% dosing.

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