

Employment of **PLASTRON** products

Cycle Time Reduction

Standard Machine Parameters

Application:	Stacking box
Process:	Injection moulding
Machine:	Krauss Maffei 380-2700 E3, y.o.c.: 2008
Shut off nozzle/ Hot runner:	No/ NO
Raw materials:	PP recycled
Shot weight:	74 g
Cycle time:	35 s
Holding pressure:	60 bar
Filling time:	22 s
Temperature profile:	210/220/220/220/210 °C

With Nucleant **PLASTRONNUC C 20 – N**

Nucleant:	PLASTRONNUC C 20 – N
Dosage:	0.7 %
Cycle time	27 s
Holding pressure:	40 bar
Filling time:	14 s
Shot weight:	73 g
Weight reduction:	1 g
Temperature profile:	200/210/210/210/200 °C

Melt temperature reduction:	10°C
Cycle time reduction:	23 %
Holding pressure reduction:	20 bar
Weight reduction:	1 g
Energy saving:	0.01 KW/h kg
Deformation:	reduced, see picture



With PLASTRON NUC C 20-N

Without nucleation