

Employment of **PLASTRON** products

Cycle Time Reduction

Standard Machine Parameters

Application:	Production of buckets
Process:	Injection moulding
Machine:	Krauss Maffei 380-2700 E3, y.o.c.: 2008
Shut off nozzle:	yes
Raw materials:	PP
Shot weight:	319 g:
Cycle time:	11, 5 s
Holding pressure:	55 bar
Temperature profile:	50/255/255/265/265/265/265/240/265/250 °C

With Nucleant **PLASTRONNUC C 20 – N**

Nucleant:	PLASTRONNUC C 20 – N
Dosage:	0, 7 %
Cycle time	10 s
Cycle time reduction:	13%
Shot weight:	302 g
Weight reduction:	5%
Holding pressure:	50 bar
Temperature profile:	50/235/235/245/245/245/245/220/245/230 °C
Melt temperature reduction:	20°C
Energy saving:	0,016 KW/h kg
Deformation:	reduced, see picture



Without nucleation



with nucleation