

Employment of PLASTRON products

Cycle Time Reduction

Standard Machine Parameters

Application:	Piece of pushchair
Process:	Injection moulding
Machine:	20Battenfeld TM 1000
Shut off nozzle/ Hot runner:	No/ NO
Raw materials:	PP with colour
Shot weight:	115 g:
Cycle time:	59.73 s
Holding pressure:	15 bar for 5 s
Cooling time:	43 s
Injection time:	4.89 s
Temperature profile:	205/200/195/190 °C

With Nucleant PLASTRONNUC C 20 – N

Nucleant:	PLASTRONNUC C 20 – N
Dosage:	0.4 %
Cycle time:	42 s
Cycle time reduction:	30 %
Holding pressure:	10 bar for 10 s
Cooling time:	25 s

Injection time:	5.28 s
Temperature profile:	200/195/185/180 °C
Melt temperature reduction:	10°C
Energy saving:	0.01 KW/h kg
Deformation:	reduced, see picture

