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- Screw Roll With Nut
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- Natural Rubber
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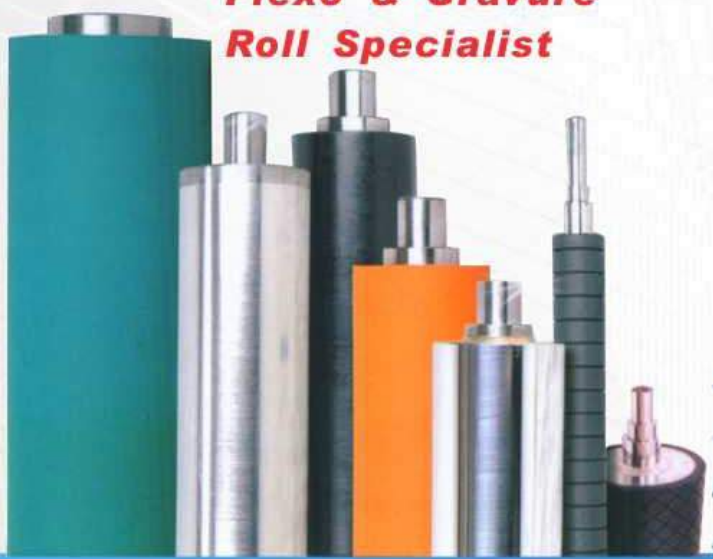

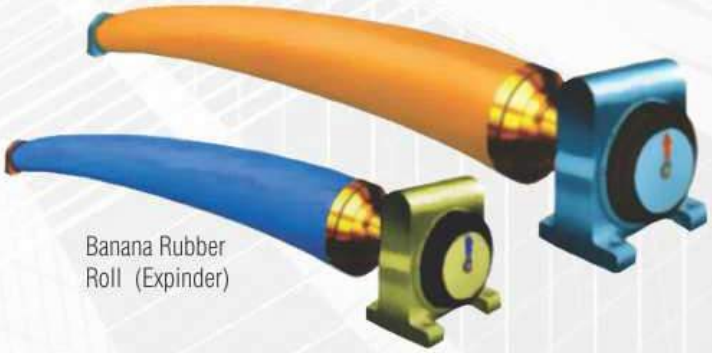

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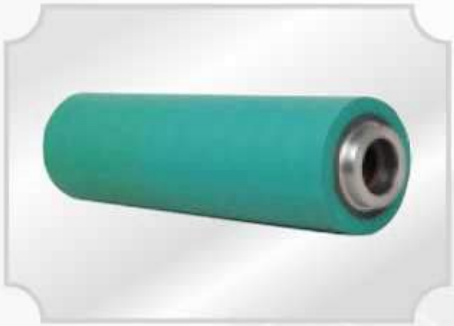

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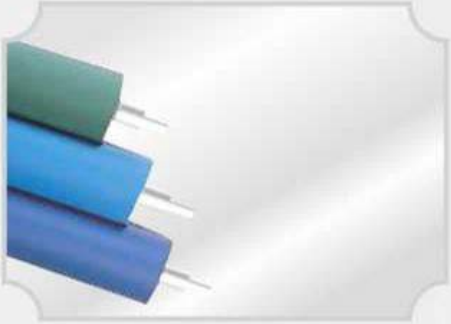

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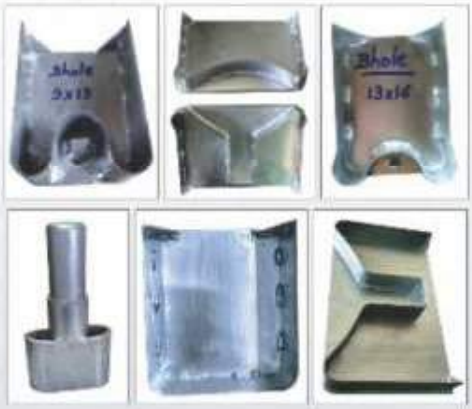

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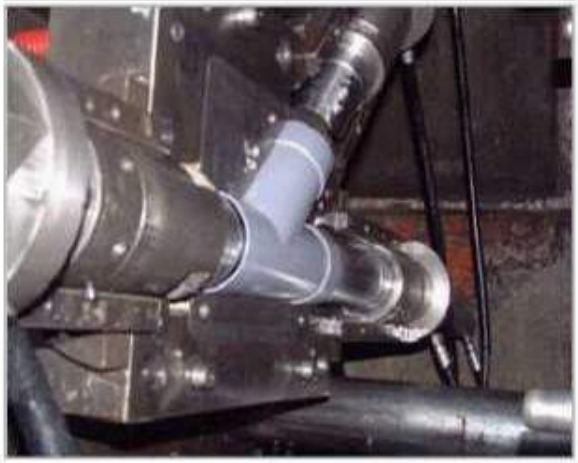

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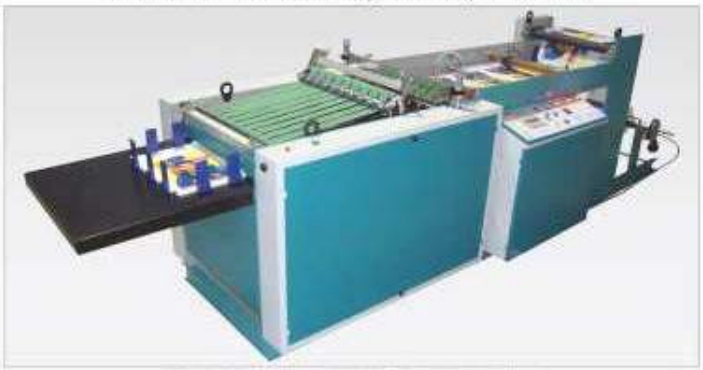

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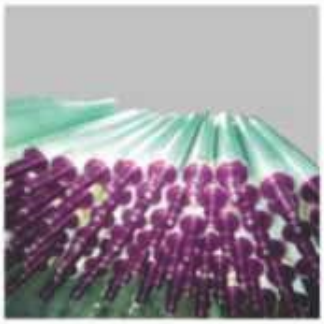

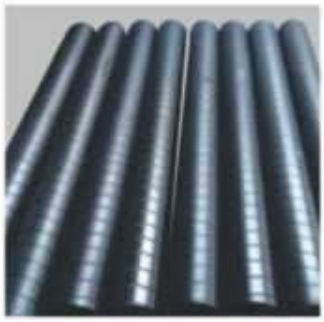

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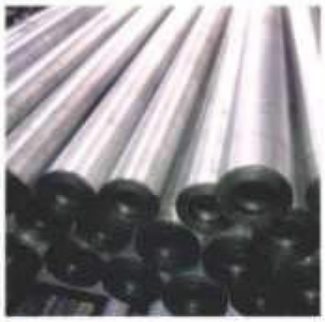





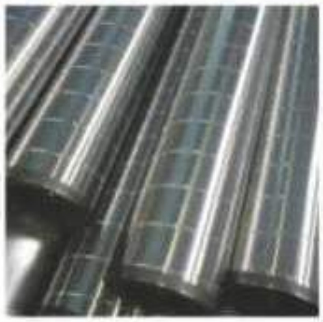

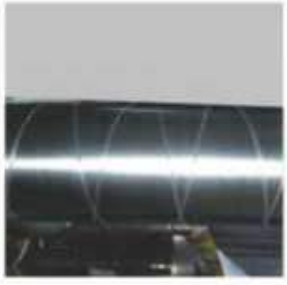

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Editorial

Indiaplast 2019, a poineering exhibition for plastics industry 28th Feb. . to 04th March. 2019,

The Indian plastic industry which has opened up a very large scale development in the Indian economic scenario is also heading towards revolutionising the production of plastic goods in terms of having a world class technology in Plastics Machinery Manufacturing. Looking at the rate of per capita plastic consumption across US and Europe between 50-100 kg in comparison to 10 kg in India gives India a challenging export oriented platform. In this existing scenario the evolution of new age Plastic Exhibition will showcase to the nation and the world the ability of our Plastic Industry today. INDIAPLAST 2019 in Association with PLASTASIA, an evolved plastics exhibition is a jointly organised by the Plastics Machinery Manufacturers Association of India (PMMAI) and Triune Exhibitors Pvt Ltd is among the leading upcoming Plastic Exhibition in India. INDIAPLAST 2019 will also be an exclusive Exhibition on Plastic Machinery and an Exhibition on Plastic Raw Materials . PMMAI is the apex body of Plastics machinery manufacturers in India. Its members include an elite list of quality conscious, result-driven companies who have a track record of consistent performance. With a vision to make Indian Plastics machinery Industry a global player in providing world class products at a competitive price the Mission is to work continuously for Indian plastics machinery to be world class in terms of quality, technology and cost competitiveness. Triune Exhibitors with their successful track record of six Plastics Machinery and Raw Materials Exhibition – PLASTASIA is a leading organiser of industrial exhibitions and have a commendable track record of over forty five exhibitions to their credit including Plastic Exhibition in Delhi. As in the Words of Mr.Mahendra N Patel, Chairman, PMMAI "Evolution is a natural order. It is time now for our industry to evolve a changed paradigm for organising industry exhibitions. Our industry needs to focus exclusively for developing business and competing with global players. With "Make in India" initiative of the Government, India is now a destination of choice for overseas companies to set up manufacturing base. Plastics consumption in India is growing. Domestic manufacturers are reaching saturation of their capacity. This will further invite competition. No doubt newcomers will expand the market and create new opportunities. But we all have face the onslaught of competitors. We have to be a stronger competitor." A POWERFUL AND EMERGING PLASTICS EXHIBITION FOR THE HIGHLY COMPETITIVE AND GROWING PLASTICS INDUSTRY The shift in gears of the plastics industry has propelled the need to host an International Plastics Exhibition which will bring over 900+ exhibitors from over eighteen countries. These serve as an influential stage to bring companies, professional and experts under a common umbrella in order that information is shared and develops long lasting business relationships. As an inevitable part of marketing and promotions exhibitions are mediums to showcase businesses in actions which is unavailable through other marketing media. Imagine the volume of buyers and sellers in the industry being brought together at the same time by itself is a message of growth in this evolving exhibition. Indiaplast 2019 in association with Plastasia will be held at India's most reputed exhibition centre – The INDIA EXPO MART, Greater Noida on over 72,000 Square Metres of space with indisputable on-site facilities. Plastics Trade Shows or Plastics Trade Fairs cater to the industry which is poised for a substantial leap in the years to come. With an evolved Plastic Machinery Exhibition IndiaPlast 2019 will not just be restricted to a genre of the industry but involve all the players of the Indian Plastic Industry. Listed among the leading upcoming Plastics Trade expo Indiaplast 2019 has an array of key participants who would showcase their products through live demonstration which is a salient feature of a Machinery Exhibition. KEY PARTICIPANTS IN INDIAPLAST 2019 GUARANTEED AN ULTIMATE AND WHOLESOME EXPERIENCE OF PLASTICS INDUSTRY With a number of upcoming International plastics exhibitions and trade fairs the Plastics Industry across the globe has also seen exclusive Plastics trade shows like Blow Moulding Exhibition, Injection Moulding Exhibition, Raw Material Exhibition to name a few. Globally India is emerging as a leading hub for plastic manufacturing and processing. Machines made in India are technologically advanced and compete well with those manufactured by suppliers from developed economies. Indiaplast 2019 has a singular objective and vision – to showcase the strengths of Indian manufacturers to India and the world and at its heart, Indiaplast 2019 is a machinery expo but there's much more to it! Many other exhibitors that are complimentary to machines will augment Indiaplast 2019. These will be companies that specialize in raw materials, masterbatch, auxiliary equipment, mould makers, additives, polymer companies and many more. Indeed INDIAPLAST 2019 is truly an evolved Plastics Exhibition to showcase all under a common roof

We **The Orient Sp- Age Publication** wish grand success before to the coming great exhibition..

- Editor

Rajesh Gohil

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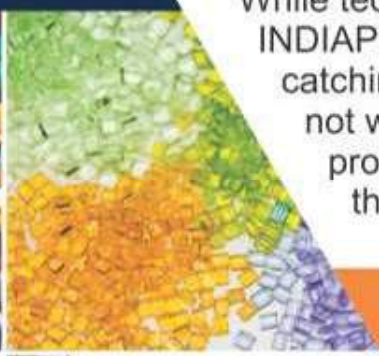

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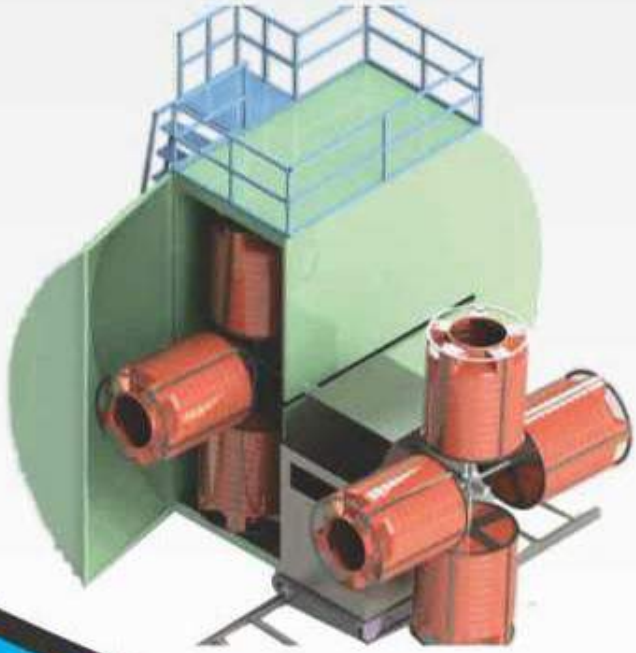

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Industry 4.0 - current trend of automation and data exchange in injection molding technologies at K

Industry 4.0 or the fourth industrial revolution, is the current trend of automation and data exchange in manufacturing technologies. It includes cyber-physical systems, the Internet Of Things and cloud computing. Industry 4.0 creates what has been called a "smart factory" and will be the important "mantra" for injection molders at K 2016. For producers of plastic parts it promises to be a real game-changer, allowing every processing detail to be attached to a component for immediate recall from anywhere in the world at any time. Some of the injection molding technologies being featured at K 2016 include:

Milacron will mark its European show debut at K 2016 with its co-injection PET Technology. The M-PET 300, is a servo-hydraulic co-injection PET system, which combines key components across Milacron's product portfolio - machines, clamps, injection unit, post mold cooling, co-injection hot runner, mold and robots - into a single solution. The M-PET system will be utilizing a state of the art co-injection hot runner system and co-injection nozzles featuring Kortec technologies. The New Mold-Masters M-AX servo axis controller is Milacron's most technologically advanced controller to date. The M-AX controller has the same powerhouse TempMaster Adaptive Process System (APS) used to control temperature in our entire temperature control line up but also contains an unmatched ability to control motion functions as well. Milacron's SmartMold module allows different pieces of equipment to talk to each other, improving process quality and efficiency all while providing improved information and metrics. It collects data and reports the data via the cloud or LAN, and also allows for the scheduling of regular and preventive maintenance.

Netstal will demonstrate the Elios 7500, a new high performance injection molding machine with a clamping force of 7500 kN. An extremely high-performance, robust and highly precise machine that is optimally tailored to meet the rigorous demands of the competitive thin-wall packaging market. The Elios 7500 will be in continuous operation at K: With a cycle time of 4 seconds, more than 43,000 round lids with a part weight of 2.8 grams are produced per hour in a 24+24 stack mold. The Elios is currently the fastest (measured according to Euromap) dry cycle in its size class, due to its newly developed and especially energy-efficient electrical clamping unit. The centrally aligned 5-point dual toggle lever ensures optimum introduction of force into the center of the mold installation space, and therefore uniform distribution of the clamping force. The robust design effectively prevents any deformation of the mold plates. The very large pillar distance and the extremely ample opening stroke facilitates the installation of stack molds or simple molds with large cavities. Husky Injection Molding Systems will launch of its next-generation system for high-output beverage closure molding, HyCAP4, that includes several new capabilities and features that combine industry-leading performance and productivity with energy efficiency. The system is also equipped with intelligent features that make it easier to use, with simplified controls for faster process set-up and improved repeatability. To optimize productivity and efficiency while producing high-quality, lightweight closures, Husky made adjustments such as electrification of the clamp motion, servo-variable pumping technology and a regenerative clamp stroke. Combined, these enhancements deliver up to 40% improvement in energy consumption over the previous generation, without sacrificing performance, explained Husky. Additionally, by integrating more intelligence into the system, operators of all skill levels are able to maximize productivity and part consistency. Enhancements include a new part eject assist feature to ensure a consistent freefall of closures at the fastest cycles, and sensor-driven mold alignment to reduce mold wear. Husky's patented intelligent Mold ID technology helps to further simplify start-up and improve ease of use while providing information on mold maintenance, process set-up and

Continues On Page No.: 50

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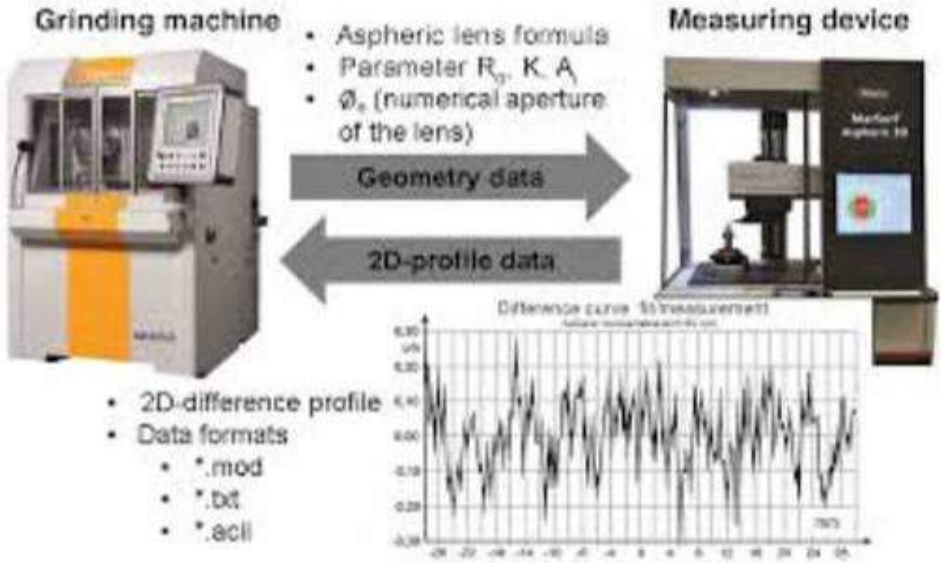
Industry 4.0 - current trend of automation and

operation for each start-up. Jomar has announced the launch of its next-generation injection blow molding (IBM) machine series that incorporates a unique custom-designed servo-driven hydraulic system. The Jomar IntelliDrive Series delivers major improvements in energy consumption, output and performance while also maintaining the machine's footprint. It features precise servo-driven hydraulics that reduces energy consumption by 40-50% and boasts a dry cycle time of 1.8 seconds, which is significantly faster than standard hydraulic machines. Along with the lower energy and utility costs, the IntelliDrive series offers a reinforced main platen, which reduces the possibility of deflection. The machine also features a closed-loop system for the machine's clamping system, which delivers exact control over the clamp's speed and position. The IntelliDrive series has a higher degree of control over the machine's internal functions, resulting in more efficient use of energy.

Sumitomo SHI Demag will showcase networking solutions for all aspects of injection moulding machines under the banner Electrified 4.0. Of particular interest to the customer is that Sumitomo (SHI) Demag not only equips new machines with Industry 4.0 solutions, but offers retrofitted solutions for plant that is already in operation. This ensures production efficiency throughout the life of the machine.



Wittman will introduce Unilog B8 controller for all its injection machines. It has a larger, 21.5-in. color multi-touch screen, capable of displaying two pages at once, and it runs under the new Windows 10 IoT ("internet of things") operating system. Wittmann will also run an 1100-ton MacroPower press in the first public demonstration of its Condition Monitoring System (CMS), part of its "Smart Services". Key machine status data will be measured by sensors, processed by the machine's controller, and passed on to a corporate or plant MES system for maintenance planning.

Arburg will present a mini smart factory linking an Allrounder injection machine with its Freeformer 3D printer and a seven-axis robot. A total of 27 machines will be on display at K with a focus on: Entry-level electric series: ALLROUNDER GOLDEN ELECTRIC, lightweight construction, silicone and high-speed machines, Automation ranging from pickers to turnkey systems, Innovative cube-mould technology for two component closures, Injection moulding of a wristwatch from two different liquid silicones (LSR), High-speed medical technology application

Haitian will have three recent developments at the show.

The "p" (for packaging) version of the Venus II all-electric series (150 to 450 m.t.) is aimed at high-speed, high-cavitation applications with cycle times above 4 sec, such as caps and closures for cosmetics. It comes with a square platen, modified machine bed to handle heavy molds, and a 25:1 L/D injection unit with speeds up to 350 mm/sec and a special ballscrew to avoid overheating during fast cycles. A 300-m.t. model will mold an IML cup in 4.4 sec. The new Jupiter II plus series, an enhancement of the Jupiter II. These two-platen models now have significantly faster clamp movements, new linear guides that eliminate lubricant and friction on the tiebars, optimized platen structure that reduces deformation, and a new Keba controller with 15-in. screen offering double-page view .

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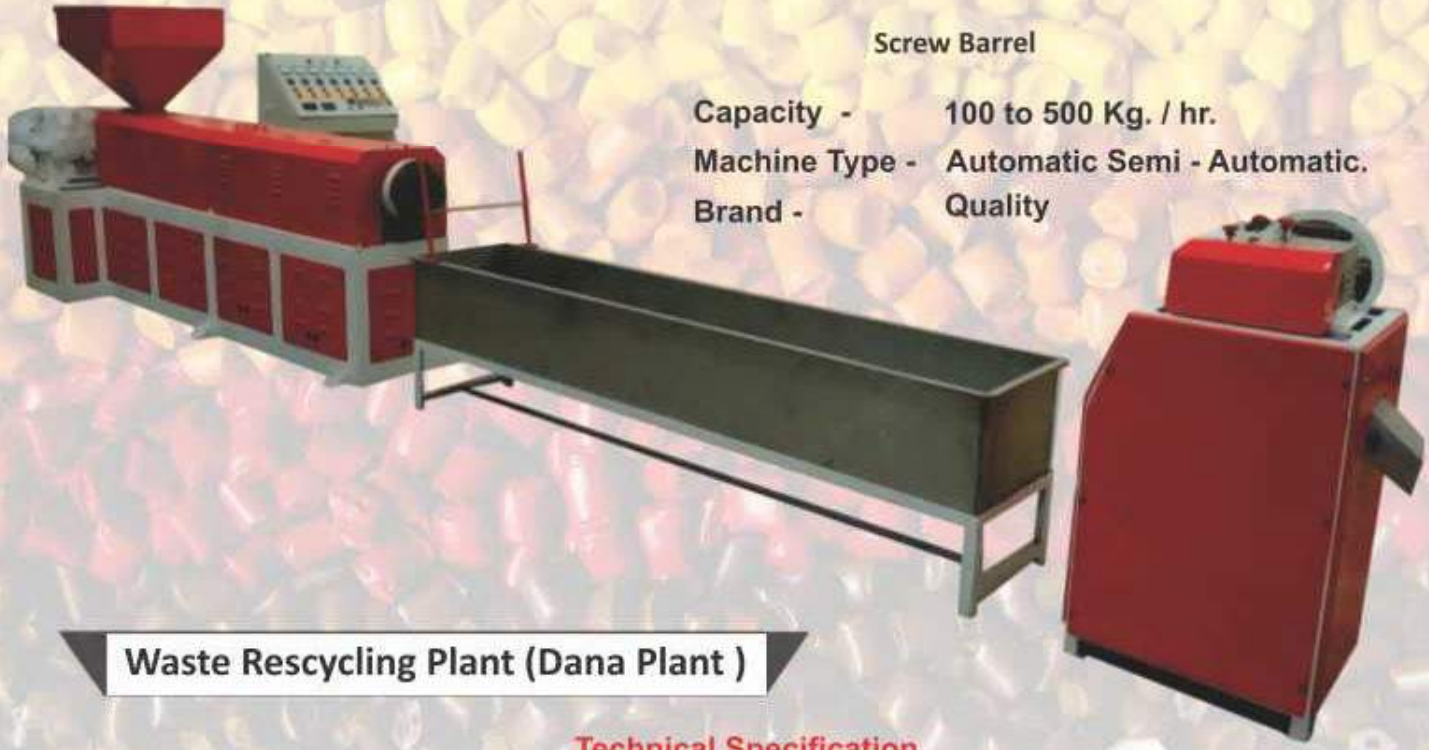

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Plastic Injection Molding: Improved Part Quality And Considerable Cost Savings Result With Mixing Nozzles

It is well known that static mixers – so called mixing nozzles help to avoid color streaks in injection molding. Less known is the fact that mixing nozzles can be used to solve many other quality problems, improve the process stability and reduce production costs. This article provides an overview about the opportunities and what is important:

Installation and how it works

In the screw of an injection molding machine the plastic material will be melted and additives such as masterbatch will be mixed with the melt. Screw design and control systems have been improved over the last several years in order to optimize and fasten this process as much as possible.

However due to the fact that injection molding is a discontinuous process the residence time of the melt in the screw barrel is uneven. In addition, the screw barrel has to be heavily heated from outside in order to melt the plastic as fast as possible. These two effects lead to uneven temperatures in the melt both over the cross section as well as over the whole injection stroke. Uneven temperatures also create uneven melt viscosity and uneven melt velocities. These are prime reasons for using a mixing nozzle as shown in figure 1. The static mixer, when integrated into the nozzle of the injection molding machine, will homogenize temperature, viscosity and flow velocity over the whole injection cycle. Figure 2. shows the temperature deviation over a whole injection stroke with a standard injection nozzle as well as with a Promix mixing nozzle.

Quality problems that can be solved with a mixing nozzle

Many quality problems in injection molding have their source in the uneven temperature, viscosity and velocity of the melt. As a consequence an improved homogenization of these parameters help to improve mass tolerances and avoid undesirable effects like dull or brilliant surface areas. Weak areas affecting the strength of the plastic part created by flow lines can be reduced significantly. Figure 3. shows an early collapse of an outlet area of a cartridge that could be eliminated by the use of a Promix mixing nozzle. It is already well known that mixing nozzles effectively avoid color streaks due to improved mixing. Figure 4 shows colour streaks spreading from the injection point of a molded part that could be significantly reduced by the use of a Promix mixing nozzle. A mixing nozzle is an efficient problem solver, and the injection molding process can be improved in many ways that also bring significant cost savings.

Saving of masterbatch costs

More and more processors today are using direct coloring with masterbatch or liquid colors to

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Plastic Injection Molding: Improved Part Quality And Considerable Cost Savings Result With Mixing Nozzles

reduce raw material costs and to increase production flexibility. However, it's not always easy to get constant and even color shades because the result will be affected by the process conditions of melt temperature, back-pressure, screw speed and the color dispensing device. An accurate and constant gravimetric or volumetric color dispensing system in combination with a mixing nozzle is the perfect solution for this challenge.

The mixing nozzle assures that a constant and even color shade can be achieved independent from the injection moulding machine type and the processing parameters. In addition, the consumption of masterbatch and liquid colors can typically be reduced by 15 to 25% depending on the color type and application. This is due to the efficient breaking down of color pigment agglomerates and the homogenized distribution of the pigment particles.

Improved energy efficiency and shorter cycle time:

Depending on the type of polymer and the type of molded part, the melt temperature can often be reduced when using a static mixer because of

its ability to reduce deviation of melt temperature. A possible reduction of 10 °C increases the energy efficiency significantly and results in shorter cooling times, which, depending on the molded part, can be a significant part of the whole cycle time. A producer of a 2.5 kg PP-container could for example reduce the cycle time from 120 to 110 sec based on a reduced melt temperature.

Mixing screw versus static mixer

Color streak issues can be reduced by the increase of the back-pressure of the injection molding machine and the use of an increased quantity of masterbatch. However, it is obvious that this approach is not economic and will lead to higher masterbatch costs and, depending on the polymer type, to reduced life of the plasticizing screw. Can a color streak problem be solved with a special mixing screw? To a certain extent yes, but at the same time there are some significant disadvantages in comparison to a well-designed static mixer. The mixing performance of a mixing screw depends on the screw drive as well as on the back pressure. Destroying of color agglomerates, despite very high local shear rates in a because

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Plastic Injection Molding: Improved Part Quality And Considerable Cost Savings Result With Mixing Nozzles

the shear impact is uneven and therefore ineffective. Using part of the screw length for mixing tasks is always a compromise because less length for plasticizing will be available. Last but not least, the installation of a mixing nozzle is much faster and more cost efficient compared to the installation of a new screw.

Mixer geometry and a correct design are essential:

There are examples of when a mixing nozzle cannot help to improve the process: A mixing nozzle cannot compensate for a poor uneven masterbatch dispensing system. Correct design and sizing of the mixing nozzle is essential to obtain the maximum benefit. The size of the injection molding machine, the clamping force, and the type of polymer all have an important impact on the design of a mixing nozzle. A poor mixer design or wrong mixer geometry is solving the problem only partly or not at all. In addition, the pressure drop can be too high or the polymer can build deposits inside the mixer and start to decompose. A well designed mixer should not add more than 10 to 15% pressure drop to the injection pressure.

Also, the mixer geometry has an important influence on the performance. A very effective mixing over the whole cross section in a very short installation length and with minimal pressure drop is required in order to get a satisfying result. A single mixer geometry will not provide the same result for all process applications. An incorrect mixing geometry or design can lead to poor results that will often be interpreted as a general problem of mixing nozzles.

Cleaning of mixing nozzles

It is perceived by some that static mixers tend to build up deposits and that cleaning the mixers will be difficult. The opposite is true when the mixing geometry, housing tolerances and installation of the nozzle assembly are applied correctly. In general, a well-designed mixing nozzle does not have to be removed and dismantled for cleaning. The cleaning can be done in line with new polymer purging out the material in the mixer.

Figure 5. above, shows the results of inline cleaning tests with a Promix mixing nozzle demonstrating that a cleaning volume of only 3 times the mixer volume is enough to completely clean the mixing nozzle. This is much less then for example the cleaning of an empty pipe section or the cleaning of the plasticizing screw.

Steel quality is important

The mechanical stress impacting a static mixer during the injection cycle is enormous. The static mixer has to withstand on-going, alternating pressure drop loads of up to 100 bar (approx. 1500 psig). This can only be accomplished with static mixers made quality, correctly designed and applied static mixer will last several years.

There's much value in store in e-waste

Estimated at over $3 billion annually, the sector has the potential to generate up to 300,000 jobs in

Bernd Kopacek

In recent years, the waste from electrical and electronic equipment, also referred to as WEEE or e-waste, has become an important focus of legislators globally. This can be attributed principally to two reasons: the hazardous nature of this waste component, both in terms of the health of the citizens and the environment, and the possibility of deriving valuable materials like precious, critical and base metals from the e-waste.

Moreover, among all urban solid waste, e-waste is the fastest growing waste stream ('UNEP 2007 E-waste Inventory Assessment Manual Volume I'), and this trend is expected to continue, in line with advancements in the quality and quantity of technology products' consumption globally. Such multifaceted characterisation makes handling of e-waste very challenging to address, especially considering the political, social and environmental factors involved in both developed and developing countries.

Despite the effort to avoid a copy-paste approach amongst the parties concerned, most governments, like India, followed the Extended Producer Responsibility (EPR) principle, when the discussion turned to the crucial issue of financing the development of sound e-waste management systems due to low or absent investment capacity.

The sustainable management of e-waste (average of the all products and including all logistics and treatment costs) is not a profitable business at the moment and, therefore, additional money is required to avoid "cherry picking" (processing only profitable products) or compromising the quality of recycling. In Europe, where the e-waste legislation was enacted 15 years ago, all producers joined forces in PROs (producer responsibility organisations) to enable economies of scale for the sound collection and recycling of

Untapped opportunity

In the past 15 years, since the enactment of the e-waste legislation in Europe, the e-waste sector has shown that proper e-waste management is good for the environment and essential for a sustainable economy. The 1.8 million tonnes of e-waste produced in India this year has the potential to generate up to 300,000 jobs, provided a new sector, valued at over $3 billion annually, is established.

In addition, many more jobs can be secured in the production sector because recycling precious and critical metals is the basis for manufacturing new products in the country, especially since resources are becoming scarce and more expensive. In Europe, our hi-tech wastes are already called the "urban mine".

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There's much value in store in e-waste

To develop a prosperous market, it is necessary for products that are not being used or repaired to reach proper recycling facilities. Currently, the informal sector dominates the e-waste sector in India, using manual dismantling and crude, low quality (or non-existent) processing technology.

However, India's khabadiwalas provide a much better collection service to its citizens as compared to Europe (we have to bring our e-waste to municipal collection centres ourselves), leading to a higher collection rate of e-waste in India. This service must be strengthened by formalising the collectors and converting the informal processors into formalised dismantlers. India's large size requires a decentralised approach to recycling; this may even entail small mobile units travelling from dismantler to dismantler and performing the recycling on site.

Considering the challenges associated with the attitude, capacity, and capabilities of some formal recyclers in India, strong enforcement by government institutions is very important. Simultaneously, several producers and importers of electrical

and electronic equipment who are obliged by law to take over the responsibility for the products at the end-of-life stage have adopted a "wait and see" approach by attempting to avert their financing obligation. While enforcement is required to tackle these issues, a balance must be struck and regulators must take care not to over-regulate the market which could hinder healthy growth of the e-waste sector.

There is a critical need for all stakeholders to join hands to make this possible. Private households, small businesses, bulk consumers and public institutions must dispose of their obsolete equipment responsibly, dismantlers and recyclers must adopt the zero-waste approach and producers (and importers) must contribute their share by taking over the financial responsibility for responsible collection and treatment of e-waste while also improving the design of their new products to enable longer life of products and easier repair, and recycling.

A lot of our jobs in the future depend directly or indirectly on the resources that we can save or recover today.

The author is International Consultant, International Finance Corporation.

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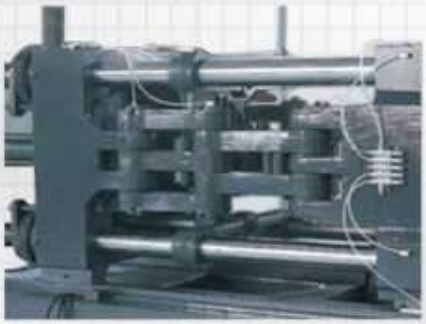

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Plastic recycling advantages and disadvantages

that harm to the environment, A lot of the waste materials thrown in the landfills all over the world are composed of non-biodegradable products that take a long time to decompose.

Plastic Recycling can help you save the money, There are companies that pay cash for your trash, patronizing the recycled products saves your money because they are less expensive.

Plastic Recycling can reduce the need for the allied activities such as the transportation and mining which are the biggest producers of the greenhouse gases and the pollution.

Plastic recycling disadvantages

Plastic recycling can be harmful to the environment, When the material is melted down, VOCs are released into the atmosphere, They are harmful to nearby plant and animal life.

VOCs (volatile organic compounds) released from plastic recycling harm the environment, They present health risks to the people who use the recycled plastic, Plastic resin is manufactured from the petroleum and it can leech into the foods that are stored in the recycled plastic containers.

The heat is required to melt the plastic, the process generates carbon emissions, The harmful greenhouse gases contribute to the global warming and they are already taking an effect on our planet's climate, As the plastic carries the potential health threats, much of recycled plastic will be less useful product.

After the plastic has been recycled once, it is very rarely suitable for the second round of recycling, So, the material will end up in the waste, If the plastic recycling continues in this way then the manufacturers will always have the same demand for new material.

Plastic Recycling tons of garbage will require separate factories, This could result in more pollution and energy consumption to clean, sort, store and transport the waste materials, The need for extra bins for different kinds of trash will be needed, This can equate to more trucks to pick them up, increasing the air pollution.

Plastic Recycling will produce the pollutants, including the chemical stews after breaking down the waste materials, It can hurt the environment, if not planned well, Recycling is not always cost-efficient and it can result in net loss year after year.

Plastic Recycling can increase low quality jobs, These include sorting the garbage, cleaning toxins and doing the other manual and the intensive labor, This can result in low morale, low income and poor quality of life in the community.

Plastic Recycling can create more environmental problems, if not done right, recycling companies might abandon dump sites and leave the .

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Plastic recycling advantages and disadvantages

that harm to the environment, A lot of the waste materials thrown in the landfills all over the world are composed of non-biodegradable products that take a long time to decompose.

Plastic Recycling can help you save the money, There are companies that pay cash for your trash, patronizing the recycled products saves your money because they are less expensive.

Plastic Recycling can reduce the need for the allied activities such as the transportation and mining which are the biggest producers of the greenhouse gases and the pollution.

Plastic recycling disadvantages

Plastic recycling can be harmful to the environment, When the material is melted down, VOCs are released into the atmosphere, They are harmful to nearby plant and animal life.

VOCs (volatile organic compounds) released from plastic recycling harm the environment, They present health risks to the people who use the recycled plastic, Plastic resin is manufactured from the petroleum and it can leech into the foods that are stored in the recycled plastic containers.

The heat is required to melt the plastic, the process generates carbon emissions, The harmful greenhouse gases contribute to the global warming and they are already taking an effect on our planet's climate, As the plastic carries the potential health threats, much of recycled plastic will be less useful product.

After the plastic has been recycled once, it is very rarely suitable for the second round of recycling, So, the material will end up in the waste, If the plastic recycling continues in this way then the manufacturers will always have the same demand for new material.

Plastic Recycling tons of garbage will require separate factories, This could result in more pollution and energy consumption to clean, sort, store and transport the waste materials, The need for extra bins for different kinds of trash will be needed, This can equate to more trucks to pick them up, increasing the air pollution.

Plastic Recycling will produce the pollutants, including the chemical stews after breaking down the waste materials, It can hurt the environment, if not planned well, Recycling is not always cost-efficient and it can result in net loss year after year.

Plastic Recycling can increase low quality jobs, These include sorting the garbage, cleaning toxins and doing the other manual and the intensive labor, This can result in low morale, low income and poor quality of life in the community.

Plastic Recycling can create more environmental problems, if not done right, recycling companies might abandon dump sites and leave the .

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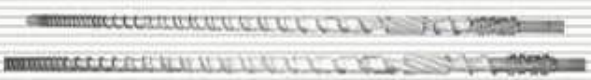

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India says no to plastic pollution

Introduction

The 2018 World Environment Day was momentous for India as the country was the global host and joined the league of the nations which hosted this prestigious event before.

With "Beat Plastic Pollution" as the theme for this day, India went big with an announcement to wipe out all the single-use plastics from the country by 2022. This announcement gave an extension to the activities carried on by millions of Indians like policymakers, celebrities, business magnates and small entrepreneurs, innovators, environmentalist, and activists against plastic pollution around the country.

Prime Minister Narendra Modi applauded World Environment Day as an outset of a global movement to overthrow single-use plastics which will contribute to the country's rapid economic development. This exceptional and ambitious action against the disposable plastic will drastically curb the flow of plastics from 130 crore people and businesses in the fastest growing economy in the world.

Pan-India Initiatives on plastic pollution

Several pan-India initiatives will be launched to fight plastic pollution like clean-up drives of public spaces, national reserves, forests, and beaches. These initiatives also include making 100 monuments across the country into plastic and litter-free zones. Even the Tourism Ministry will contribute their lot to the cause by vowing to avoid plastic straws at public places.

Nevertheless, many developmental measures have already been initiated by various states across the country to lower their plastic consumption and handle the existing waste across their jurisdiction. These actions serve as perfect examples and can be adopted by other states as well.

Below are some initiatives adopted by the municipalities, the state administration and the common public to tackle the plastic crises at their own level across the country.

1. Use of recyclables in government offices in Kerala

Many government offices in Kerala are contributing in their own way towards the Beat Plastic Pollution initiative of the government to make India plastic free. The employees in these offices have shifted from using plastic-made items like plastic water bottles and disposable teacups to steel cutlery, and from pens made of plastic to pens made of steel.

This action of the government offices was mooted by the Suchitwa Mission and Haritha Keralam Mission, which aimed at making the government departments an example of a clean environment. This step can also be easily implied in corporate and private organizations while paving the way for an environment-friendly work culture.

2. Extracting of plastic waste from water bodies in Kerala

Continues On Page No.: 72

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Continues From Page No.: 68

India says no to plastic pollution

It's really sad that the marine creatures are paying the price of our callousness and impotence to handle the plastic waste. It becomes very depressing when multiple reports highlighting the dead bodies of the marine animals found on the seashores, with plastic waste inside their tummies.

To handle this grave situation, Kerala's Suchitwa Mission has launched an excellent project in which 28 fishermen have been employed from the Neendakara harbor in not just finding the fishes but also extracting the plastic from the water bodies that either gets stuck in the fishing nets or float on the sea. The Mission has managed to retrieve 25 tonnes of plastic waste in last 10 months of the project launch.

3. Tackling plastic use in Sikkim

Sikkim has always been at the forefront when it comes to tackling the plastic pollution. Its success in restricting usage and sale of plastic bags is an example for the other states to learn from. This success is not achieved by Sikkim by just imposing random fines on the plastic use, but by making people aware of the dangers caused by plastics. In 1998, it became the first Indian state to ban disposable plastic bags and single-use plastic bottles.

The Sikkim government took two bigger decisions in 2016. Firstly, it targeted the government offices for imposing a ban on the use of packaged drinking water on its premises to reduce an unnecessary burden on the dump yards. Secondly, it completely banned the consumption of Styrofoam and thermocol disposable plates and cutlery in the entire state in order to reduce harmful effects of the plastic pollution and tackle its ever-increasing garbage problem.

Ever since 2005, the state has been engaged in conducting significant campaigns to spread awareness among people about the harms imposed by plastic on the environment. Similar success stories have emerged out of Nainital and Jaipur, where shopkeepers have begun to use chargeable cloth bags instead of plastic ones.

4. Utilising plastic for road surfacing

Due to the plausible efforts of Professor Rajagopalan Vasudevan of the Thiagarajar College of Engineering in Madurai, the road surfacing using plastics is now a reality. The plastic which is banned and considered a waste can now be utilized in flagging off development projects across the country. Many states in India are planning to implement this pioneering technique to manage their plastic waste. The states of Kerala, Maharashtra, and Tamil Nadu have already started to work on this unique technique.

5. Recycling plastic for better purposes

It is an impossible task to dispose of such huge amounts of plastic waste generated in India at one go. The only option available is to use this plastic

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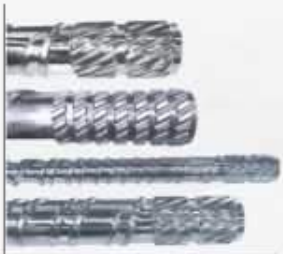

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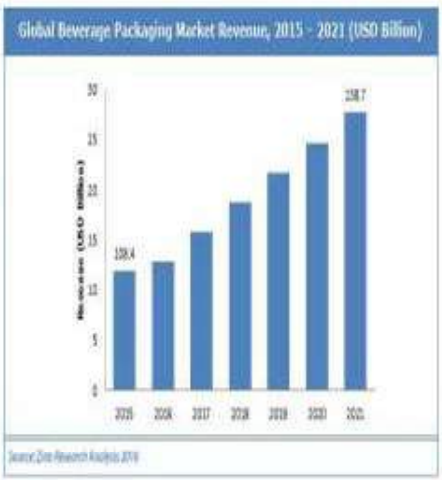
Investment promotion programs in India, focus on growth sectors in China drive global demand for polymer fillers

High-quality optical properties, improved impact strength, and ability to replace expensive plastic resins make it the preferred material for various applications. Polymer fillers provide industries with immense development opportunities of newer materials, which have enhanced properties and improved molding properties, thus driving the market growth. The global polymer filler market has experienced a remarkable growth over the past decade is expected to continue growing well. The polymer fillers market size is estimated to reach US$53.10 bln by 2020 at a CAGR of 3.3% between 2015 and 2020, as per Markets and Markets. The growing popularity of polymer fillers in various types plays a significant role in driving the market. Salts, silicates, oxides, and hydro-oxides are its most important types. The rising demand for low-cost fillers in countries, such as China, and India, is projected to increase their demand in the coming years. The Indian government has started investment promotion programs to assist companies that are developing and



manufacturing salts, oxides, and silicates pushing the growth of this market upward. The Chinese government is focusing on the growing manufacturing sector that is driving the consumption of plastics-related products, domestically and hence increase the demand for polymer fillers in the Asia-Pacific region.

Asia-Pacific was the largest and North America was the second-largest market for polymer fillers in 2014. Asia-Pacific also registered the highest growth rate between 2015 and 2020. Innovations, developments, and demand in the consumer industries for better products are directly affecting the rise in the use of polymer fillers. The excessive growth and innovation, along with industry consolidations, are projected to ascertain a bright future for the industry in the region. The high demand in Asia-Pacific is due to growth in the building & construction as well as packaging industries in the last few years. There is an increase in the use of polymer fillers for building & construction, packaging, and automotive industries in Asia-Pacific due to the continued industrialization and rise in the manufacturing sector of the region.

The global Polymer Filler Market is expected to reach US$62.54 bln by 2024, according to a report by Grand View Research, Inc. The surge in demand for low-density fillers with better impact strength is likely to propel the market growth. Polymer fillers are likely to emerge as a cheaper alternative to costly plastic resins over the forecast period. Increasing demand for low-cost fillers from various end-use industries in both developed and emerging countries such as the U.S., Germany, India, China, etc. is expected to propel the market growth. Stringent regulations pertaining to automotive pollution has forced automotive manufacturers in the U.S. and Europe to use lightweight materials for manufacturing. Development of novel low-density fillers is expected to propel the market growth. Inorganic fillers were the leading product segment and accounted for 78.9% of total market volume in 2015. However, organic fillers are expected to witness a brisk growth of 5.6% over the forecast period. Increasing environmental concerns have attracted more industries to opt for organic filers rather than traditional inorganic fillers. Abundant availability along with renewable nature of the natural fibers such as wood, cellulose, etc. is also expected to have a positive impact on the market growth.

Continues On Page No.: 90

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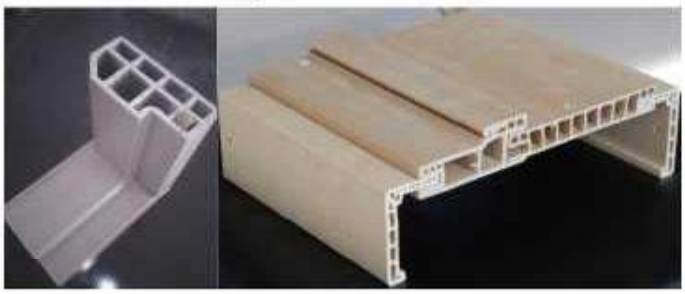
Cost, Process, time, after effects and

maintenance, color varnish &
maintenance issues, strength and
durability, weather's effect, to get rid of such issues, Wooden Door-frame material is being replaced
mainly by Plastic for which PVC is proposed as comparatively lighter material. {PP/ HDPE are heavier}
In fact such material saves time of Carpentry and money on process, and is easier to install as well.
Technically such frames should be made at 0.9 GCC density. India ideally uses the sizes of 5" x 4", 4"x3"
and so on.
BUT one most unfortunate character is, we need Solid frames, People feel and assume that solid frames
can offer strength. Tis mental block still makes our frames costlier and unnecessarily heavier. Whereas
CHINA and others use hollow sections as below.
Understand the figures for the project:



•The investment in the project can be:
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The Author, Mr. Kamal Shah, is Ahmedabad based consultant, assisting to set up Lucrative and new
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Earlier only wood, now is replaced by plastic + Wood +CaCO3.

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Small investment Business. PVC wall and ceiling profile making. Made

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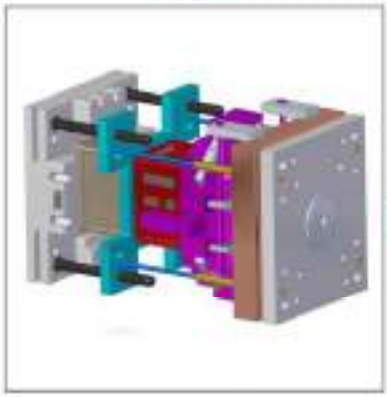
- Unscrewing Moulds
- Core Pulling System Moulds
- Side Core Moving System
- Hot Runner Moulds
- Blow Moulds
- Investment Castings Dies
- Jigs & Fixtures


Carat


Carat Mould

All types of Plastics Injection moulds, Blow Moulds, Investment Die castings, Jigs & fixtures manufacturing works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Eleptical Tub


Eleptical Tub Mould


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Best Opportunities for the new and lucrative projects for INDIA.

Made from PVC +CaCO3 and is a replacement to artificial wall and ceiling of wood and many other traditional material.

Sanitary Napkin: The best possible business for the day. Tis product is made from WOOD + paper + Plastics and please be informed that by weight, about 26% of the Napkin is made from Plastics!

High investment, HIGH Volume business.

FLEX banner making, again is a big and huge business. Just 9 companies in INDIA So far and much is imported at India ports each month regularly to cater to the INDIAN demand. High Investment, Huge Quantity Business. The Banner Fabric too is as high as 50% CaCO3 made product with PVC and additives.

Though, honestly, there must be a proportion as to how much we should add CaCO3 to make any product from plastic. BUT most of us do not bother and use as much as we can to make unethical money and to fight cheap competition. Not good.

Again, India is unfortunate country with so-called democracy. We have unfortunate freedom to speak and to do whatever we feel like, which is an issue and the democracy is a curse on us. So-called environmentalists, people without much of productive business, come forward at times (till they are fed enough money by the industrialists to keep quiet), cry against plastics but note that we are not like Germans who find alternate ways and also can manage to do away without the things at times, we are slaves of the needs and the cheap products. AND SO WE NEED AND WE SHALL ALWAYS NEED THE PLASTICS and PLASTIC-MADE products for always, BUT blessing for the industrialists are the opportunities so offered by such needs. SO HAPPILY MAKE MONEY. GOOD LUCK.

JAI HIND!

KAMAL SHAH. Ahmedabad

Mobile : 9624112091 / 9879552875

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Website

Save wood, protect forests

The world is changing fast and for the better tomorrow. There is one more product to assist the goal
to avoiding deforestation.
Like people started replacing wooden plywood with PVC plywood, now the laminates made with paper and polluting formaldehyde is also being replaced by PVC +CaCO3 made laminate.
The benefits are:

o Saves trees
o Saves lot of water
o Can be folded many number of times
o Water-proof, Maintenance-free, termite-proof,
o Easiest and most economic to manufacture.
o Can be made in thicknesses like, 1.2 mm /1mm / 0.9 mm /0.8 mm / 0.72 mm
Important data:
And so even smaller individual entrepreneurs can enter in to this business.

Project costs: Rs.	
Machinery Landed cost in INDIA.	17500000
Land 2 acres	7000000
Building 7000 Square foot	7000000
EB cost and all Utilities	3500000
Installation and commissioning	300000
Consultant's cost	500000
Total initial investment.	3,58,00,000

In INDIA some traditional laminate manufacturers have started entering in to such business already.
Not only unorganized sector but organized sector product manufacturers also are eying this business.
Now note most important data on this business which is true guide to go in for this business.

Assume that working only for 300 days and not 312 days		1518895353.4	300 days and 20 hours
Assume further that work for 18 hours / day and not 20 Hours		1367058818.1	300 days and 18 hours
Assume losses / wastage of overall 10%		1230352363	wastage at 10 %

KAMAL SHAH. Ahmedabad
Mobile : 9624112091 / 9879552875
mail@positiveaggression.in

PVC Laminate making business.		Realization value is : ONE	
Cost per sheet works out to be Rs	715.12	1213	
Profit per sheet is		497.8791676	
Assuming production of just 300 Kg per hour			
No of sheets made per hour	50.847		
Profit per Hour works out to be		25315.89224	
NO of sheets made per year can be	317288		
Profit per year can be		157971167.6	312 days and 20 hours/ day

The author is a consultant based at Ahmedabad assisting to set up new projects right from Scratch.
Disclaimer: All the figures and data are collected from Industries from time to time and readers' discretion is advised.

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Lab Hydraulic Press

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Email : sales@rkengineeringworks.com

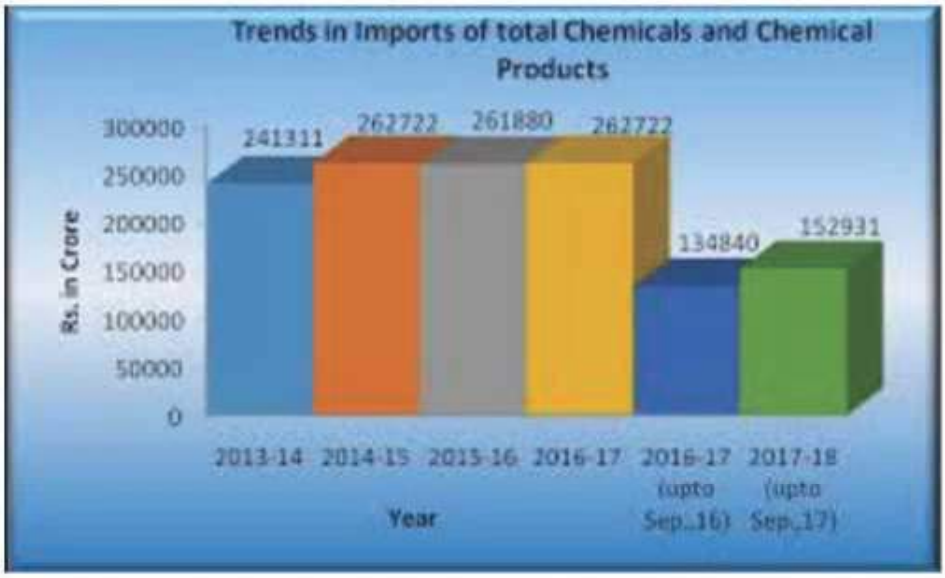
Continues From Page No.: 78

Investment promotion programs in

Further key findings from the report suggest:

*Global Polymer Filler Market demand was 31.75 million tons in 2015 and is expected to reach 49.72 million tons by 2024, growing at CAGR of 5.1% from 2016 to 2024

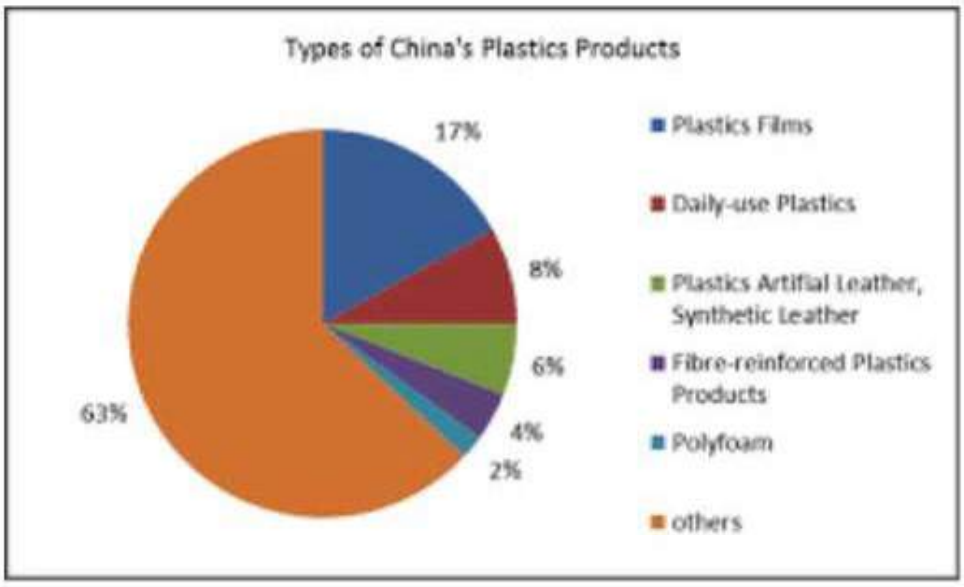
*Automotive and building & construction collectively accounted for over 40% of total market volume in 2015. Increasing demand for high strength plastic composites in all these end-use industries is expected to drive the market growth.



Automotive is also expected to witness the highest growth of 5.9% over the forecast period.

*Asia Pacific emerged dominated the global market with demand share exceeding 45% in 2015. Burgeoning building & construction industry along with favorable governmental regulations in India, China, Indonesia, and Thailand is likely to drive the regional market. Increasing demand for lightweight polymer composites in the U.S. is expected to propel the North American market over the forecast period.

*Key market players include Quarzwerke group, 20 Micron Limited, GCR group, Omya AG, Imerys S.A., Hoffman Minerals, Minerals Technologies, Unimin Corporation, LKAB group.



Global polymer fillers industry is fragmented in nature, and the threat of new entrants is high due to lower initial investment. Despite presence of a large number of market players, the value chain is mainly dominated by end-use industries as most of the polymer composites are manufactured considering the application requirements.

The global market for industrial fillers is forecast to increase from US$29.3 bln in 2014 to US$36 bln in 2019, at a compound annual growth rate (CAGR) of 4.2% for the five-year period. This market growth will be driven by the increasing use of polymers in the construction, automotive, electronics and packaging industries, according to BCC Research. The study expects carbon black fillers to have the highest growth prospects over the forecast period. Increased polymer production in the construction, automotive and packaging industries will drive growth in the global industrial fillers market. BCC Research reveals in its new report that carbon black is expected to have the highest growth prospects over the forecast period. Carbon black is prominently used as reinforcing filler in a variety of rubber products including tires, pipes, hoses and footwear. In addition, it is used in other applications such as films, adhesives, plastics and paints for improving the reinforcement properties of the final product.

Fillers are inexpensive materials added to other base materials such as plastics, rubbers, paper, and concrete to enhance their reinforcement properties. They can replace expensive base materials, thus reducing overall product cost while enhancing the reinforcement properties of plastics, adhesives, sealants, rubbers, paints, concrete, and paper. Favorable government support towards promoting the shale gas industry and petrochemicals production is expected to boost the production of polymers, which should increase the use of fillers, particularly the popularly used filler material, carbon black. "The addition of fillers to a polymer formulation lowers the compound cost or improves properties such as mechanical strength and improvement, "says BCC research analyst Tanmay Joshi. "In addition, increasing demand for plastics from the automotive, building, construction, electronics and packaging industries, coupled with growing consumption of carbon black in plastics, is expected to fuel market demand for plastics over the forecast period."

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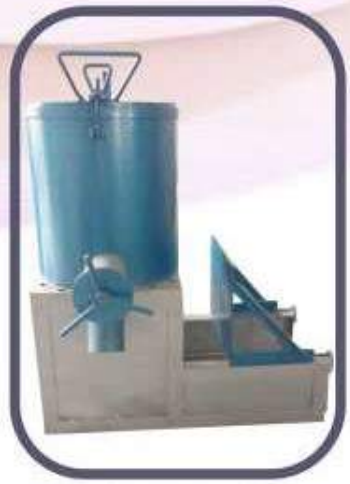

50 Kg High Speed Mixer

24 Pipe Grinder

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'Follow the Plan' When Installing and Commissioning Compounding Lines

A fully operational and documented system doesn't happen by chance. An efficient, well-designed installation plan, prepared well in advance, will put you on the path to maintaining a timeline and budget.

When you are shopping for a line for compounding, devolatilization, reactive and direct extrusion, purchasing the correct equipment is only part of the equation. Not unlike an addition to your house, communication (by providing all relevant specifications) and selecting the right contractors will make all the difference in getting the project completed on time without (or at least with minimal) cost overruns. Local contractors are generally preferable.

You must be prepared to provide detailed specifications and engineering efforts up front to any companies, including machinery suppliers, that offer turnkey solutions. An organized engineering effort is required to provide an accurate turnkey system and installation proposal. A word to the wise: Don't overly rely on third parties.

PREPARATION PHASE

Site preparation and coordination of the many divergent tasks that are required to install and successfully commission equipment is best not left to chance. Even modest advanced planning will yield benefits far beyond the installation and startup phases of a new project.

Before starting, it is highly recommended that the technical and timeline aspects of a project be defined in a written specification. Request-for-quotation and bid documents need to be thoughtfully prepared to facilitate effective communication with vendors and contractors to obtain accurate information on both performance and timeline. Using local and experienced contractors that are familiar with plant personnel and local codes, where possible, generally helps the project's overall efficiency.

The following checklists are intended to serve as a rough guideline for what's needed:

Engineering Documentation:

In-house and vendor drawings prepared in AutoCAD;

Operating manuals for all equipment;

P & ID drawing for entire system;

General arrangement views of entire system, plan and elevation;

Extruder assembly drawing, three views;

Barrel/screw layout (to scale in AutoCAD), elevation view only;

Standard utility requirements: electrical, water, compressed air;

System utility requirements: dust control and any special HVAC requirements;

Wiring diagrams for extruder, feeders, and other auxiliary equipment.

Contractor Documentation:

Sub-vendor mechanical, electrical, and installation drawings;

Floor loading drawing;

System interconnecting cabling drawing;

-Conduit runs;

-Number of conductors;

-Wire type and gauge, etc.;

System interconnecting piping drawing.

Additional Documentation:

Detailed functional specification for PLC logic;

System Input/output list;

Source code for programming;

Bid package preparation for third-party contractors;

Spare-parts lists/pricing for all equipment supplied from bill of materials;

Environmental permit applications, as required.

Factory Acceptance Test (FAT), including:

Visual inspection and identification of system components;

Review of control-panel layout;

Documentation of model numbers, serial numbers, and pertinent specifications of all applicable components;

Continues On Page No.: **96**

Injection
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From 98 to 800 Tone

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Contact person : Yash Rakesh Shah

Continues From Page No.: 94

'Follow the Plan' When Installing and

Confirmation of tagging and labeling;
Heat-zone check-out;
Identification/verification of product contact materials and surface finishes;
Overview and demonstration of power-up procedure;
Verification of temperatures, speeds and other indicated values;
Complete system dry test;
Generation, recording and compilation of FAT documentation.

INSTALLATION PHASE

This is where you find out how prepared you really are. Adequate space, light and administrative assistance may not always be available, but establishing the resources that are available will help ensure a successful completion of a project. Careful planning and implementation are the keys to success, including:

Mechanical:

All workers must have adequate PPE (Personal Protection Equipment). Generally, this includes, as a minimum, safety shoes, safety glasses, a hard hat, and work gloves. Explosion-proof and hazardous materials require special handling and treatment. Set up a "contractor area" and provide multiple copies of all the mechanical and electrical drawings. Require that all responsible parties have access to information as needed.

Create a physical "laydown area" in the plant. This area will be used to lay out the equipment as each skid is unpacked. Keep it separate from where the equipment will be installed, but not too far away. Open cardboard boxes so you can see what's inside. Keep the parts from each supplier together. Take pictures of incoming packages and parts.

Use the general-arrangement drawing to mark the floor with the rough outline in chalk of each major piece of equipment or component.

Carefully consider the order of installation. Generally, start with larger machines and work toward smaller pieces. Remember not to position something large, like the power panel, so that it blocks access to another part of the line. The twin-screw extruder is typically installed after the mezzanine and support structures.

Rigging tip #1: Don't lift a machine any higher than is required, and move very slowly. (Professional riggers never want a lifted load to have any momentum.)

Rigging tip #2: Know the approximate weight of each item before attempting to lift it, and never lift a load over a person (web straps and chains can break).

Don't anchor any machinery to the concrete floor until everything is installed and it's confirmed that all the positions and alignments are correct (an exception may be necessary for some machinery because of its size and weight distribution). Once you are satisfied that all the machinery is in the correct position, anchor the fixed machines to the floor.

Electrical: Review the field wiring specification with the electrical contractor to ensure it follows the provided cabling- and conduit-run instructions. Make note of any exceptions and document each remedy for issues that develop. Review each piece of equipment's wiring diagram with the contractor and confirm the availability of the various types of wire and cables required.

Make sure all power is "locked out/tagged out" while the electrical work is being done. Confirm the on-site procedures. There should be absolutely no way any part of the system can be energized

Think through which machines are fixed and which are moveable. (Example: underwater-pelletizer cart moves on floor tracks.) Make sure flexible cables and appropriate connections are planned. All interconnecting wires/cables should be marked according to the wiring diagram. Changes/corrections should be noted for the as-built configuration..

Do not apply power to the main panel or any other parts of the system until the appropriate technician is on-site and has inspected the installation.

Piping/Plumbing:

As part of preparation, the piping contractor provided a drawing (P&ID) showing all the pipe routings and sizes suited to the expected maximum flow rates. As installation progresses this document is modified accordingly. Discuss with the contractor what material will be used for the various piping runs (black iron, galvanized, stainless steel, PVC, etc.).

Confirm the location of isolation ball valves. Branches of the system will need to be shut off for maintenance. To aid in troubleshooting, consider where pressure or temperature gauges are to be located. Mark all the final information on the P&ID.

As with the electrical contractor, where machines are on tracks or will be moved for maintenance, plan on flexible connections and make a note of any required quick disconnects. If any of the piping will be carrying chilled water, those pipes should be insulated. When finished, label all piping with its purpose and arrows showing the flow direction.

Filling and Checking Fluids:

Confirm that each gearbox in the system is filled with the correct grade of oil. Make a note of the gearboxes that arrive from the factory filled with oil and establish which are sealed and will not require oil changes. (Synthetic oils are now being used and are good for the lifetime of many smaller gearboxes.)

Check to ensure all water-cooling tanks are filled. Sometimes it's best to start with plain city water. If no leaks are apparent, then change to the recommended water with corrosion inhibitors.

Safety Check:

A safety team or OSHA team must evaluate the installation for potential hazards and confirm that issues are being addressed systematically by the site's safety/health program. Categorize concerns as they apply to the relevant regulations and suggest remedies as required. Categories may include:

Walking and working surfaces;
Fire safety;
Hazardous-material storage/handling;
Confined-space entry (vessels and crawl spaces);
Machine guards;
Lock out/tag out;
Electrical (power tools/welding equipment).

START-UP PHASE

Before any production, a preliminary evaluation of the equipment is conducted. This will include the technical documentation (SOP, FAT) as well as operating instructions. Time should be allotted for operator-related modifications to the system.

Installation Qualification:

The first thing the technician should do upon arriving on-site is to inspect the installation work.

Visual inspection and identification of system components;
Verification of all utility connections;
Inspection of electrical devices and corresponding wiring;
Heat-zone check-out;
Overview and demonstration of power-up procedure.

Continues On Page No.: 98

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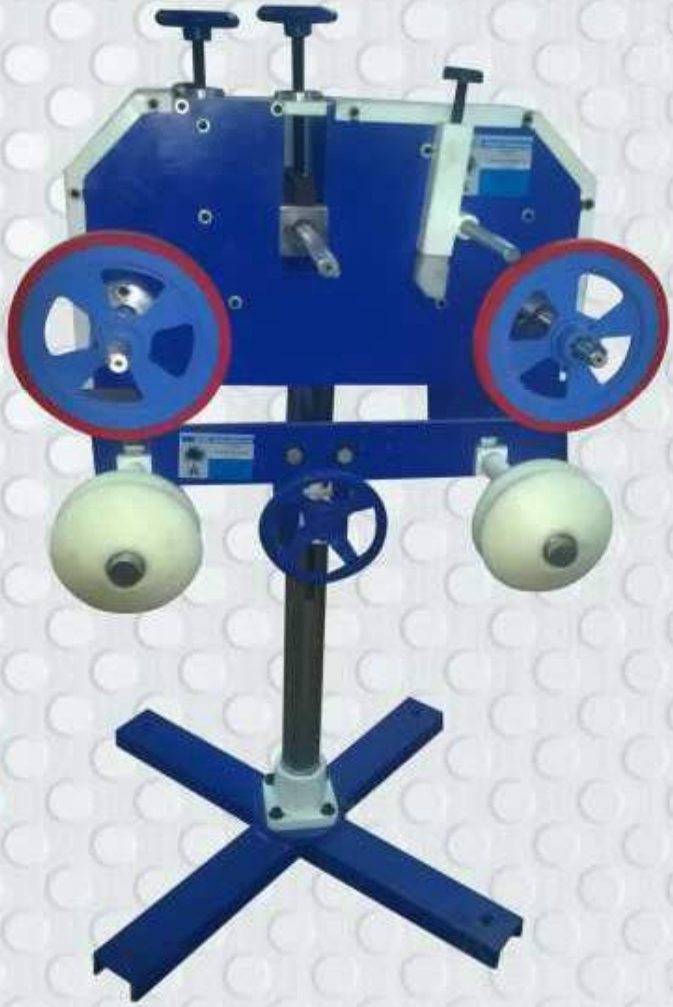

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Without Batch No

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E-mail : spc_utkarsh@yahoo.co.in

Continues From Page No.: 96

'Follow the Plan' When Installing and

The technicians should follow a start-up checklist. Beginning with the machine interlocks, the checklist will include:
Verification of all safety devices and system interlocks;
Verification of temperatures, speeds and other indicated values;
Complete system dry test;
Generation, recording, and compilation of IQ documentation;
Mechanical items related to machinery operation.
It's best to check the functions of the most complicated componentry (PLC/HMI, Emergency Stop, AC variable-speed drives, heat zones, etc.) before simpler items such as single-speed motors and level switches. Some motors need to be tested uncoupled, while most peripheral-system motors are safe to test coupled. It is important to confirm that the motor rotation is correct prior to running the machinery under load.
Material will be required to put an initial load on the extruder. Have plastic on-site, so the technicians can put a load on the extruder when it's ready for an initial test. Run all the machines below 50% load at first, while checking for any abnormal sounds, vibration, fluid leaks, etc. When the technician is confident all is OK, then the system can be run up to higher rates.

Operational Qualification:
Training is the final step in starting up a new system. Once the system is working properly it's time to tackle operator training. It's very difficult to troubleshoot equipment issues while training people at the same time. Operator training is best handled independently after the system is up and running.

Review customer-generated SOPs;
Review equipment and systems manual;
Review FAT and IQ documentation where required;
Equipment operation conformity check-out;
Review the normal value on the gauges, indicators and the zone controllers in a manual/discrete operator interface;
Confirm the initial calibrations and establish a method to collect the data that will be used to maintain an operating baseline;
Review touchscreen/HMI operation:

Access level (operator/engineer/administrator);
Heat-up, interlock/bypass;
Set up screen;
Calibration screens;
Interlocks and alarms;
Startup checklist;
Main screen;
Data logging.
Review the startup procedure:
The main disconnect;
Temperature settings and heat-soak times;
Startup water-cooling systems and lube-oil pumps;
Turn on downstream equipment;
Fill the feeders;
Start the main drive at low speed;
Start the feeders at low rate;
Monitor torque;
Engage the pelletizing equipment;
Ramp up extruder and feeders to appropriate rate;
Increase the pelletizer speed to match rates.
Turn on vacuum pump and/or open valve to the system.

Review how to clear an upset condition and clean/maintain the vacuum pump.
Monitor feed throat for feed limitations.
Discuss various processing tips.

Review the use of the special tools and preventive items to be noted daily, monthly, and annually.
The objective for the installation of any twin-screw extruder system is to plan well, provide an efficient, well-designed installation plan, and maintain a timeline and budget. The end-result is a fully operational and documented system. This doesn't happen by chance. The initial specifications developed during the preparation phase of a project become a "living document." While this up-front work can be tedious and time consuming at the beginning, it ultimately minimizes miscommunications and saves time and money.
Turnkey isn't always turnkey. While the term may be flippantly used to describe the installation, in reality there are many responsible parties that must contribute to ensure that a twin-screw system is operational on time and producing a quality product. No matter what, it'll be a lot of effort.

ABOUT THE AUTHORS:

Bert Elliott has held various manufacturing and engineering positions with extruder OEMs since 1981 and has been Leistritz's engineering manager since 1993. He has been involved in over 1000 extruder installations, including many in the Far East. Contact: (908) 685-2333; belliott@leistritz-extrusion.com; leistritz-extrusion.com.

William L. Novak is the product-area manager for Leistritz Extrusion in Somerville, N.J. His responsibilities include business-development efforts to expand the use of twin-screw extrusion into new areas and applications, as well as regional responsibilities. Previously, he was Coperion's regional service manager. During his tenure at Coperion, Novak held several sales- and engineering-related positions and has more than 27 years of product-development experience. Contact: wnovak@leistritz-extrusion.com.

Charlie Martin is president and general manager of Leistrtiz. Martin has been in the extrusion industry for more than 25 years, is a member and former chair of the SPE Extrusion Div. and has given 100+ papers at various technical conferences on a range of extrusion topics around the world. Contact: cmartin@leistritz-extrusion.com.

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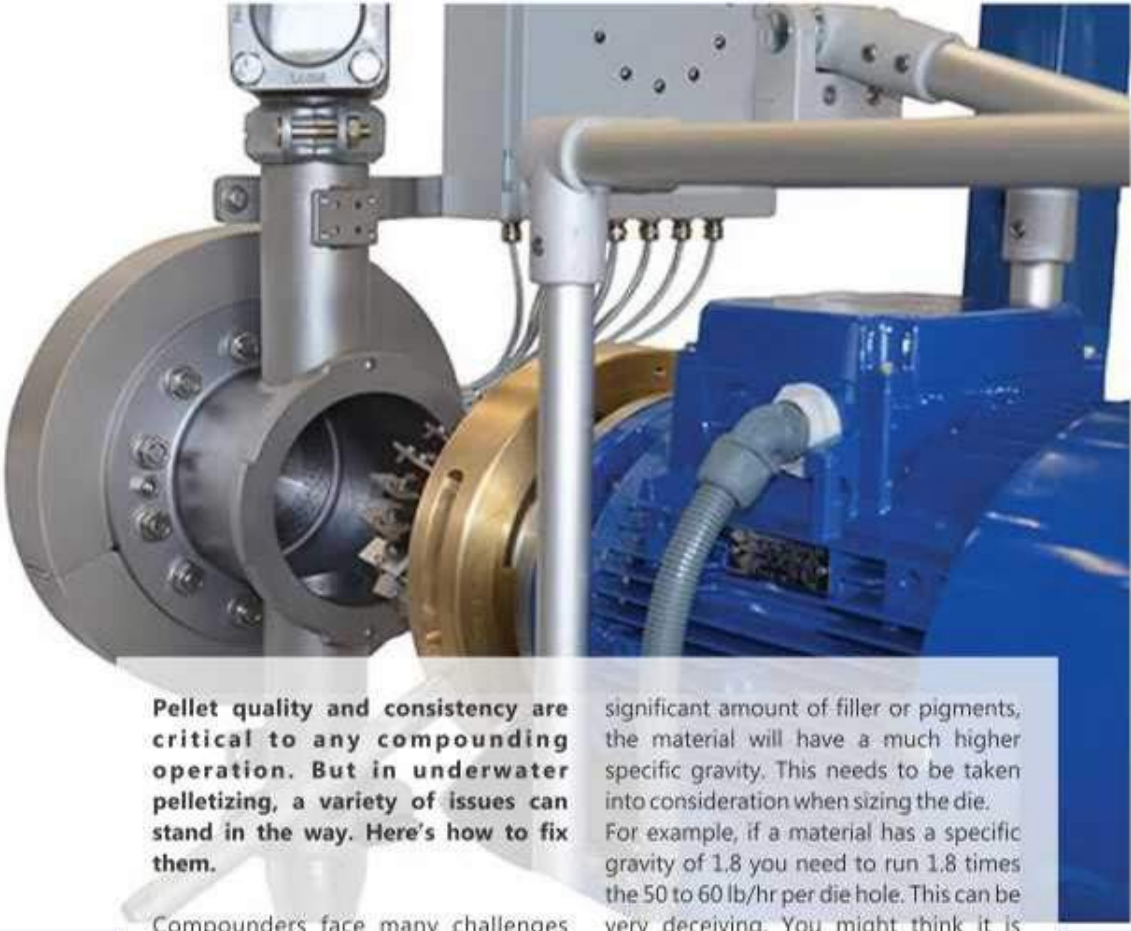

Solving Common Problems in Underwater Pelletizing

by :
Mark Tate from Gala Industries Inc.

Pellet quality and consistency are critical to any compounding operation. But in underwater pelletizing, a variety of issues can stand in the way. Here's how to fix them.

Compounders face many challenges today. Maintaining consistent product quality is critical to success. One of the most common issues with underwater pelletizing is pellet inconsistency. Pellet inconsistency can be caused by improper die selection or sizing or by output fluctuations.

In this article, we will examine several issues that contribute to pellet inconsistency and suggest ways to solve them.

IMPROPER DIE SIZING

In most underwater pelletizing applications, improperly sizing the die can lead to poor polymer flow uniformity across the die-hole cross-section and actual solidification of polymer in the die hole (sometimes referred to as freeze-off). To prevent die freeze, a minimum polymer velocity through the extrusion hole and the correct die temperature must be maintained.

In most cases, 2.5 to 3 ft/sec velocity through the die hole is recommended to to prevent the extrudate from solidifying in the hole. To maintain correct velocity per hole, you must have the correct number of holes in the die plate for the desired production rate.

Let's look at sizing a die using a hole diameter of 0.125 in. (3.2 mm). In order to achieve the recommended velocity you need 50 to 60 lb/hr per die hole (V=0.0002122/R2 x rate per hole in lb/hr). Keep in mind that this is based on a material with specific gravity of 1. In many instances where there is a significant amount of filler or pigments, the material will have a much higher specific gravity. This needs to be taken into consideration when sizing the die.

For example, if a material has a specific gravity of 1.8 you need to run 1.8 times the 50 to 60 lb/hr per die hole. This can be very deceiving. You might think it is necessary to add more holes to the die to reduce the pressure drop across it, when in reality, fewer holes are needed so that all stay "open" while running. There is a calculation to determine if all die holes are open while running. It is as follows:

$X = R \times 7.6 / (W \times S \times N)$ where:

X = Number of open holes
R = Rate in lb/hr
W = Weight in grams per pellet
S = Speed of the pelletizer in RPM
N = Number of blades on the cutter hub

Generally speaking, the velocity of polymer, in addition to the heat it provides at the die plate, must be managed properly to facilitate a cleanly cut pellet. Without this control or understanding, few process settings or engineered devices can provide a full solution to certain process problems causing pellet inconsistency.

IMPROPER DIE TEMPERATURE

This can also contribute to die freeze. In most cases the die temperature should be 25° F higher than the melt temperature of the polymer. This may vary a bit from product to product, but it is a good starting point. The temperature of the die can also be affected by insulation. Most dies are insulated in some form. This is necessary to isolate all but the cutting face from contact with the process water to prevent the die from losing heat.

Continues On Page No.: 102

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This insulation is usually sealed with a high-temperature, room-temperature-vulcanizing (RTV) silicone, and you need to be aware of the temperature ratings. Sealant degrades over time and at elevated temperatures, which allows water to seep into the insulation and bring the die temperature down. For example, suppose the die temperature drops significantly from setpoint at startup and the control system is calling for heat, but the die struggles or never comes back up to the original die heat setpoint. This is a very good indication that the die plate insulation has degraded, is missing, or is improperly installed.

Check the amount of power the die is using. Many control systems are equipped with an ammeter on each die heat zone. Calculate the amp draw required for each heat zone then compare with the actual reading. If the reading is less than optimum, one or more heaters have likely failed.

DIE-HOLE BLOCKAGE

Inconsistent pellets can be caused by physical blockage of the die holes from contaminants in the material or from mineral fillers not dispersed well in the matrix. In most cases a screen changer or some type of filtration prior to the die is desirable. On

mproper die sizing can cause a variety of pellet-quality problems in underwater pelletizing. Pictured here is Gala's Model 7 EAC Pelletizer showing the cutter hub and the cutting chamber, with a bit of the downstream side of the die visible

smaller systems this type of blockage can be removed from the die hole using a special hand-cleaning tool. On larger systems the die is usually removed for cleaning. It is also advisable to reduce temperature profiles, including the die heat zone, during prolonged periods of idle time.

Up to this point we have talked about cause and effect on the underwater pelletizer itself, but there can be several factors in the process that may lead to inconsistent pellet sizes. Feedstock bridging in the hopper can reduce the flow of material into the extruder. Depending on the product being processed, this can result in inconsistent pellets or may cause die freeze.

Improper extruder temperature settings can cause surging in the extruder, causing pellets sizes to vary. This can also lead to a melt temperature that is too high, which may not necessarily cause inconsistent pellet sizes, but can cause pellet deformity.

FINES AND TAILS ON THE PELLETS

This problem can be attributed to a number of factors; however, it is typically caused by die and/or blade wear. If the die-plate cutting face becomes grooved, it is not possible for even a new and sharp blade to cut the polymer cleanly. At the point of the cut, a small amount of the material is pulled through that groove, resulting in a tail on the pellet. The same thing can be said of a blade that is grooved and operating on a new die face. This highlights the importance of choosing the correct—and compatible—materials of construction for the die face and blades. Using a blade that is too hard may give you a little longer blade life in the short term but can accelerate wear on the die face.

Other possible causes for tails are excessive melt temperature, die alignment out of tolerance, mechanical wear issues on pelletizer bearings resulting in excessive shaft run-out, or process water that is too hot.

It must also be emphasized that without maintaining proper polymer velocity through the die-plate extrusion holes, an exaggerated flow gradient exists within the die hole, causing a sleeving effect. This creates an undesirable polymer shoulder against which the blade will struggle for a clean cut.

As the pellet goes through a centrifugal dryer, the tail breaks off, resulting in fines. This can cause problems in material-handling systems as well high residual moisture on the pellets. Fines can stick to the dryer screens, reducing the open area and air flow through the screens.

Fines are not the only possible cause for higher than desired residual moisture content on the finished pellet. Other causes include melt fracture (or "shark skinning"), a pellet that is porous due to high loadings of filler or fibrous material, irregular pellet shape, as well as operating or environmental parameters.

Melt fracture produces a very rough surface on the pellets, providing numerous places to trap water as the pellet travels through the centrifugal dryer. This rough surface presents itself on the side wall of the pellet and generally not on the cut ends. One way to minimize melt fracture is to cut the pellet a little thinner, thereby reducing the sidewall area. Keep in mind this does increase the total surface area. Another way to minimize melt fracture is to reduce the velocity through the die holes, in addition to polishing or extrude-honing the dies.

High levels of mineral filler can produce a porous pellet that can be very difficult to dry. This porosity allows water into the voids, which can be very difficult to remove by centrifugal action alone. Fiber fillers such as glass or wood act like a wick to draw moisture into the pellet, making it almost impossible to dry mechanically, so post-drying may be required.

Since centrifugal dryers operate on three basic principles—residual heat in the pellet, centrifugal action, and countercurrent ambient air flow—proper operating parameters must be established. For example, if the process-water temperature is too low, the resulting pellet temperature will be too low to flash off sufficient surface moisture. On the other hand, if the water temperature is too high, tails may be generated. Countercurrent air flow through the dryer is very important to reduce surface moisture levels. It should be checked and adjusted to the manufacture's specifications.

Environmental conditions can play a significant role in the reduction of pellet surface moisture. For a process line located in a very humid area and processing a melt-fractured or porous pellets, one would expect very low pellet-moisture levels will be difficult to obtain. Also, if running a product that is very sticky and requires very cold water, and the pellet is exiting the dryer at a temperature below the current dewpoint, then even though the pellet may be dry as it exits the dryer, condensate will form, resulting in higher moisture content when it is packaged.

These are some of the common issues that are faced by operators of underwater pelletizing systems. Proper understanding of cause and effect can in most cases eliminate these problems. If you find yourself faced with some of these problems, contact your underwater pelletizer manufacturer to help improve your process.

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TOOLING: Balancing the Heat Budget In Injection Molds

by :
Philip Burger from Burger & Brown Engineering

Basic formulas for how much heat you must pull out of the mold to achieve a set cycle time

There are several reasons to be interested in the flow of energy into and out of injection molds. This balance of energy flow (the heat budget) is the basis for determining sufficiency of cooling circuits in an existing mold and for designing new tooling. This information can also be used to determine required size and capacity for portable and central coolant delivery systems. The following will introduce and explain the polymer science and simple calculations used to determine heat flows and balance the heat budget for any mold.

FIRST, THE PHYSICS

To begin, we will dust off the books and talk a bit about the nature of energy and materials. Many materials can exist in more than one state or phase. We experience this daily with water, which we often see as vapor (clouds and steam), liquid, or solid. To cause a change from one state to another, heat must be added or removed.

It is very interesting that during the phase change the temperature of the material remains constant. We all know water freezes at 32°F and boils at 212°F under standard conditions. The heat added or removed during the phase change is called latent (hidden) heat. Sensible heat is what we call the heat that changes the temperature of a substance.

An example of this is heating water at room temperature to boiling. The water will increase in temperature steadily until it boils. Then the temperature will stay at 212°F (at sea level) as it changes to steam, even as heat is steadily applied. Cooling water to freezing works just the same, the temperature holding at 32°F until freezing is complete. Remember, latent heat changes the state (or phase) of a substance without changing its temperature, and sensible heat changes only the temperature.

As we progress to a quantitative discussion about energy, we will employ the familiar British Thermal Unit (Btu), defined as the amount of energy required to heat 1 lb of distilled water 1° F. Another way of saying this is that water has a heat capacity of 1 Btu/lb-°F. As an interesting aside, water has the highest heat capacity among common substances, making it a very useful heat-transfer medium.

THE CONNECTION WITH POLYMERS

So what does all this have to do with plastics? Calculating the energy required to heat and cool a polymer during processing uses all the energy principles and units we have just introduced. However, an important difference exists between amorphous and semi-crystalline polymers. Semi-crystalline materials have a latent heat component that must be added during heating and removed during cooling to "thaw and re-freeze" the crystalline part of the molecular structure.

It is called Latent heat of Fusion and its units are Btu/lb. Amorphous polymers, of course, do not have the crystalline content and thus do not have a latent heat value. Table 2 shows heat capacity and latent heat of fusion values as well as some generic processing and ejection temperatures for common materials. Examples below will demonstrate how to perform energy calculations with both categories of polymers.

Using the data in Table 1 (plus a few assumptions), we can begin to perform several interesting and useful energy calculations.

Continues On Page No.: 108

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We can calculate the energy required to heat a material from room temperature to processing temperature, either per shot or per pound of material. We can also calculate energy flow rates into a mold or from a mold during part cooling.

AMORPHOUS MATERIALS CALCULATIONS

For simplicity we will begin with an amorphous material, polystyrene, and let's say we are heating the material from room temperature at 80°F to a processing temperature of 475°F. Our shot weighs 0.25 lb (including conventional runner) and the cycle time is 12 sec. First we will calculate energy/lb using the expression (see Table 1 for definitions of each symbol):

Elb = W x **ΔT x C**

We are heating the material from 80°F to 475°F, thus:

ΔT = 475 F-80 F = 395° F.

Since we first want to calculate energy added per pound of material, we use 1 lb as the shot weight. From Table 1 we find the heat capacity of PS is 0.43 Btu/lb.-°F. Next we insert all the values into the expression as follows:

Elb = 1 lb x 395° F x 0.43 Btu/lb-°F = 169.9 Btu/lb of material

Next, let's calculate the energy per shot using the same expression, but substituting our assumed shot weight of 0.25 lb to get the following result:

Eshot = 0.25 lb/shot x 395° F x 0.43 BTU/lb-°F = 42.46 Btu per shot

It is also interesting to calculate the heat flow in Btu/hr of heat input to the mold based on the above Btu/shot value. For this we need only to multiply Btu/shot by shots/hr (SPH) as follows:

Using our assumed cycle time,

SPH =3600 sec/hr ÷ 12 sec/cycle = 300

Energy flow into mold:

Q = 42.46 Btu/shot x 300 shots/hr = 12,738 Btu/hr

SEMI-CRYSTALLINE MATERIAL CALCULATIONS

In our next example we will calculate energy flow into an 8-cavity mold running a fairly thick, reuseable polypropylene food-storage container with a shot weight of 0.78 lb and cycle time of 16 sec. From Table 2 we select the heat capacity value of 0.61 Btu/lb.-°F, and latent heat of fusion value of 89.1 Btu/lb, the processing temperature of 450°F, and again a room temperature of 80°F.

The calculation method will be the same as for PS except we must include the latent heat with PP. Notice that the latent heat units are Btu/lb, thus the latent heat value depends only on weight, and not temperature. It will be interesting to compare Btu/lb heating from room to processing temperatures for the two materials. Thus, for PP we will begin with energy/lb using the following expression:

Elb = W x ((ΔT x C) + LF)

ΔT = 450 F-80 F = 370° F

Elb = 1 lb x ((370 x 0.61)+ 89.1) = (225.7+ 89.1) = 314.8 Btu/lb

Notice that even though the processing temperature for polystyrene is higher (475°F), PP requires nearly double the heat to reach processing temperature due to the latent heat that must be added to melt the crystalline structure. Next we will calculate the energy flow rate for our PP part:

Eshot = 0.78 lb x ((370 x 0.61) + 89.1) = 0.78 x ((225.7+ 89.1) = 0.78 x 314.8 = 245.5 Btu/shot

Next we can calculate energy flow just as before, using

Q = BTU/shot x SPH

SPH = 3600 sec/hr ÷ 16 sec/cycle = 225

Q = 245.5 Btu/shot x 225 SPH = 55,238 Btu/hr

RULES OF THUMB & COOLING

One can find rules of thumb suggesting that the mold-cooling circuits should be capable of removing approximately 60% of the energy input to a mold like we have just calculated. Our studies indicate that while it is simple to estimate energy input to a mold, the various paths of heat removal are more complex and depend on several factors.

Conventional machined cooling circuits with liquid coolant normally do most of the cooling, but a heated mold can transfer significant heat to machine platens by conduction and also to the surroundings by radiation and natural convection. A ceiling fan placed directly above a molding machine can influence the heat-transfer balance and temperature of a mold. And don't forget the significant heat remaining in the ejected parts and runner.

Another approach to estimating the cooling needs of a mold is to perform a calculation based on the difference between processing and ejection temperatures. I like this method because one can use a resin producer's recommended processing and ejection temperatures—or better still, use experienced-based values you know and trust.

To illustrate, we will continue with the properties and values for our PP container. The major difference is that we have no need to calculate the heat added to the material to reach processing temperature. Instead, we can directly calculate cooling energy based on changing the temperature of the molded parts (and runner if applicable) from processing to ejection temperature.

One additional factor to consider is that the material may not be 100% crystallized in the part's interior when the parts are ejected. You may have experienced this condition by feeling parts "heating up" to the touch after ejection. (Such "reheating" of parts after demolding can also occur if there are thick sections that remain hotter in the center than the frozen skin when the mold opens.) The degree of crystallization in the mold depends primarily on mold temperature and cooling capability. We will assume our parts are 60% crystallized when ejected and use a corrected latent heat value of 0.6 x 89.1 or 53.5 Btu/lb in our calculation.

To continue with our calculation, select processing and ejection temperatures for PP from Table 1:

Ecooling =

W((**ΔT x C**) + LF)

Cooling ΔT is processing temperature minus ejection temperature = 450-212 F = 238 °F.

Ecooling = 0.78 lb x ((238 x 0.61) + 53.5) =

0.78 x (145.2 + 53.5) = 155 Btu/shot

Qcooling = Ecooling x SPH = 155 Btu/shot x 225 SPH = 34,868 Btu/hr.

We can see that these calculations are fairly simple and straightforward. For best accuracy, use measured melt temperature as the processing temperature. The values provide a solid basis for evaluation of existing mold-cooling circuits or for designing cooling circuits for a new mold. They are also useful for estimating chiller capacities and water pumping capacity. In Part 2 we will explore water-cooling factors in balancing the heat budget.

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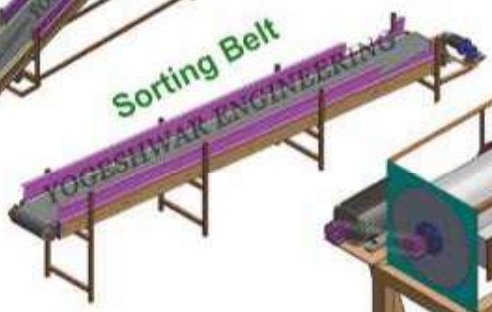

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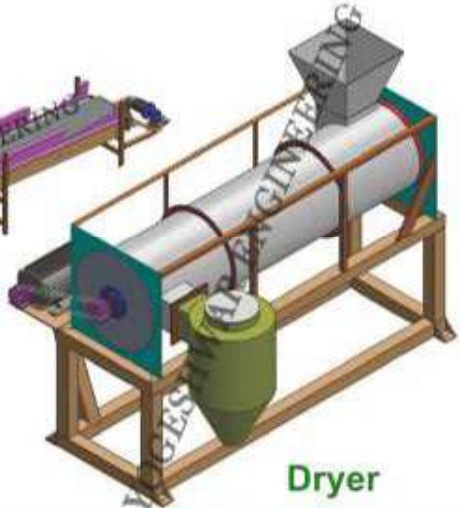

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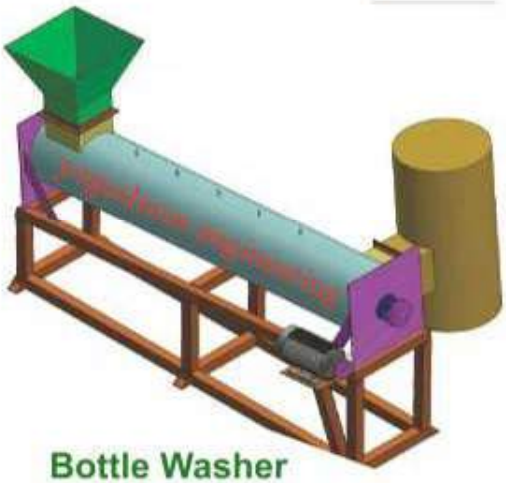

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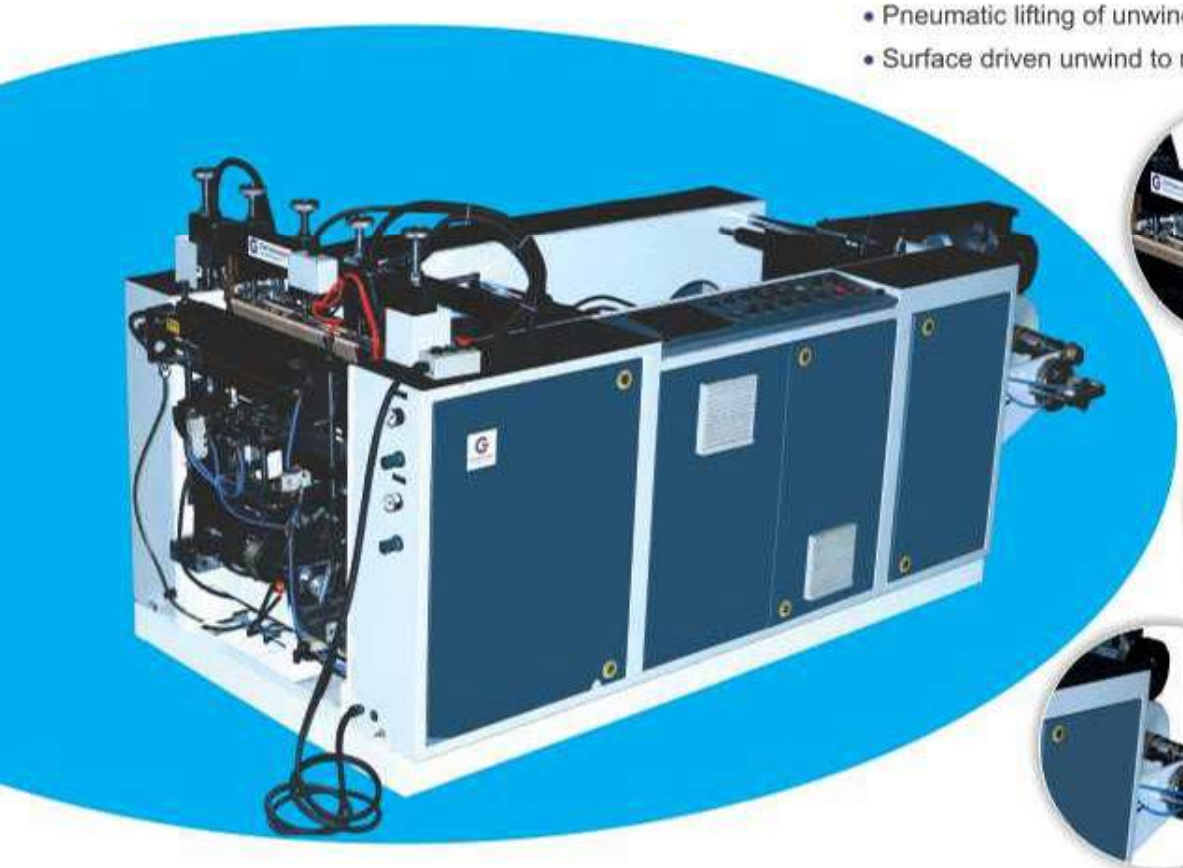

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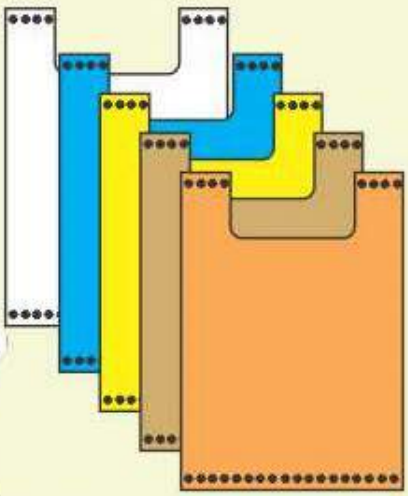

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Bike-Path Made From Recycled Plastic Opens in the Netherlands

Officials with the Dutch city of Zwolle have announced the opening of a new bike path made using recycled plastic. The bike path is part of a nationwide effort to recycle more user end products. The bike path was made using a modular design called PlasticRoad by a pipe-making company called Wavin.

The idea for the bike path was conceived by Anne Koudstaal and Simon Jorritsma who work for KWS—a company that makes roads. KWS and Wavin were joined by petroleum giant Total in designing the PlasticRoad concept.

The bike path is 30 meters long and runs from Verenigingstraat to Lindestraat in Zwolle. Officials with Wavin report that the modules making up the bike path used the equivalent of a a half-million plastic bottle caps and approximately 218,000 plastic cups.

Recycled plastic accounted for approximately 70 percent of the PlasticRoad material. The modules were created using a hollow design—at the top is the road surface—beneath it is a hollow area that can be used for draining. A frame holds the top and bottom pieces together.

The researchers also added sensors in the hollow section to count traffic and monitor wear and tear on each module. Installation of a stretch of roadway or bike path is done by excavating the ground and then laying the modules one by one. Each module is then connected to adjacent ones to provide a seamless ride for bike riders. Wavin officials claim the modules are easy to install, very lightweight and are more durable than asphalt. They are made with circular production methods, which means that when a module wears out, it can be melted down for production of new modules.

The Netherlands is a prime location for such a bike path, as biking is very popular there—the country has 22 million bikes for just 17 million people. And the bikers are supported by a vast infrastructure dedicated to their use—the city of Amsterdam, for example, has approximately 800 km of bike paths.

Officials with Wavin report that a second bike path is to be installed in the town of Giethoorn—both pilot projects are meant to test the idea of using recyclable plastics for building bike paths and perhaps roadways.

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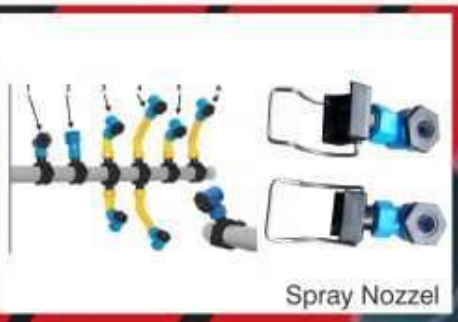
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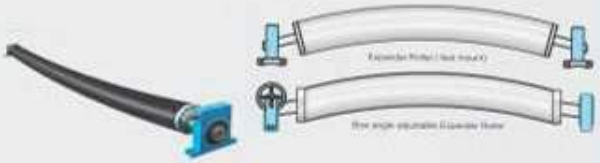

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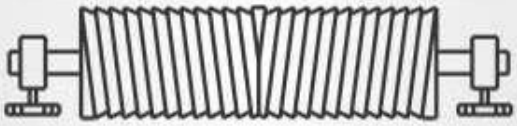

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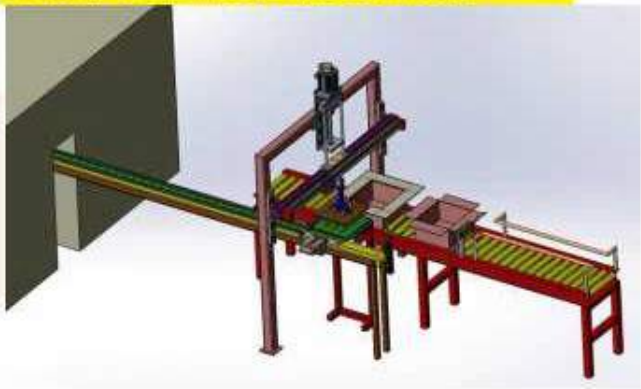

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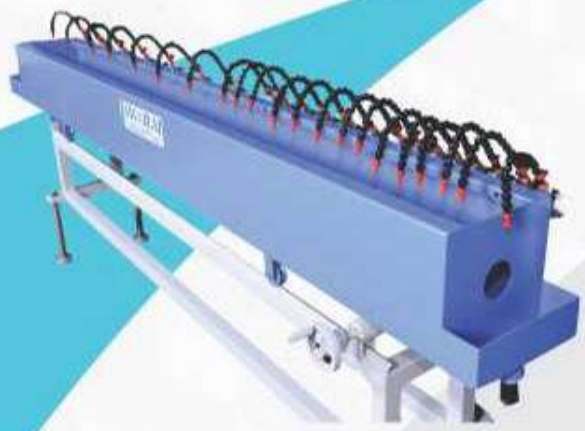

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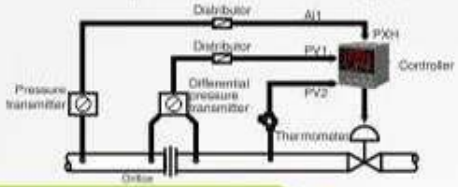

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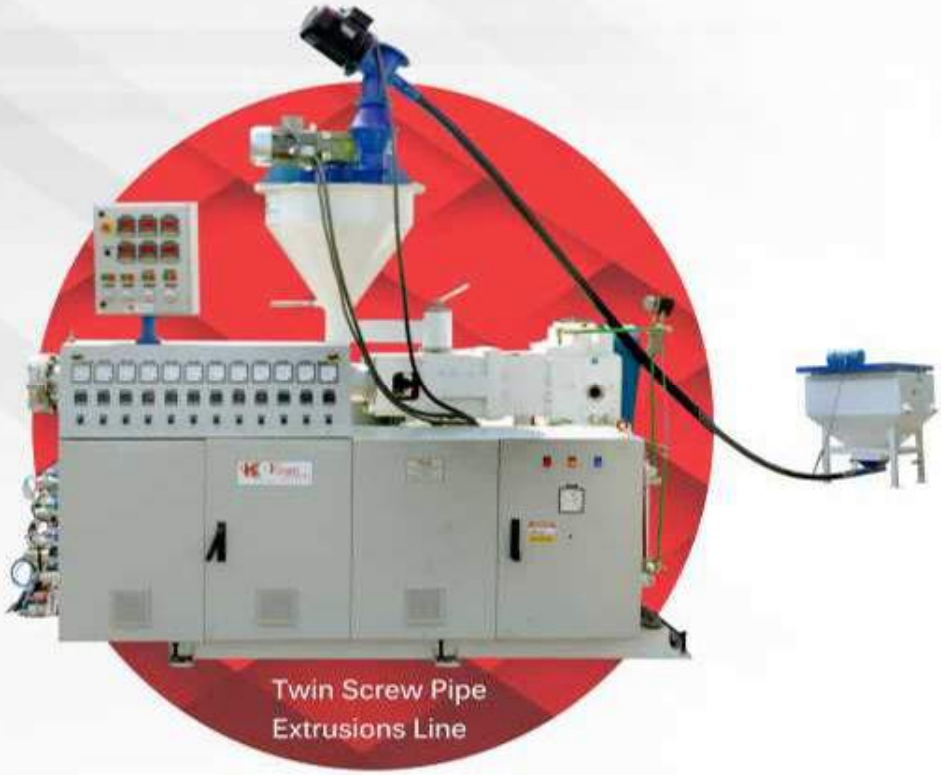

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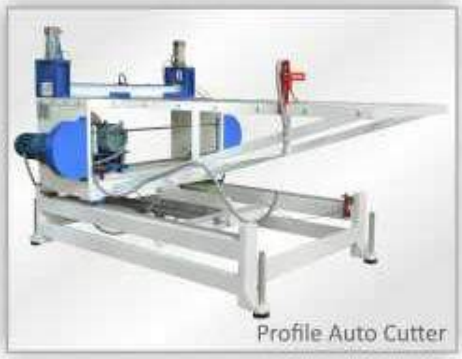
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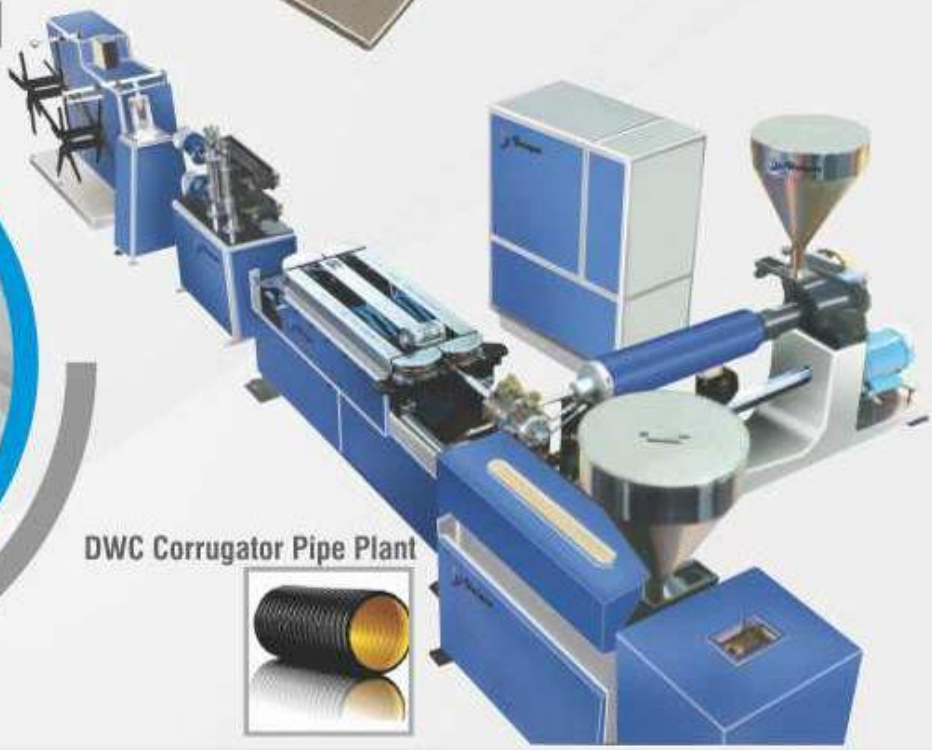

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- Stretch Wrapping Machine
- Masking Tape Machine

High Speed Rotogravure Printing Machine

Bopp Tape Cutting Machine (Automatic)

Core LODER (Automatic)

Paper Core Cutting Machine (semi Automatic)

Bopp Tape Cutting Machine

MINI Bopp Tape Cutting Machine

MINI Rewinder Machine

Paper Core Cutting Machine (Pedal Type)

We Also Provide Converting Machinery Equipments

Masking Tape Slicer (Automatic) Machine

Masking Tape Rewinder Machine

PVC TAPE Slicer Machine (Automatic)

Drum Type Paper Slitter Rewinder Machine

High Speed Paper Slitter Rewinder Machine

Paper Core Cutting Machine(Manaul)

Rotogravure Printing Machine

Unwinder Unit

Web Aligner Unit With Trally

Fully Automartic Paper Core Cutting Machine

BOPP Coating Machine

PVC Slicer Machine (Manual)

SHREEJITECH ENGINEERING

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Sulti Plants

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PVC Socketing Machine

Coiling Unit

Tube / Pipe Cutting Unit

Single Screw Extruders Polyolefins

Pipe Tilting Unit

NILKANTH ENGINEERING WORKS

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