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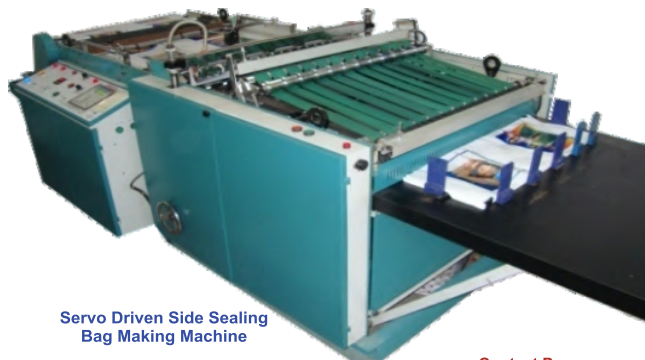
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"EXPERTISE IN EXTRUSION"

ABC CO-EXTRUSION HIGH SPEED BLOWN FILM MACHINE

APPLICATION

LAMINATION FILM

FOOD PACKAGING

MULTCH FILM MAKING

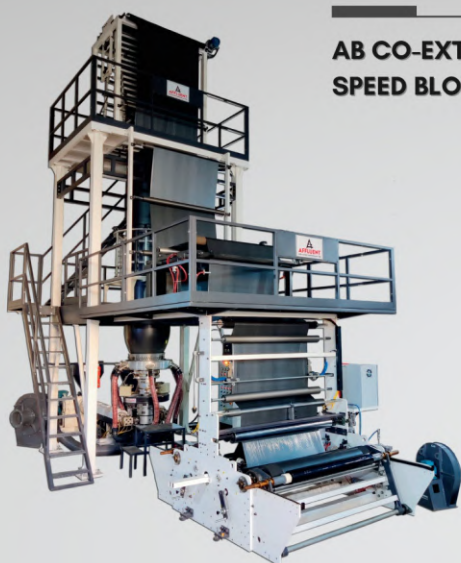
CONSTRUCTION FILM

CONSTRUCTION SHEETING

MATERIAL

LLDPE, LDPE, HDPE





AB CO-EXTRUSION HIGH SPEED BLOWN FILM MACHINE

APPLICATION

AGRICULTURAL FILM
PACKAGING FILM
MULTCH FILM

MATERIAL

LDPE, LLDPE



MONOLAYER HIGH SPEED BLOWN FILM MACHINE

APPLICATION

GREEN SHED NET

MATERIAL

HDPE, MASTERBATCH



ABA CO-EXTRUSION HIGH SPEED BLOWN FILM MACHINE

APPLICATION

GARBAGE BAGS
SHOPPING BAGS
SHADE NET FILM LINERS
BOTTOM SEALED FLAT BAG
SUPERMARKET BAG

MATERIAL

LLDPE, CaCO₃,
HDPE, LDPE,
Additives



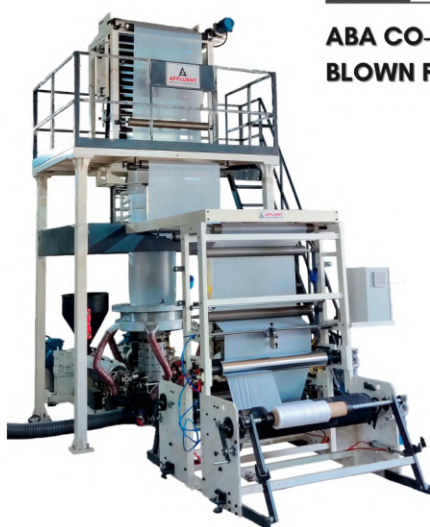
MONOLAYER HIGH SPEED BLOWN FILM MACHINE

APPLICATION

BIODEGRABLE MATERIAL
SHOPPING BAGS
GROCERY BAGS
T-SHIRT BAGS
SHRINK FILM
LINERS

MATERIAL

HDPE, LDPE, LLDPE,
Masterbatch, CaCO₃



ABA CO-EXTRUSION MINI BLOWN FILM MACHINE

APPLICATION

COMPOSTABLE BAGS
SHRINK FILM

MATERIAL

HDPE, LDPE,
LLDPE, CaCO₃,
Additives



MONOLAYER MINI BLOWN FILM MACHINE

APPLICATION

BOTTOM SEALED FLAT BAG
COMPOSTABLE BAGS
SHOPPING BAGS
SHRINK FILM
CARRY BAGS
VEST BAGS
LINERS

MATERIAL

HDPE, LDPE,
LLDPE, Masterbatch,
CaCO₃

FACTORY : 14, KRISHNA INDUSTRIAL PARK-1, ODHAV-KATHALAL HIGHWAY, AHMEDABAD, GUJARAT, INDIA. PIN : 382430

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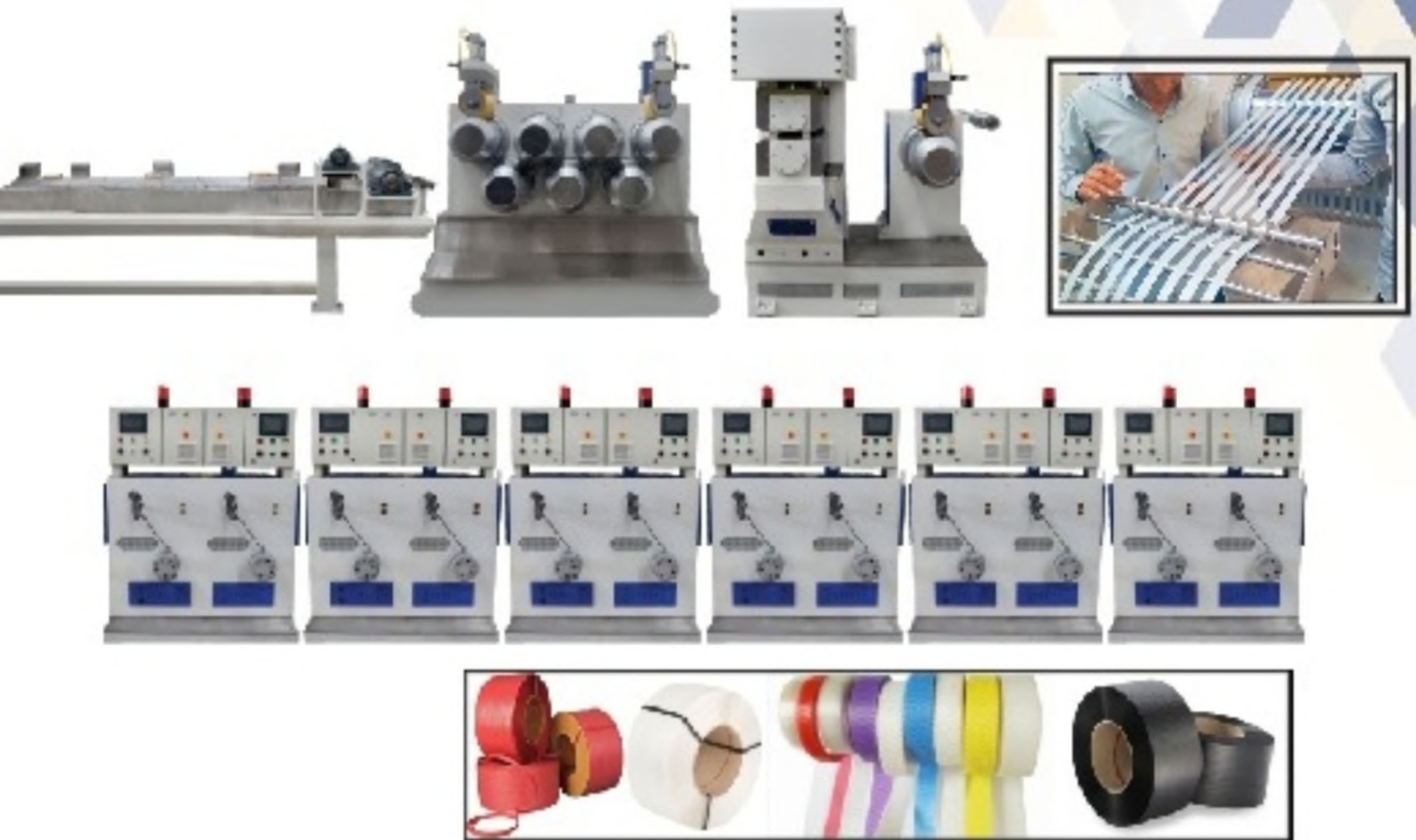
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◆ **PP / HDPE FIBRILLATION TAPE EXTRUSION LINE
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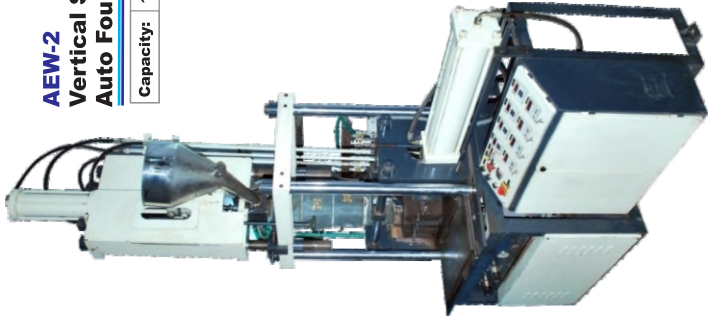
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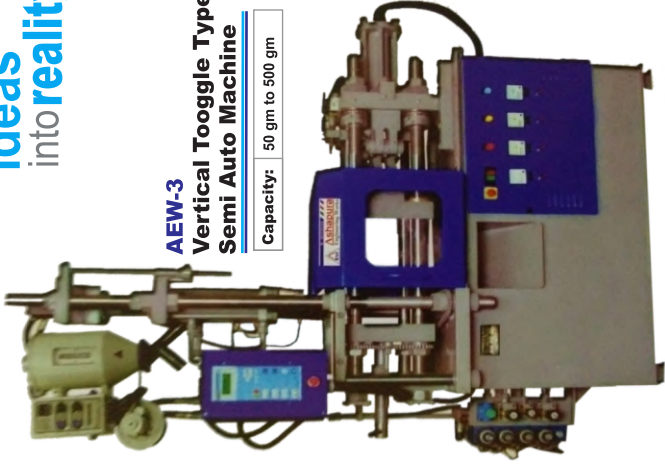
AEW-2 Vertical Semi Auto Four Pillar Moulding Machine

Capacity: 150 gm to 1 Kg.



AEW-3 Vertical Toggle Type Semi Auto Machine

Capacity: 50 gm to 500 gm



AEW-1

Vertical Toggle Type Semi Auto Four Pillar

Capacity: 30 gm to 500 gm



Technology With the Machine

- Open Loop Hydraulic System With Variable Piston Pump for the Power Saving Up to 30%.
- Electro Proportional Valve for Fine Control of Pressure & Flow.
- PLC Based 12-Line LCD Screen Displayed Microprocess Controller For Perfect Operation.
- Electro Linear Scale For Require Pressure & Flow At particular Position of Injection & Locking.
- Five Point "d" - Type Tapper Toggle For Positive Locking.
- Square Platen Area.



More...

AEW-4 UPVC Vertical Semi Auto Machine

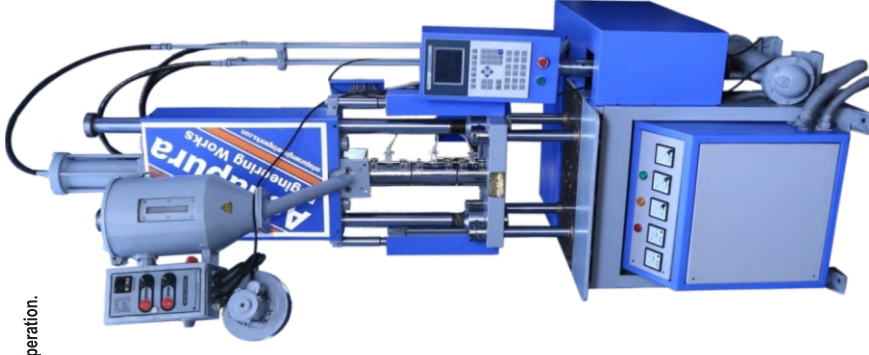
Capacity: 150 gm to 1 kg.



AEW-6

Vertical Insert Moulding Machine

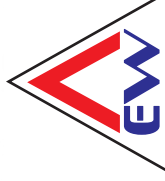
Capacity: 30 gm to 500 gm



AEW-5

Horizontal Injection Moulding Machine

Capacity: 50 Ton to 400 Ton



Mfg. of: Injection Moulding Machines.
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LASER PRINTER

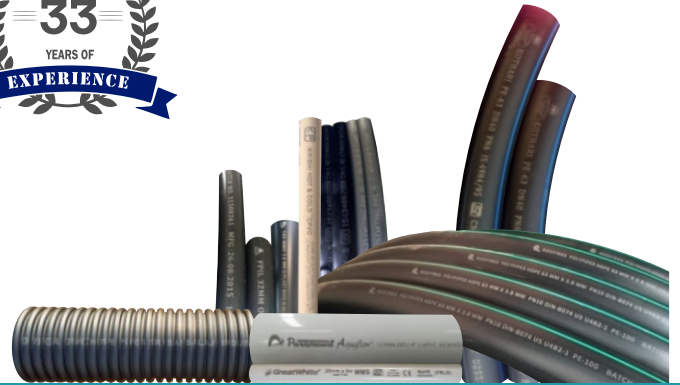
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DWC Pipes
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Fittings

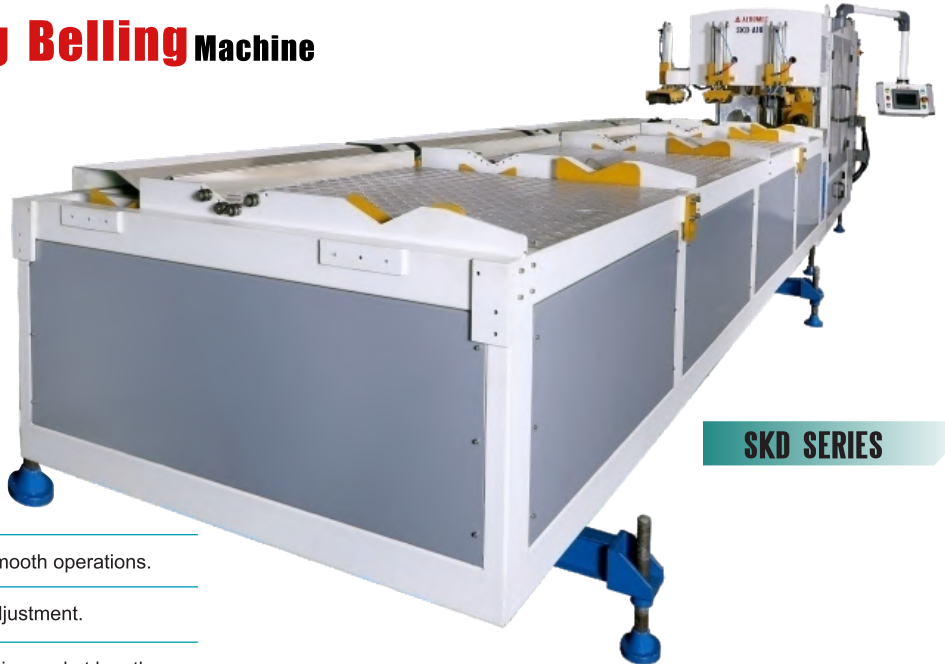


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- Motorised conveying system at forming station for precise socket length.
- Water cooling chamber for fast cooling of socket.
- Proven and durable machines using German design and development cycle.

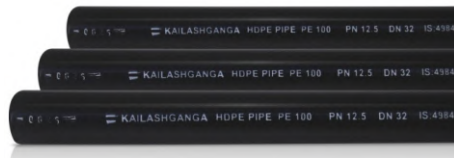


SKD-110V



Online **Hot Foil Stamping** Machine For PE / PP / PPR Pipes

AEROMEC Rotary type hot foil stamping machine specifically design for mark on PE/ PP/PPR pipes with various colors and sizes. Various models with 20mm -1200mm support.



Other Models

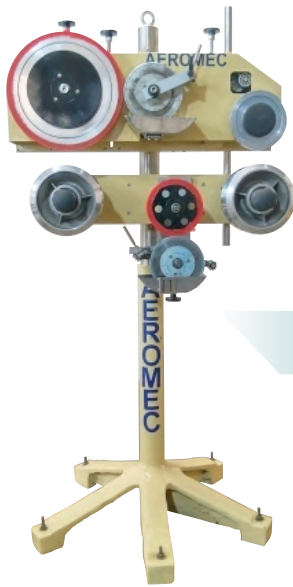
AMC-450

AMC-650

AMC-707



Online **PVC** Roto Gravure **Link** Marking Machine For



AMC-210Ink

Top
Marking

AMC-210Ink+B

Top + Bottom
Marking



CONSUMABLES

MARKING FOILS/TAPES

Hot stamping foil comes in different colours with 1000mtrs roll with 9mm & 12mm width.



BRONZE STEREOS / LETTERS

Bronze stereotypes are the marking stamps which contains the matter to be printed, comes with different chars. height & fonts. Available with 3mm,4mm,5mm,6mm,8mm, 10mm & 12mm.



POLYMER STEREOS

Polymer stereotypes are available from 0-9 as numeric and A-Z in alphabets. They are using with online Roto gravure Ink printing machine to print the batch no.



INKS AND REDUCERS

Inks and reducers are use with Roto gravure Ink printing machine to print on the PVC pipes.



Online **Laser Perforation** for rain pipe punching



Features

- Online laser punching machine for LLDPE rain pipes
- High speed punching - 50mpm available
- Punching + Printing combination in single machine
- Can punch thousands of rain flow punching graphs

CONTACT



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Editorial

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IS THIS WHAT YOU CALL CONFLICT ?

MOST OF US THINK WE ARE QUITE SERIOUS - IF WE FOLLOW A CERTAIN ACTION TO WHICH WE ARE COMMITTED, OR PURSUE TO THE END A PARTICULAR IDEA, A PARTICULAR BELIEF, OR HAVING COMMITTED OURSELVES TO A CERTAIN IDEOLOGY, WE PURSUE THAT THROUGHOUT LIFE, NOT DEVAITING FROM IT. WE ALSO THINK WE ARE VERY SERIOUS IF WE HAVE A CONCEPT, A FORMULA OF LIFE, AND CARRY THAT OUT THROUGHOUT OUR EXISTENCE.

NOW, IS THAT SERIOUSNESS? IF WE HAVE COMMITTED OURSELVES TO A PARTICULAR BELIEF, AND PURSUED THAT BELIEF, IF WE HAVE GIVEN OURSELVES OVER TO CERTAIN IDEOLOGICAL FORMULA, AND HAVE LIVED ACCORDINGLY TO THAT FORMULA OR ACCORDING TO A BELIEF, WHICH IS A CONCEPT, DOES ALL THAT CONSTITUTE SERIOUSNESS? WE ARE JUST QUESTIONING IT BECAUSE THAT WORD HAS GREAT CONTENT IN IT. IF WE COULD, AS IT WAS, OPEN UP THAT WORD, AND INVESTIGATE ITS SIGNIFICANCE AND ITS STRUCTURE, THEN PERHAPS WE COULD ESTABLISH A COMMUNICATION WITH EACH OTHER, BECAUSE WHAT WE ARE TALKING ABOUT IS QUITE SERIOUS.

TO BE REALLY SERIOUS MEANS TO BE FREE- FREE TO INVESTIGATE, TO FIND OUT, TO HAVE PASSION TO PURSUE. PEOPLE DO HAVE PASSION TO PURSUE ACCORDING TO A FORMULA. A MAN WHO BELIEVES ARDENTLY PURSUES; HE LIVES A LIFE, BUT IT IS LIFE COMMITTED TO AN IDEA; TO A BELIEF, TO A FORMULA, TO A CONCEPT, IS JUST GOING ROUND AND ROUND IN CIRCLES. IT IS REALLY A FORM OF SELF-WORSHIP THROUGH IDENTIFICATION WITH BELIEF.

BY USING THAT WORD SERIOUS WE MEAN SOMETHING ENTIRELY DIFFERENT. TO INQUIRE INTO, OR EXAMINE INTO, THE REALITY OF LIFE, INTO WHAT IS EXISTENCE, WE MUST BE TOTALLY FREE; OTHERWISE, WE CAN'T EXAMINE. IT SEEMS TO US THAT A PERSON WHO IS SERIOUS, WHO IS ESSENTIALLY FREE, DEMANDS FREEDOM. HE MAY NOT BE FREE, BUT HE DEMANDS IT; AND IN THE DEMANDING OF IT, HE BECOMES SERIOUS BECAUSE HE HAS NO CONCEPT OF WHAT FREEDOM IS. IF WE HAVE A CONCEPT WHAT FREEDOM IS AND ARE TO THAT CONCEPT, THEN WE ARE NO LONGER FREE TO INVESTIGATE FREEDOM. BUT IF WE DENY THE WHOLE COMMITMENT TO A FORMULA, TO A CONCEPT, TO A CONDITIONED STATE OR TO PROPAGANDA - ON THAT BASIS WE MAY DISCUSS. IF THE MIND HAS BEEN BRAINWASHED THROUGH PROPAGANDA, THROUGH A CERTAIN BELIEF, SUCH A PERSON IS NOT FREE TO INQUIRE, AND THEREFORE HE IS NOT SERIOUS.

IN THE DEEP CONSCIOUSNESS OF A MAN, THERE ARE CRISIS BECAUSE HE HAS TO FACE A TREMENDOUS CHANGES IN THE WORLD, NOT ONLY OUTWARDLY, BUT INWARDLY ALSO. THE OUTWARD RESPONSE DEPENDS ON THE INWARD STATE, NATURALLY; AND IF THE INWARD STATE IS MERELY A RESPONSE OF A CONDITIONED MIND, THEN OF COURSE THE CRISIS DOESN'T EXIST AT ALL.

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Plastfocus 2024- An Evolved Plastics Exhibition for the best plastics manufacturing technologies.

After the resounding success in February 2019, PMMAI and Triune Exhibitors Pvt Ltd bring to you Plastfocus 2024- An Evolved plastics exhibition.

India's emergence as the leading global hub for plastics manufacturing and processing entails a congregation of all Plastics manufacturers and dealers from across the world to present the best plastics manufacturing technologies. Be a Part of the Evolution- Participate in PlastFocus 2024, India's flagship event in the field of plastics, raw materials, processing machinery and finished goods.

Plastfocus 2024 will also be held at India's best trade fair venue- India International Convention & Expo centre (IICC), Dwarka, New Delhi. Just an hour's drive from the nation's capital Delhi, the venue, renowned for superlative facilities with ergonomically laid out exhibition halls, has remarkable connectivity from the Airport, Highway, Railway & Cargo Port.

Hosted in Yashobhoomi (IICC)

To provide the best experience and convenience to the participants, the exhibition will be held at the Yashobhoomi (IICC), Dwarka, New Delhi, one of the large convention and exhibition centres in India with a total area of 3,00,000 m². The venue provides a perfectly suitable space for large exhibitions with a sprawling compound. The fairgrounds provide pillarless halls with a clear height of 16 metres with excellent load-bearing capacity. These features are of utmost significance for an event as Plastfocus 2024 where large and heavy machines will be showcased.

Why Exhibit

Benefit from the vast alliance network of the two leaders from



Plastics Manufacturing & Exhibition Organisation - PMMAI & TRIUNE EXHIBITORS (PLASTASIA). Plastfocus offers exhibitors a world class venue in the NCR that has a proven track record of meticulous planning & professional execution.

Business Facilitation

Plastfocus will help bring together in one place, a spectrum of players from the global plastics industry - manufacturers, suppliers and distributors, consultants, consumers, etc. Participants will feature CEOs, Managers, Engineers, Executives from every sector of the comprehensive supply chain of the plastics as well as user and allied industry. Congregation of such a broad audience in one place will boost business facilitation during the 5 days of the trade show. All participants will be able to schedule meetings, negotiate orders, explore business development opportunities and collaborate on projects.

Create Brand Awareness and Expansion

Plastfocus will provide businesses of every scale ways to grow their brand and build brand awareness with existing and prospective customers. Plastfocus offers a route to present a brand in front of current and future clients, whether they come to the show as a visitor or as an exhibitor.

New Launches will captures new Audience

A large portion of meaningful business visitors at this highly targeted market place is often interested in one main aspect- new products. They will travel and

attend Plastfocus to learn about new brands, new products, and new solutions, making this a great opportunity to launch a product.

Reach Out to Target Market Cost Effectively

Plastfocus offers budget friendly, simple, inexpensive solutions to market and sell your product - A perfect marketing aide for SMEs. Conclude deals at this ideal playing field that will pull in a decidedly targeted market with a high level of interest in exhibitor products. Even though the event is only 5 days long, benefit from the presence and interest of thousands of who come to one location specifically to learn about new products and developments.

Relationship Builder

Plastfocus offers an arena for personal interaction that will allow exhibitors to establish a direct, more effective relationship with both current and future clients. Benefit from the receptiveness of the business visitor who is part of the highly targeted community that is actively seeking new products and services.

Generate Sales Lead

Plastfocus will be your powerful marketing tool- providing potential buyers the opportunity to witness live demonstrations of your products and also have face to face interactions. This will build new relationships and deeper connections that open channels for new sales leads. Your business will vastly benefit as you unearth an untapped market and discover a potentially unexplored application for your product.

Benefits to Small Businesses Benefit

Plastfocus is a boon to smaller businesses trying to establish themselves in a marketplace. Plastfocus allows SMEs to get their name in the world of larger companies and reach thousands of clients at once.

Use of Plastics in Medical Science

By: Jai Inder

As a medical product manufacturer continues to search for new and better ways to prolong and save lives, They increasingly turn to engineering plastics for a material that helps them meet the critical design, manufacturing, and component tolerance requirements for medical devices and packages. Material failure is not an option in this industry, so resin performance is critical.

Engineering resins are used to solve problems when the properties of a standard grade resin can't meet the high demands of medical products,. For example, polyamide, as well as various blends, is often used by medical OEMs for challenging medical applications. Resin manufacturers respond to design needs by helping medical product manufacturers solve their material problems. They constantly develop new grades and optimize the material properties and processing parameters. For instance, the good steam stentizability of a high-heat grade of polycarbonate resin enabled an OEM to design a laparoscope as a reusable and disposable instrument. The handle, formed from the high-heat polycarbonate, is cleaned after use, sterilized and reused. However, the instrument insert are for single use only.

Gene therapy is a longer term trend affecting medical product manufacturers and resin suppliers. Since gene therapy uses a different base for providing medicine, it places different demands on materials to protect molecules from change and interaction. Resin manufacturers are preparing the next generation of materials needed for storage, delivery and disposal. Engineering plastic take over Polycarbonate

Occupies a unique niche in the medical device market. Engineers tap its key features of toughness, rigidity and strength for critical devices where safety and performance are vital. Furthermore, ease of sterilization gives designers wide latitude in designing products independent of the sterilization method. These features are further complemented by its high clarity, a key benefit when visual assessment of both patients and their prescribed therapies is indispensable. Polycarbonate replaces glass and metal in many

applications because of its desirable combination of properties.

Kidney dialysis is one example. Polycarbonate is used to make the cartridge housing for the haemodialysis filter membrane. The Polycarbonate's rigidity and strength protects the membrane, while its clarity allows the dialysis technician to observe the blood flow during the procedure.

Polycarbonate is also widely used to form the sturdy housing of oxygenators. During open-heart surgery, blood circulation is maintained vi a heart-fun machine. The heart of this system is the oxygenator, which enriches the blood with oxygen and combination of Polycarbonate's rigidity, strength and high transparency make it the material of choice for this life-saving application. Continuing advances in Polycarbonate chemistry are providing new or improved medical grades of the engineering resin to support changing medical needs. One example is lipid resistant Polycarbonate, developed in response to the increasing use of lipid emulsions to administer non-water-soluble pharmaceuticals. When IV connector components made of Polycarbonate are under stress load and exposed over extended periods (several days) to

Lipid emulsions, they can begin developing cracks. A new grade of lipid-resistant Polycarbonate resin developed for the IV component market show improved resistance to lipid-induced failure. This makes the material an excellent choice for lures, tubing connectors, Y-site medication ports, stopcocks and other similar applications. Acrylonitrile-butadiene-styrene (ABS) resins provide an excellent balance of properties for melded medical parts, mcdudting good giddy, strength, toughness, and creep resistance. Depending on the grade used, applications induce roller clamps, piercing pins, IV spikes, surgical instruments, disposable diagnostics, ballast filters, and test sets. Additionally, ABS resins offer excellent surface quality, a variety of pigmentation options and good chemical resistance, making the material ideal for break-resistant, making the material ideal for break-resistant housing for hearing aids. Blood pressure and pulse rate measuring instruments, and x-ray film cassettes. Styrene-Acrylonitrile (SAN) medical products are transparent, with the level of optional

clarity dependent on the grade used. Typical

properties include good surface gloss, high rigidity, hardness, and chemical products are transparent, with the level of optional clarity dependent on the grade used. Typical properties include good surface gloss, high rigidity, hardness, and chemical resistance. With its flow characteristics and process ability, SAN enables the production of thin-section mouldings with high strength and dimensional accuracy. The combination of process ability and transparency makes SAN well suited to medical applications such as reaction chambers of automated diagnostic units, in this instance, the clarity of the specimen-tube carriers and the nonspecific bonding characteristics of SAN enhance the accuracy of automated diagnostic test. Other application includes ampoules, measuring beakers, drip chambers, and line joints.

Thermoplastic polyurethane (TPUs) combine patient comfort with ease of use, design flexibility, and excellent process ability, and currently are used to create oxygen masks, medical tubing, catheters, soft and pliable post-surgical appliances, and other medical parts. Although they are a small slice of the overall thermoplastic polyurethane market, medical TPUs are gaining a reputation similar to the one held by their non-medical siblings. They are flexible, tough and rugged materials withstanding abuse without braking, and enhancing the performance of many applications.

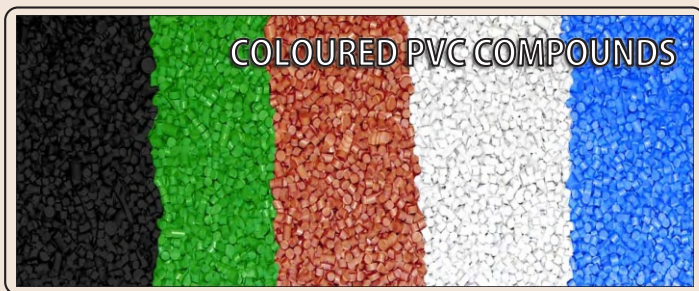
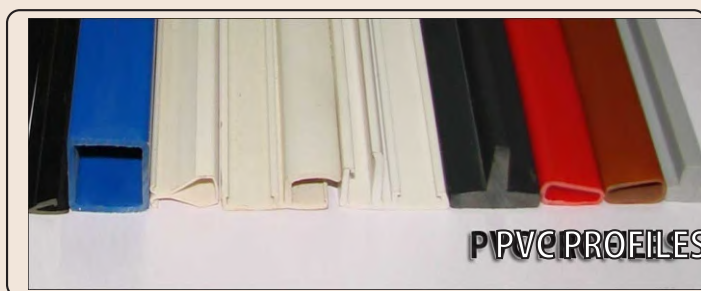
TPUs provide significant patient benefits. Medical TPUs are free of plasticizers and cause a few incidences of allergic reactions. And when compared with other plastic and elastomeric materials, TPUs have excellent nonthrombogenic behaviour, meaning blood tends not to clot as much when it comes into contact with the material. The materials also soften slightly at body temperature, allowing products such as catheters to be strong enough for insertion but subsequently soft enough for insertion but subsequently soft enough to end patient comfort. Other medical TPU properties include flow extractabtes, high tensile and tear strength, as well as excellent abrasion resistance and chemical resistance. The materials are sterilized using radiation, ethylene oxide and dry heat. Processed by most standard methods, TPUs are used in injection moulding, extrysuib and blow moulding.

Cont. on Page. 31

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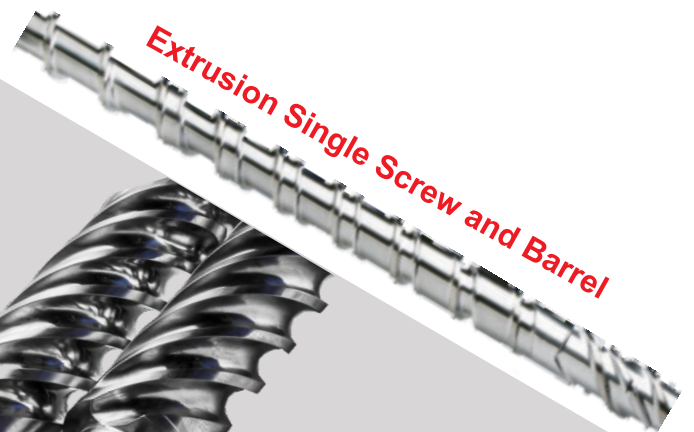
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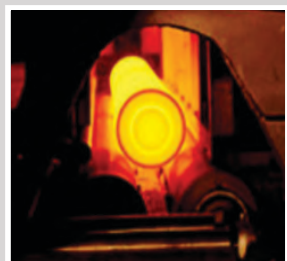
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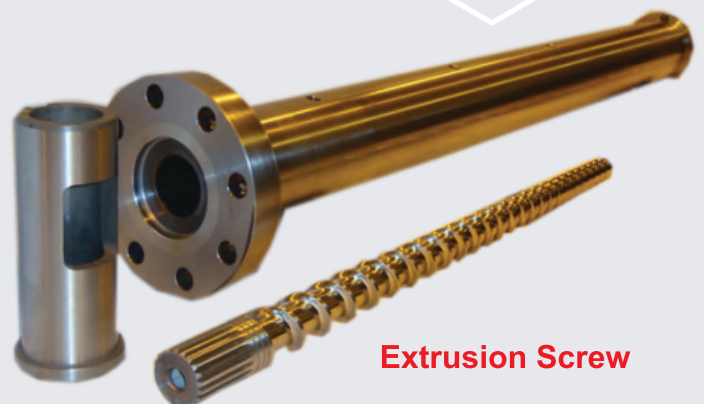
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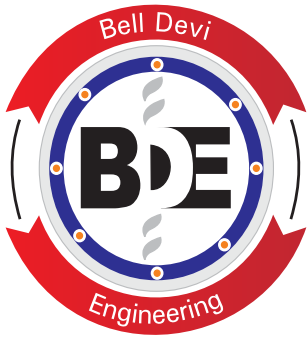


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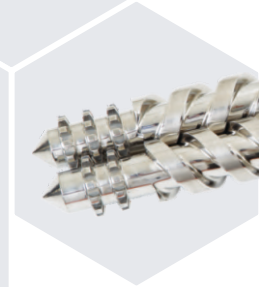
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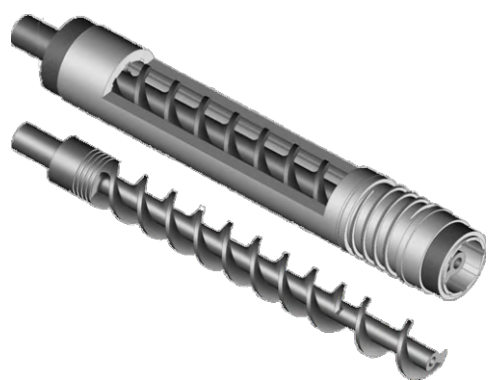
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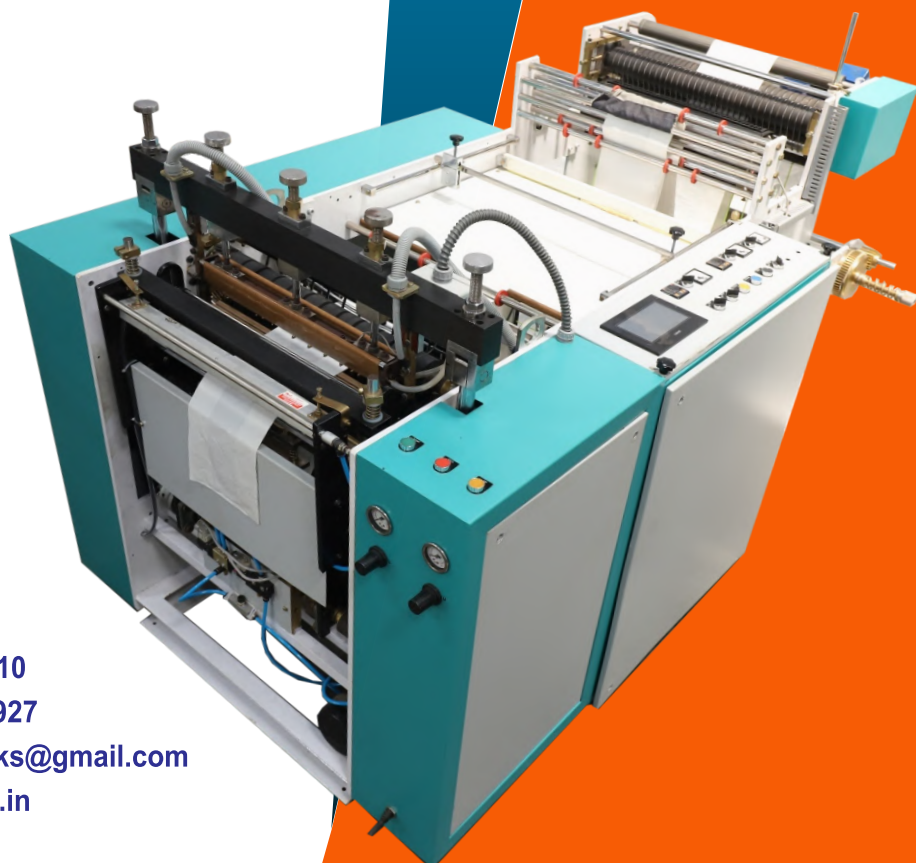


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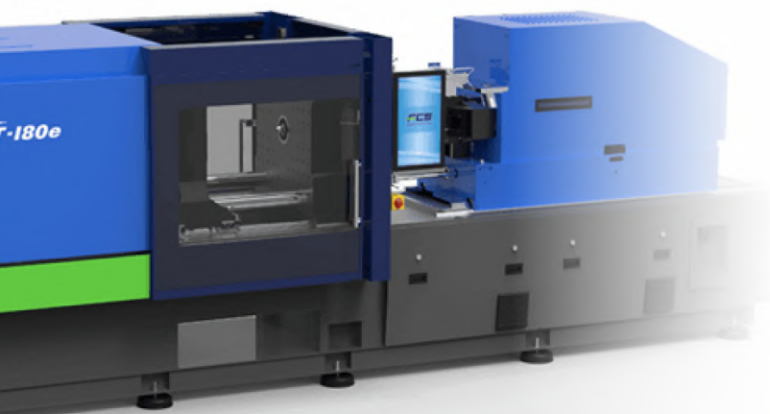


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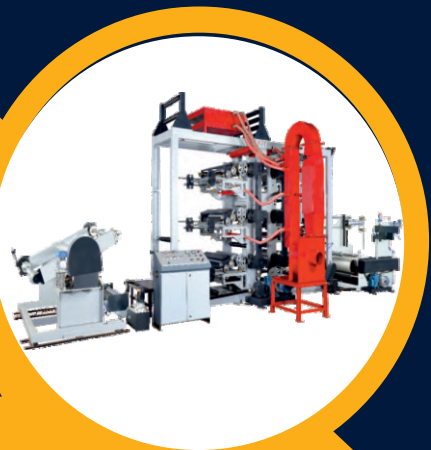
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GROWTH OF PLASTICS

By Amajit Singh

Plastics have become an integral part and parcel of our lives due to its economic value, easy availability, easy process ability, light weight, durability and energy efficiency, besides other benefits. This industry has made a modest start in the 1970s but has steadily grown to be noticeable in volume and value, and has achieved a double-digit growth. At the current consumption pattern Indian will be the 3rd largest polymer consumer in the world very soon.

What is plastics?

Plastics are synthetic, resinous, polymeric substance that can be given any permanent shape by Heat and Pressure. Types of Plastics: Major Polymers:- L . D . P . E . L i n e a r

PE?LLDPE?HDPE,PP,PVC,PS,PET. Major Thermoplastics: ANS, Polyamides (6 && 66) PET/PBT moulding grade Polycarbonate, Thermo sets.

Use in Automobiles:

Modern car manufacturers use FRP(Fibre Reinforced Plastics) to manufacture body parts which not only can be moulded into Aero Dynamic shapes but also offer good surface finish. The light weight contributes higher car averages and thus economy.

Use in Agriculture

Agriculture plastic products have become indispensable products and measures for modern agricultural developments to fight against natural disasters and achieve stable, high yield, high quality and efficiency in the farming process. They have been widely used in the agriculture, forestry, animal husbandry and fishery industries; Agriculture has become the

second biggest consuming sector of plastic products only to follow the packaging industry. According to different applications, agricultural plastics can be classified into agricultural sheathing materials; water pipes and equipment for water conservation; agricultural packaging material as well as various materials for farming, planting, raising, breeding and storage.

Plastic pipe is one of the important product types among chemical building materials. With different varieties and high growth rate, it has a good market prospect and huge potential for further development. Among great variety of plastic pipes products, the consumption of pvc pipes is the biggest.

In the field of Construction

After the appearance of wooden, steel, and aluminium products, PVC windows and doors are considered as the 4th generation new building materials in the world from the 20th-21st Century. The consumption rate of plastic profiles as well as plastic windows and doors is still increasing. Polymer water proof rolled products are replacing the other old water proofing products.

Use in the field of Medical

With the continued development of the plastics industry and wide application of the medical science and technology plastics in medical fields, for major types of medical plastics, namely artificial organs, repairing materials, products of non-repeatable use as well as medical containers are mainly used as they are safe, convenient and efficient.

The demand of plastic packaging for medicine has been increased also. The demand for bubble type of packaging and plastic bottles has remarkable increase in medical sector.

Through changing the molecular structure of the polymer, the market can be further developed by making plastic material conductive to electricity, shielded against electro-magnetic field, magnetic, conductive to heat, transparent, sensitive to light or fire-retardant.

Use in the powerful explosives

The powerful explosives of plastics are commonly used by engineers and combat engineers. The most common commercial use of plastic explosives is in hardening high manganese percentage in steel. This material is typically used in train rail compartment and earth decking implements.

The new generation plastic explosives are fairly stable and can be moulded into any form such as a ball or a sheet.

Exports of Plastics from India:

With the Government identifying exports of plastics products from India as a thrust area with potential, the Indian entrepreneurs are gearing themselves to make their presence felt at International Markets. The top 10 trading partners for India's plastic industry are: USA, UAE, Italy, UK, Belgium, Germany, Singapore, Saudi Arabia and China.

Although, we Indians use lot of plastics in the form of Acrylic Mirrors, the Comb, the hair brush, Nylon multi zipped bags or in the form of office briefcase in our daily life but we are far away from the per kg per person ration as compared to developed countries.

Use of Plastics in Medical Science

Cont. From Page. 18

Polyamide resins provide a balance of physical properties including high dynamic fatigue resistance, chemical resistance, high strength and rigidity, attractive surface appearance, and high abrasion resistance. Applications in medical equipment include disposable clamps, piercing pins, and components subjected to serve mechanical or dynamic stress. Steam-sterilized composite films made of polyamide and polyethylene are successfully used in transparent, sterile packaging applications. A combination of thermoformed film and sterile paper is

frequently used for surgical instruments.

Blends meet OEM needs by combining the best properties of different materials, and are excellent choices for forming the housing of medical products, including portable diagnostic devices and patient monitoring equipment.

Polycarbonate/ABS blends provide good toughness and impact

Resistance even at low temperatures, excellent colour stability & consistency, easy processing, dimensional & thermal stability, & excellent creep PR technology that is antimony, bromine, & chlorine free. Furthermore, these blends provide a thin-wall

design capability & are easily plated or EMI-shielded.

Polycarbonate/polyester blends exhibit exceptional strength across a broad temperature range & have excellent chemical resistance. They are available in general purpose and FR grades & are easily EMI or RGI-shielded using vacuum metallization, electronic plating, or painting techniques.

ABS/polyamide blends offer ABS-like processing characteristics, while a nylon-rich surface provides superior chemical & abrasion resistance. These blends also exhibit higher heat resistance than ABS resin.

Cont. from page. 17



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Network with other attendees- strategic business partners or prospective customers

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Consolidate the purchasing process, Compare products at one location, get great deals.

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- Recycling Machines
- Measurement & Testing Equipment
- Parts & Components
- Auxiliary & Testing Equipment

Die/Mold and Tools Designing

Among the many factors to consider when designing and building a stamping die are the material to be processed, the press that will run the die, and specified part tolerances. Inadequate knowledge of these factors can contribute to die failure and production and quality problems.

Throughout the last 28 years of my tool and die career, I have seen a plethora of dies ranging in size from a 20-station progressive die that you can hold in your hand to single-station dies that are 30 feet long. I have seen tools running as slow as 1 stroke per minute (SPM) and as fast as 1,500 SPM. I have seen dies made from solid carbide and dies made from materials just short of Elmer's glue and sawdust. Presses ranging from 1 to 50,000 tons, materials being stamped from gold to S-7 tool steel. Wow! What a ride!

I travel a great deal, so I see a lot. Some tools perform flawlessly, while otherwell ... let's just say they would make good boat anchors. Very simply, a tool's performance is based on many variables and factors. Items such as the press parameters, the cutting and forming lubrication, as well as changes in temperature are a few basic factors that affect stamping process success. Following are three deadly tool design sins to avoid.

Assuming You Know Your Stamping Material

Knowing as much about the metal that you are trying to cut and form is very beneficial. Literally thousands of different types of ferrous and nonferrous metals are available today. Each type of metal has its own special behavioral characteristics. Stamping materials such as titanium and gold is not common. I usually tell my seminar attendees this: In order to process, design, or troubleshoot sheet metal successfully, you must first think like the metal. For example, if you think like low-carbon, draw-quality steel and are trying to form aluminum, you will have problems. Not that aluminum is bad, it's just different. If you are processing a part that requires a great deal of stretch or draw ability, don't attempt to process it with insufficient data. For example, don't be satisfied with knowing only that the material is 1018 steel. Instead, find out the material's tensile and yield strengths, as well as its elongation percentage and, whenever possible, its average n and r values.

Find out if the metal is coated or pre-painted. If it is a nonferrous metal, find out if it is full-hard, dead-soft, or half-hard. Also, if the metal is to be drawn, determine

if it is of drawing quality. Is the material a specialty advanced high-strength steel such as dual-phase or TRIP?

Knowing the material type will help you choose a suitable tool steel to cut and form it. Knowing your metal's characteristics also will help you to determine if it may be necessary to anneal the parts between forming operations. Higher-strength metals exhibit more spring back. Knowing if your metal is high-strength can lead you to add extra stations to compensate for spring back issues.

Avoid building common tools to form a wide variety of different metals without changing the die.

In addition, pay close attention to the metal thickness. Thick metal stretches more than thin metal. Why? There is more metal to stretch. It's a volume thing. Nothing is more difficult to stretch or draw than thin, high-strength metal. Thin metal does not resist buckling and wrinkling as well as thicker metals. Thick metal is inherently stiff, so it resists buckling much better. Very deep-drawn parts made from thin, high-strength metal often require multiple drawing operations. To get an idea of what I mean, imagine drawing a sheet of aluminum foil into an oil pan. Ouch!

Assuming You Know the Press

Making assumptions about a press is a major sin. Just recently I had a client who was attempting to run a progressive die that was designed to deep-draw a stainless steel cup. He encountered major splitting problems. Why? Although the press had adequate tonnage and bed size, its ram speed (velocity) was way too fast for deep-drawing applications. The press was engineered for blanking, not deep drawing. Much to the client's disappointment, the die will never run in that press. The die designer never asked what type of press would house the die. A grave mistake.

You must consider many factors when selecting a press for a die. For example, just because it takes 100 tons to deep-draw a large part doesn't mean that you can safely place a die in any old 100-ton press. Careful consideration must be given to the available tonnage during the stroke. For instance, a 400-ton crank-drive press with an 8-in. stroke may have only 150 tons available 3 in. from the bottom of the stroke. If the part that you are attempting to draw is 3 in. tall, you need enough tonnage to form and control the metal flow 3 in. from the bottom of the stroke. You may not have the available force needed at that point. The possible

result? Boom! A broken press.

Pay attention to the ram speed of the press. Draw-link drive, servo, and hydraulic presses are best-suited for deep-drawing applications, while faster presses often are suitable for cutting and bending applications. It is the die designer's responsibility to engineer a tool that can perform in the client's press. If the client does not have the proper press for the tool, the designer should inform the client that he is undertaking a great risk by installing it in the press (Figure 1).

Ignoring Part Tolerancing

Tight tolerances require a greater amount of precision to be engineered into the die. Keep in mind that just because a part has been designed with a very tight critical tolerance does not mean that the part can be stamped to the specified tolerance. I have seen parts with specified tolerances that would be literally impossible to achieve in a stamping die. Generally speaking, with the exception of dies that resize the metal's thickness, avoid making parts that have tolerances less than the metal's thickness.

Also keep in mind that the incoming metal will differ slightly from coil to coil. Remember, regardless of how well you process the part and how precise the die was built, the incoming metal will not be consistent, and variability in your parts will exist.

Don't make assumptions regarding the part tolerance. Avoid processing parts with unrealistic tolerances

Watch for critical trim line tolerances. Formed parts with close trim line tolerances usually require trimming the part after the part is completely formed. This adds more stations to your die. In addition, look for surface requirements such as Class 1 or A surfaces. These stringent surface requirements usually inflate the tooling cost and increase the time spent metal finishing the forming die sections.

When sheet metal meets physics, physics always wins. Don't try to defy the physical limitations of the metal that you are forming or cutting.

Art Hedrick is president and senior consultant of Dieology, 8579 River Oak Circle, Greenville, MI 48838, 616-225-2170, www.dieology.com.

Author of the "Die Science" column in STAMPING Journal®, Art also has written technical articles on stamping die design and build for a number of trade publications. A recipient of many training awards, he is active in metal stamping training and consulting worldwide.



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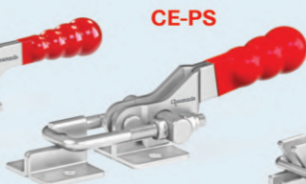
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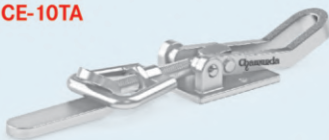


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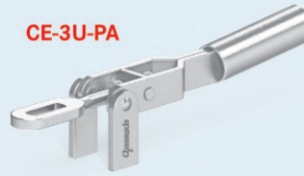
CE-10TA



CE-10TA-SA



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Mould Clamping Accessories

**GOOSE NECK
CLAMP**



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CLAMP**



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**Clamping
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**Clamping
Stud with
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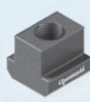


FLANGED NUT



M12 to M 24

"T" NUTS



M10 to M 20

**RHOMBUS
T-NUT**

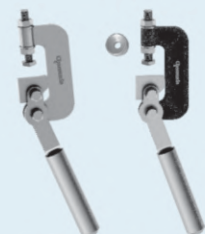


M10 to M36

TGP

Model No.	Holding Pressure
TGP-6	100 kg
TGP-8	200 kg
TGP-10	300 kg
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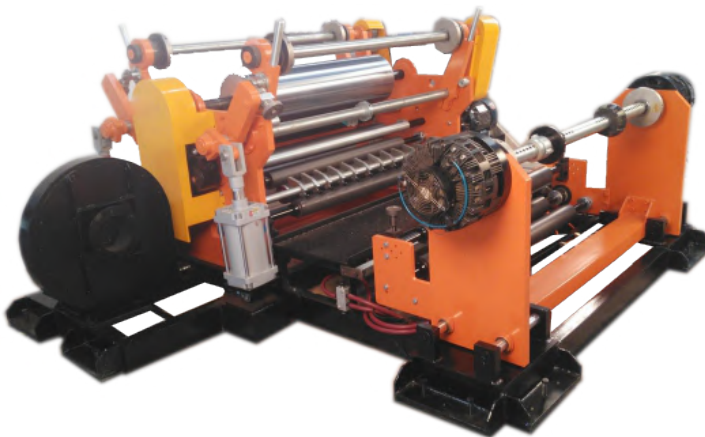
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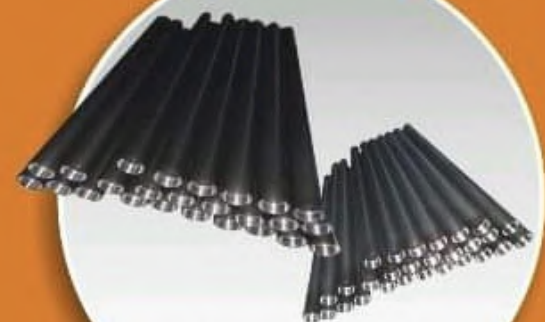
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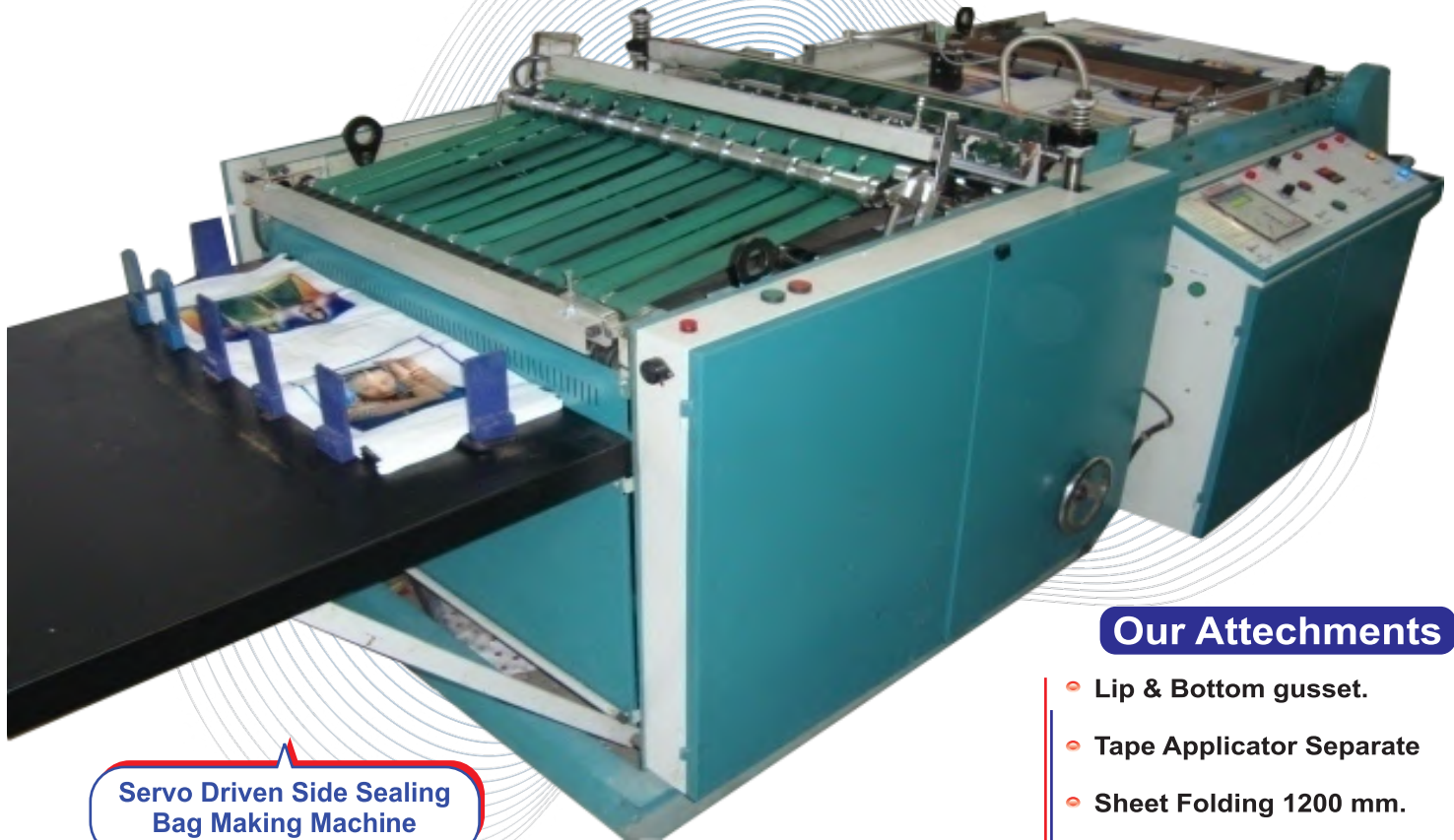
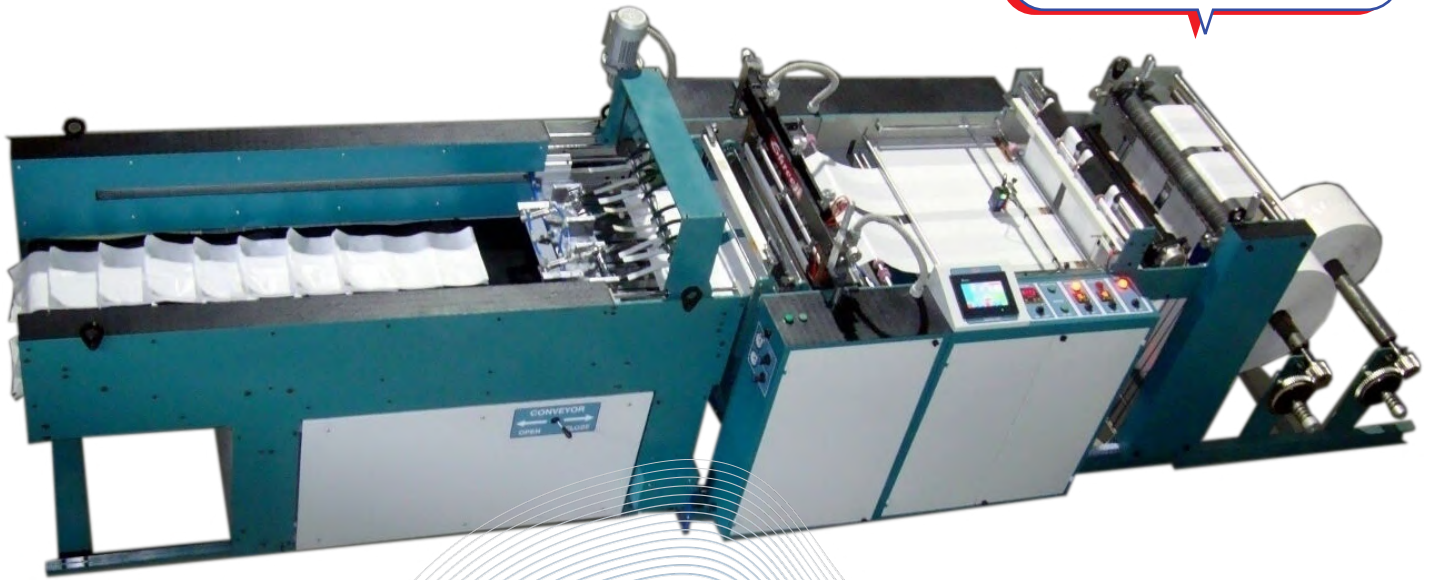
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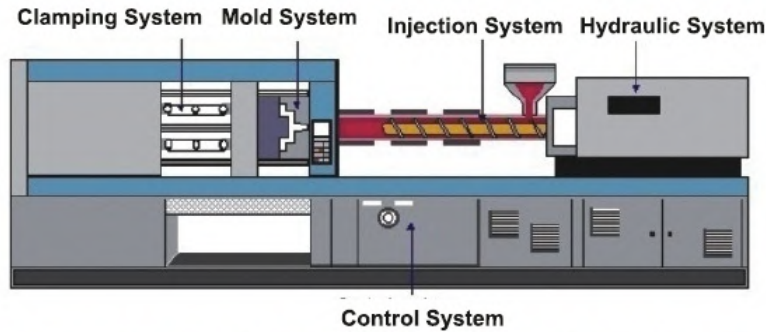
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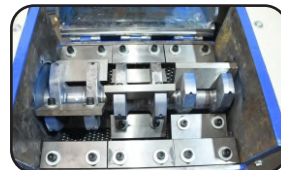
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INTRODUCING

Twin Screw Conical Extrusion

APPLICATION

**PVC profile / WPC Profile,
PVC Form Board Sheet**



■ Die Head



**Twin Screw Pipe
Extrusion**



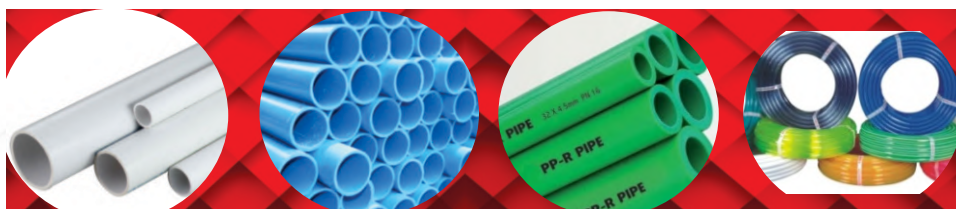
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■ Tube Auto Cutting



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■ Profile Die

Twin Screw Conical Profile Extrusion



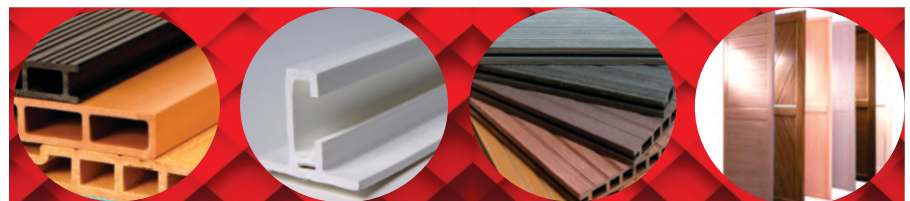
■ Vacuum Calibration Table



■ Hydraulic Haul Off



■ Profile Auto Cutter



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