



## CASE STUDY: *Cosmetic Defects with Nylon*



**\$40,000** Lifetime Savings  
**6.5%** Increase in Efficiency

### Case Study Overview

Springs Window Fashions was fighting a cosmetic flaw in a 4-cavity mold that produced a nylon 6/6 cord tilter housing for a window blind assembly. The only solution they were able to implement on the production floor was to slow down the injection rate, and they also had to frequently clean out vents and cavity faces. These 'fixes' resulted in a production loss of nearly 6.5% and a shortfall of about 972 parts every day. They knew they needed to find a better way.

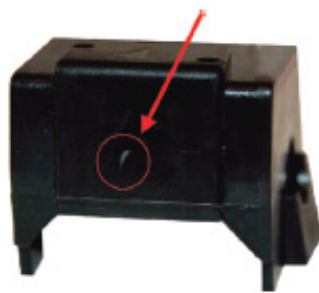
"Since we acquired MeltFlipper® technology, we only need to clean the mold at the start of each shift, which is a normal procedure," said Jim Raisbeck. "Now, our reject rate is less than 1%, but the best news of all is that we no longer get complaints about cosmetic defects from customers. We can also inject the part a little faster without any detrimental effects. As a result of these cost savings, we are in the process of incorporating Beaumont's technology into other ongoing and new projects."

### Conventional Molding Technology

Rough Surface Finish



Gas Trap

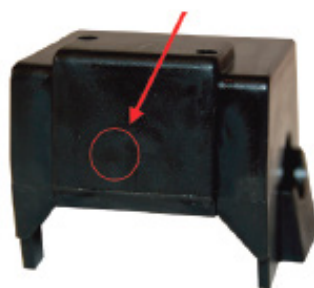


### MeltFlipper® Max™ Molding

Smooth Surface Finish



Gas Trap Eliminated



### Project Description

- 4-cavity mold
- Cord tilter housing
- Nylon 6/6

### Problems

- 5% scrap rate
- 6.5% efficiency loss
- Customer returns / complaints
- Undesirable surface appearance

### Benefits and Cost Savings

- \$40,000 savings during life of tool
- Eliminated customer complaints
- Reduced scrap to <1%
- Improved surface finish

"MeltFlipper® will have saved us over \$40,000, provided us with a less than 1% reject rate, a 6.5% efficiency increase, and no more customer complaints." -Jim Raisbeck, Engineer & Manager