

Beaumont

Revolutionizing Injection Molding



MeltFlipper® saves Avaya \$133K annually in operating costs

“MeltFlipper® Technology provided Avaya a cost reduction, a larger processing window, and quality improvements”

-Jay VanRoy, Process Engineer, Avaya, Inc.

As a supplier of telecommunication products, Avaya normally builds multiple low-cavitation molds to help minimize part quality problems associated with higher cavitation molds. This results in higher operation and equipment costs, including inherent variations from running multiple molds in different machines operated by different processors.



As a cost savings initiative, process engineer Jay VanRoy

decided to test MeltFlipper® by building a 16-cavity production mold with two runner bars — one with MeltFlipper® and the other without. The mold produced a small, thin-walled connector weighing only 0.13 grams (Figure 1).

Pressure transducers were located in one inside and one outside cavity. By comparing the pressure traces from the molds with and without MeltFlipper®, it was determined that the MeltFlipper® runner system provided a more consistent pressure within the inside and outside cavities. In addition, the standard deviation throughout the run was significantly improved.

PROJECT DESCRIPTION:

- 16-cavity production mold
- Telecommunication connector

PROBLEMS:

- Low cavitation
 - a. Increased production & equipment costs
 - b. Multiple molds require multiple machines
- High cavitation
 - a. Large imbalance
 - b. Short shots in thin features (high scrap rate)

SOLUTION:

- 16-cavity mold
- MeltFlipper® technology installed

BENEFITS/SAVINGS:

- \$133K annual savings based on press time only
- Shear imbalance reduced from 33% to 4%
- Lower pressures and standard deviation
- Lower operating costs

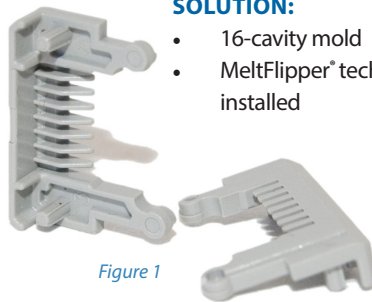


Figure 1

16 Cavity Tool Avaya Inc., RJG Inc.	Peak Pressure/Std Dev	
	Inside Cavity	Outside Cavity
Natural Balance	2509.8/99.348	2321.6/84.795
MeltFlipper	2079.2/54.261	2150.6/57.848

Summary of the peak pressure & standard deviation

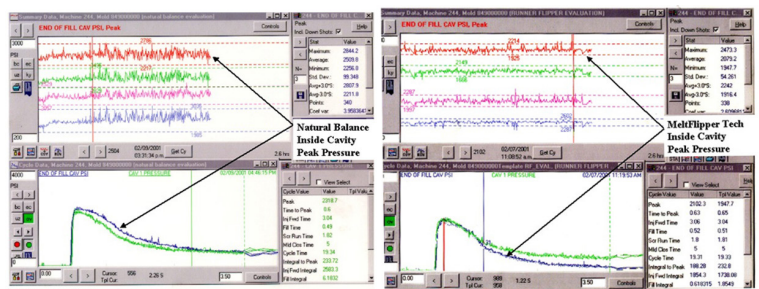


Figure 2: Pressure Trace without Meltflipper®

Figure 2: Pressure Trace with Meltflipper®

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