

## BLOW MOULDING

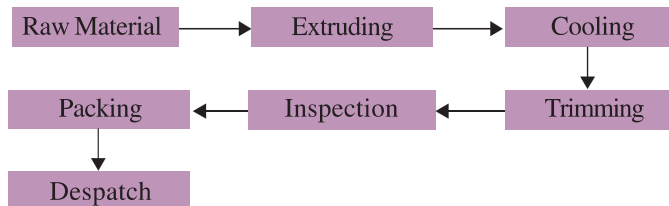


**Production capacity/annum** 150 Thousand kg.

### Production process

Plastic material in the form of granules are subjected to heat and pressure in an extruder and the semi-molten plastic is extruded through the nozzle in the form of hollow tube known as parison. Adjustments have been provided in the machine to vary wall thickness of the parison. Suitable parison is then inserted in a female mould and air blow into parison to force it against the sides of the mould. The material is then cooled before removal from the mould. The article is then trimmed to remove flashes.

### Process flow chart



### Machinery & equipment required

- Automatic extrusion blow moulding machine
- Semi automatic blow moulding machine
- Pedestal grinder
- Bench drilling machine
- Air Compressor
- Water pumps

### Raw material/consumables required

- HDPE
- Poly Propylene
- PVC

### Utilities required

|                                   |   |                     |
|-----------------------------------|---|---------------------|
| Power required (load)             | : | 24 K.W.             |
| Water required (per shift basis)  | : | 30 Liters           |
| Compressed Air ( per shift basis) | : | 120 at 8 Kg./sq.cm. |

### Manpower required

|                     |   |        |
|---------------------|---|--------|
| • Engineer          | : | 1 No.  |
| • Skilled Workers   | : | 2 Nos. |
| • Unskilled Workers | : | 4 Nos. |

### Area required

|              |   |              |
|--------------|---|--------------|
| Total Area   | : | 250 Sq. Mtr. |
| Covered Area | : | 200 Sq. Mtr. |

### Investment required

|  |   |               |
|--|---|---------------|
| Machinery & Equipment  | } | ₹ 71.04 Lakhs |
| Working Capital for 3 Months<br>(Raw material, utilities & salary) |   |               |

