

Scrap Economics for Auto Seal Extrusion

Starrett-Bytewise...leading the way with on-line profile inspection for rubber extrusions

On-Line monitoring with Profile360 will alarm immediately when there is a dimension change, so you can reduce your cost of scrap.

Profile360 users make faster startups too, another way to reduce scrap

Causes of Scrap:

- Viscous Modulus
- Elastic Modulus
- Die Swell
- Heat History
- Mix Dispersion
- Die Flow Balance
- Screen Contamination
- Feed Interruption
- Screw Speed
- Ratio Control
- Barrel and Screw Temperature
- Puller Speed
- Air Inflation Pressure
- Vulcanizing Temperature
- Mechanical Guides

Cost of Scrap (Materials Only):

- Compound Cost = \$2.97/kg
- Profile Weight = .37 kg/m
- Extruder Speed = 21.3 m/min
- Annual Production = 21.3 m/min x 60 min/hr x 20 hr/day x 350 day/yr = approximately 8,961,120 m/yr
- 1% scrap = 89,611 m x .38 kg/m x 2.97 \$/kg = \$101,250/yr
- 5% scrap = \$506,250/yr
- Scrap per hour = 21.3 m/min x 60 min/hr x .38 kg/m x \$2.97 \$/kg = \$1417/hr
- Profile360 purchase price = \$40,000
- Target savings = 1 hour per week
- Payback period = \$40000/\$1417 wk = 29 weeks



Contact

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If you can reduce scrap by 1 hour per week, you can achieve a payback in 29 weeks, based on raw materials cost avoidance alone, not to mention the cost of customer returns.