the molding foreman that an increase in mold temperature would probably enable them to run on an even faster cycle but because of the heavy production schedule, additional cycle and temperature changes were not attempted. Mr. Janicki reported that December 1964 had been one of the busiest months in Cutler's history.

The Co-Mer modified molding material, BXMG-1983 was also evaluated on the box test. The lab foreman and Mr. Janicki were both impressed by the fact that the box test mobility curve matched exactly the one obtained for the pilot plant batch previously evaluated. The box appearance was checked, and in all cases there was a slight indication of the smear effect which had been noted in our lab tests. Mr. Janicki indicated that this smear would cause no problem to Cutler, since all applications would be for electrical components where appearance is not critical.

The job selected for the trial was the molding of a binocular insert on a Stokes 150 ton automatic transfer press. The mold temperature was 310° F. Each shot used six 2" preforms which were automatically IR preheated to 240° F. The cure being used was 1' 8" on the competitive material Plenco 304, Flow 130.

When the BXMG-1983 was put in directly behind the Plenco material, good pieces were immediately obtained. The preform temperature was adjusted to the maximum which would still allow complete mold fill out. This temperature was found to be 240° F. When an attempt was made to reduce the cure time to one minute, blisters appeared on the molded pieces. This was the same point at which the Plenco 304 also blistered, indicating that the Co-Mer modified material was competitive in cure with the Plenco material but no better at that mold temperature. The writer felt that an increase in mold temperature would probably have given an improvement in cure speed, but again, because of the tight production schedule, the molding foreman was reluctant to risk disturbing the cycle which had been established. The press operator indicated that the BXMG-1983 molded and released well, and had good cut-off and flash release. It was interesting to note that there was a slight smear on the surface of the molded pieces, but it was no worse than the smear on the parts molded from the Plenco 304. Mr. Janicki was quite pleased with the performance of the BXMG-1983 on this job and was greatly interested in trying it out on other jobs in the shop to check the versatility claimed for it. If it continues to work well, he will probably enter an order for a full production batch. A "universal flow" material of this type, that is, one which could be used on a wide variety of jobs, would be ideal for a customer such as Cutler, since their materials storage area is quite small.

In conclusion, then, the Cutler-Hammer evaluation proved to be quite successful. The BMMA-5715 Batch 8 performed considerably better than the previous batch. Its molding latitude was greatly improved through strict control of the roll temperatures at the lowest possible level and by

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