25 years
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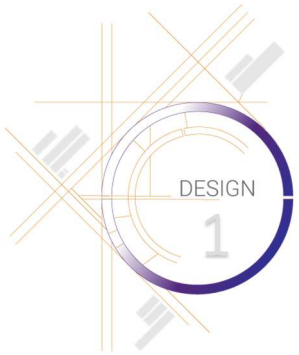
MANUNOR
Since 1993...

PRADO

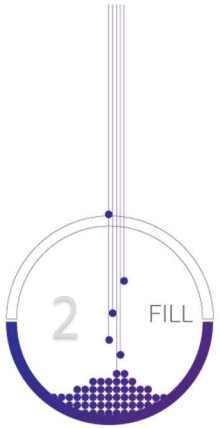
HOW IT WORKS

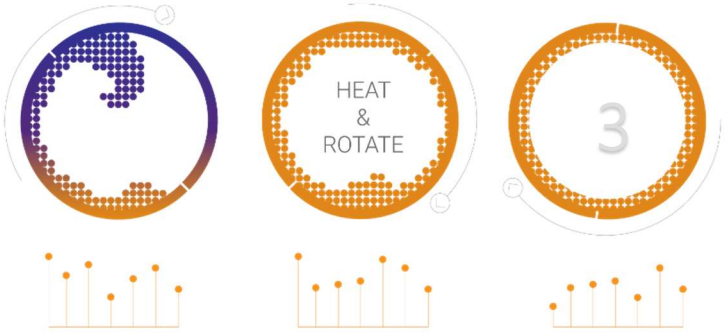
Rotomolding



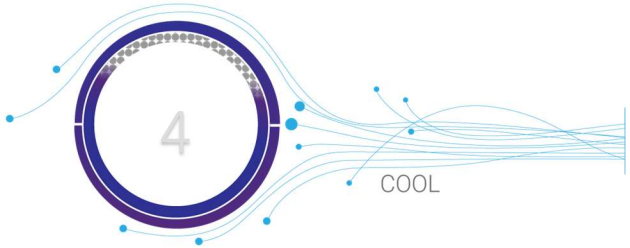
1. Great rotomolded products begin with great design. Our unique process of low stress part formation relies on material flowing around the mould and that means design has to start well before the first mould is constructed. Knowledgeable designers can use the process to add strength, function and beauty.

2. The first stage of the process is to place the material, ground into either a powder or granule form, into a hollow or shell like mould. A good rotational moulder will help you to access high quality moulds that will produce the best possible product at the end of the process.





3. Parts are rotated either on one or two axels during the process to cover the walls of the mould and create the part. These rotations can be programmed to ensure walls are thicker or thinner depending on the requirements for the end product. The material needs to be heated enough to allow any bubbles to pass through the walls and create a solid part.



4. The final stage of the process is to allow the part to come out of the mould and cool properly. Most plastic changes as it cools and controlling this part of the process can add even more strength or other features to the final product.

5. Once cooled to the optimum temperature in the mould, the rotomolded parts are taken out of the mould. Most parts will continue to cool for some time after being removed from the mould and may require being placed on special frames to ensure their final parameters are exact. At this stage value adding usually takes place and could include simple trimming to the addition of various kinds of fixtures and fitting, graphics or decoration to produce the final part.

Rotomolding Advantages

- ✓ Large and complex parts shape
- ✓ Control of wall thickness
- ✓ Single or double wall
- ✓ Several surface finishes
- ✓ Unlimited choice of color
- ✓ Recycling of plastic
- ✓ Openings at specific location in parts
- ✓ Include metallic inserts
- ✓ Relief printing on the plastic

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COMPARING WITH OTHERS PROCESS

FEATURES	ROTOMOLDING	INJECTION	THERMOFORMING
DEVELOPMENT	Short	Medium to long	Short
MOLD COST	Very low because it does not need to support pressure	High because it needs to support a lot of pressure	Low
PARTS SIZE	Small to very large	Small to Medium	Small to very large
PARTS	Hollow	Solid	Solid
PARTS SHAPE	Complex	Complex	Simple
PARTS JOINT OR WELDING	No	No	Yes
PRODUCTION VOLUME	Small or large	Large	Small or large
COOLING	Air *(energy free)*	Water	Air / Water
PRODUCTION WASTE	Very little	Very little	High