



# **RMD News**

**The Rotational Molding Division  
of SPE Newsletter**



1st Quarter 2016

Volume 16 Issue 1

ROTATIONAL MOLDING



**In the News:**  
**The North American  
Rotational Molding  
Business: Trends  
Influencing Strategies  
for Future Growth**



**In the News:**  
**Bruce Muller**  
**Honorary Board  
Member**

**SPE Rotational Molding  
TopCon**

**“Roto In Motion”  
June 5-8 2016**

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ROTATIONAL MOLDING

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## Chairman's Message



**Gary McQuay**

Greetings Fellow Rotational Molding Division Members,

2016 started out as a very exciting and busy year, and all signs indicate it will continue throughout. With TOPCON, "Roto in Motion", on the horizon, our TOPCON Chair, Larry Whittemore, has been working and planning non-stop. The speakers and presentations he has lined up will be something you won't want to miss.

ANTEC will be held in Indianapolis, Indiana, this year from May 23 to May 25. Denis Rodrigue informs us there were six rotational molding papers submitted this year, and there are only five time slots available. To me that's a good problem to have - growing pains.

April is election month for SPE officers. The voting dates are as follows:

April 4 for President Elect

April 11 for Senior Vice President

April 18 for Vice President

Information on the nominees for these posts is available on the SPE website. All voting is online this year, so show your support for our SPE and vote.

The Rotational Molding Division will again be presented the Silver Pinnacle Award at the ANTEC meeting for technical achievements and superior member outreach programs. My thanks to Larry Schneider for taking charge of submitting the application and to SPE for granting the award. This is much appreciated.

See you all at TOPCON .

### Newsletter Comments/Questions? Contact:

**Sponsorship: Russ Boyle at**  
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## Meet Our Members

### Tom Innis President at Avantech



Tom Innis is president of Avantech, a leading supplier of molds to the North American rotomolding business. Tom has been involved in the rotational molding industry for almost two decades. A graduate of the University of Wisconsin-Madison and La Universidad Ibero-Americana in Mexico City, Tom leverages his knowledge of international business, multi-lingual skills, leadership, and sales and marketing experience to help drive Avantech and the global rotomolding industry forward. In addition to his tenure in the rotational molding sector, Tom has held leadership positions in the transportation, pharmaceuticals and steel industries. A native of Madison, Wisconsin, he currently resides in the Northeast Ohio community of Chagrin Falls with his wife and daughter. In his free time he enjoys long-distance running, guitar playing, and traveling with his family.

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## In The News

# Bruce Muller Honorary Board Member



Russ Boyle presenting Honorary Board Member plaque to Bruce Muller



Bruce and Sheri Muller

Russ and Donna Boyle traveled to Palm City, Florida on December 15, 2016 and presented Bruce Muller with Honorary Board Member status on behalf of the Rotational Molding Division. This is the first time that this membership status has been given to any member of the Division.

This board member grade is given to an individual who has made significant contributions to the Division and allows him or her to participate on the Division's governing board.

Bruce joined the Society of Plastics Engineers in 1969; he is a founding member of the Division, past Division councilor, past Newsletter Sponsor/Solicitation Chairman and chaired TOPCONS for the Division in 2002, 2005, 2010, 2012 and 2014. He was a speaker at a rotational molding conference in Shanghai China in 2008. Bruce was given Fellow member grade of the Society of Plastics Engineers in 2006 and was awarded the Division's Past Presidents Award for Lifetime Contribution to the Division in 2012.



## Industry News: New PCRS Rotomolding Report

# The North American Rotational Molding Business: Trends Influencing Strategies for Future Growth

*By Peter Mooney*



Plastics Custom Research Services (PCRS) has been tracking developments in the North American rotational molding business for over two decades, researching and publishing reports roughly every 3 years since 1995. These reports bring together data relating to important trends in the nature of the business as well as in the machinery, molds, plastic materials and additives used in this unique process. PCRS also conducts a survey of rotomolders and their machinery/mold/material suppliers to gain their perspectives on trends influencing past and likely future growth.

One of the key trends studied of course is growth of the regional rotomolding business. Rotomolders today supply component parts and final products to customers in all the consumer and industrial durable goods manufacturing industries. Their sales grew strongly in the 1990s and through the 2000s. The Great Recession of 2009 interrupted that growth trajectory. However, rotomolders recovered from that setback better than alternative structural plastic part processors with whom they compete. Over the period 1994-2014 rotomolders enjoyed average annual sales growth of 5.4%. Officials in the companies surveyed report average annual sales growth of 3.7% in 2015, and they anticipate a return to the former 5.4% growth pattern out to 2020.

Restoring the former rotomolding sales growth dynamic hinges on future trends in a number of key variables. They include the following:

- growth in rotomolders' major markets and applications
- the rotomolders' infrastructure (machines, molds and labor force)
- the rotomolders' resin menu
- increasing demand for value-adding secondary operations
- labor efficiency (the employees/machine ratio)
- labor productivity (sales per employee)
- the shifting location of the population and OEM facilities
- the conversion of metal and other traditional materials to plastics
- the rotomolders' competitive position in that conversion process



Submit your news story or technical article to the RMD Newsletter !

*The submission deadline for the next addition is March 1st.*

## Industry News

Continued from Page 5

Along with opportunities to address new applications and markets there are challenges to be faced. The rotomolding process is labor-intensive, so ways must be sought to continually raise labor efficiency and productivity. The resin menu is limited compared to those of alternative structural plastic part processors, so it is incumbent on the rotomolding community to pool resources to develop additional rotomoldable commodity and engineering resin grades. Customers are demanding more value-adding secondary operations, and physical part prototyping is giving way to 3D printing to speed time to market. Rotomolders have diversified the markets they serve. Going forward they need to also diversify their processing methods in order to broaden their customer base.

The Projected Size of the  
Regional Rotomolding Business, 2015-2020  
(\$ billion)



For more information please contact Peter Mooney at PCRS via phone (336 998-8004) or email ([plasres@AOL.com](mailto:plasres@AOL.com))

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**ROTATIONAL MOLDING**

## Industry News



# Rotational Molding

June 5-8, 2016  
Holiday Inn Conference Center  
Independence, Ohio (Cleveland South)

## 2016

Creating Your Future in Rotational Molding

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### Questions?

Larry Whittemore  
lwhittemore@stonersolutions.com  
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## Industry News

### "Roto in Motion"



# Rotational Molding

June 5-8, 2016

Optional Plant Tour: June 8

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## Industry News

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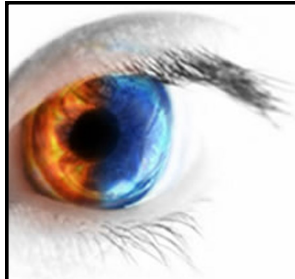
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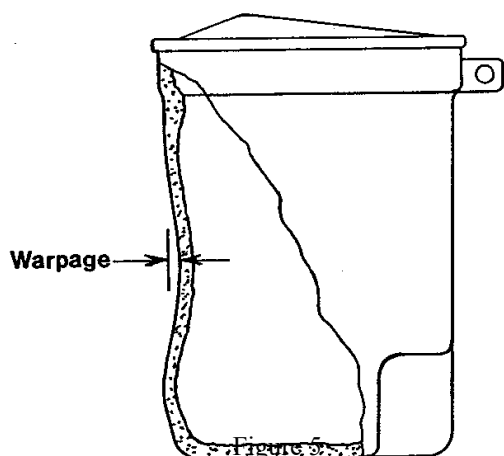


# WARPAGE CONSIDERATIONS

By: Glenn Beall

### Editor's Note:

This is the fourth in a series of twenty-six articles that will review how to design rotationally molded plastics parts and products. We look forward to publishing these articles over many issues. This is a great opportunity for newcomers to the community as well as an always appreciated chance for review of important information.



Rotationally molded parts are produced in hollow molds without cores. The inside surfaces of the parts are free-formed in this open molding process. During the cooling portion of the molding process the plastic material contracts or shrinks. Shrinkage of these hollow parts allows them to pull away from the cavity before the material has cooled enough to be strong enough to retain its shape. This condition encourages large, flat surfaces to warp as shown in Figure 5.

This type of warpage comes as a surprise to engineers who are accustomed to designing parts for closed-molding processes such as injection molding, structural foam, and reaction injection molding. Engineers who are not familiar with rotational molding can be guided by following the industry recommended flat panel warpage standards listed in Table 2.

**TABLE 2 Flat-Panel Warpage Standards for Commonly Molded Materials**  
in  $\pm$ cm/cm and in./in.

Plastic Material	Ideal	Commercial	Precision
PE	0.050	0.020	0.010
PP	0.050	0.020	0.010
PVC	0.050	0.020	0.010
Nylon	0.010	0.005	0.003
PC	0.010	0.005	0.003

The "ideal" warpage standard can normally be achieved with no additional cost. The "commercial" standard requires special care and may or may not result in a longer molding cycle and added cost. The "precision" standard will almost always be the most costly of the three ranges. The best design is, therefore, the one that can accommodate to "ideal" warpage standard.

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## Designer's Corner

Continued from Page 11

Shrinkage-related warpage can be significantly reduced or eliminated by pressurizing a hollow part during the cooling part of the molding cycle. This internal pressure forces the part to cool while being held in contact with the cavity. Forcing the part into contact with the cool cavity has the added benefit of reducing the time required to cool the part. Cooling with internal pressure also reduces part-to-part dimensional variations. The use of pressurized air or inert gas has many benefits, but not all molding machines are equipped for this type of molding.

A simpler approach to discouraging the warpage of large, flat surfaces is to avoid designs of that type. If flat surfaces cannot be eliminated, they can be strengthened to resist warpage with the use of stiffening ribs, steps, crowns, and domes as illustrated in Figure 6. In this case a large, round, flat-topped tank has been redesigned to resist warpage. A dome as small as 0.015 cm/cm (0.015 in./in.) is enough to discourage warpage, but the larger the doming or crowning, the less warpage there will be.

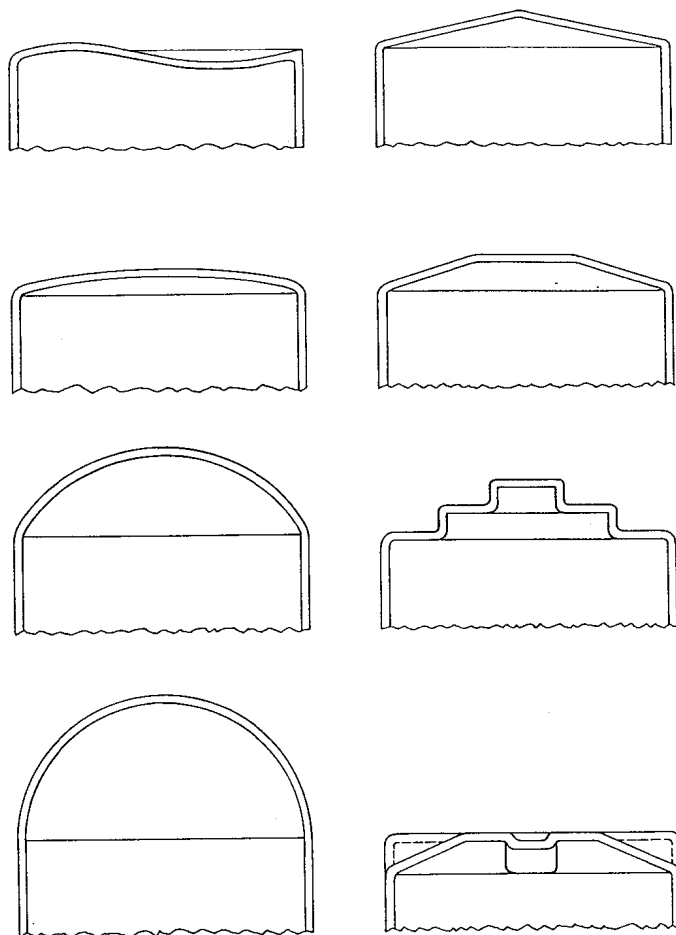


Figure 6

Glossy surfaces that reflect light, exaggerate the appearance of a warped surface. Deeply textured surfaces do not reflect light and this makes warpage less noticeable. Incorporating a graphic or engraving on a flat surface has the same effect.



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| <input type="checkbox"/> Alabama/Georgia-Southern<br><input type="checkbox"/> Asean*<br><input type="checkbox"/> Australia-New Zealand<br><input type="checkbox"/> Benelux<br><input type="checkbox"/> Brazil<br><input type="checkbox"/> California-Golden Gate<br><input type="checkbox"/> California-Southern California<br><input type="checkbox"/> Caribbean<br><input type="checkbox"/> Carolinas<br><input type="checkbox"/> Central Europe<br><input type="checkbox"/> China<br><input type="checkbox"/> Colorado-Rocky Mountain<br><input type="checkbox"/> Connecticut<br><input type="checkbox"/> Eastern New England<br><input type="checkbox"/> France<br><input type="checkbox"/> Hong Kong<br><input type="checkbox"/> Illinois-Chicago<br><input type="checkbox"/> India<br><input type="checkbox"/> Indiana-Central Indiana<br><input type="checkbox"/> Israel<br><input type="checkbox"/> Italy<br><input type="checkbox"/> Japan<br><input type="checkbox"/> Kansas City<br><input type="checkbox"/> Korea<br><input type="checkbox"/> Louisiana-Gulf South Central<br><input type="checkbox"/> Mexico-Centro<br><input type="checkbox"/> Michigan-Detroit<br><input type="checkbox"/> Michigan-Western Michigan<br><input type="checkbox"/> Middle East<br><input type="checkbox"/> Nebraska<br><input type="checkbox"/> New Jersey-Palisades<br><input type="checkbox"/> New York<br><input type="checkbox"/> North Carolina-Piedmont Coastal | <input type="checkbox"/> Ohio-Akron<br><input type="checkbox"/> Ohio-Cleveland<br><input type="checkbox"/> Ohio-Miami Valley<br><input type="checkbox"/> Ohio-Toledo<br><input type="checkbox"/> Oklahoma<br><input type="checkbox"/> Ontario<br><input type="checkbox"/> Oregon-Columbia River<br><input type="checkbox"/> Pennsylvania-Lehigh Valley<br><input type="checkbox"/> Pennsylvania-Northwestern Pennsylvania<br><input type="checkbox"/> Pennsylvania-Philadelphia<br><input type="checkbox"/> Pennsylvania-Pittsburgh<br><input type="checkbox"/> Pennsylvania-Susquehanna<br><input type="checkbox"/> Portugal<br><input type="checkbox"/> Quebec<br><input type="checkbox"/> Spain<br><input type="checkbox"/> Taiwan<br><input type="checkbox"/> Tennessee-Smoky Mountain<br><input type="checkbox"/> Tennessee Valley<br><input type="checkbox"/> Texas-Central Texas<br><input type="checkbox"/> Texas-Lower Rio Grande Valley<br><input type="checkbox"/> Texas-North Texas<br><input type="checkbox"/> Texas-South Texas<br><input type="checkbox"/> Tri-State<br><input type="checkbox"/> Turkey<br><input type="checkbox"/> United Kingdom & Ireland<br><input type="checkbox"/> Upper Midwest<br><input type="checkbox"/> Utah-Great Salt Lake<br><input type="checkbox"/> Virginia<br><input type="checkbox"/> Washington-Pacific Northwest<br><input type="checkbox"/> West Virginia-Southeastern Ohio<br><input type="checkbox"/> Western New England<br><input type="checkbox"/> Wisconsin-Milwaukee |
|--|--|

\*Asean: Indonesia, Malaysia, Philippines, Singapore, Thailand, Cambodia, Laos & Vietnam

Special Interest Groups - Explore emerging science, technologies and practices shaping the plastics industry. Choose as many as you would like, at no charge.

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|---|--|
| <input type="checkbox"/> Additive Manufacturing / 3D Printing - 033<br><input type="checkbox"/> Advanced Energy Storage - 024<br><input type="checkbox"/> Alloys & Blends - 010<br><input type="checkbox"/> Bioplastics - 028<br><input type="checkbox"/> Failure Analysis & Prevention - 002<br><input type="checkbox"/> Joining of Plastics & Composites - 012<br><input type="checkbox"/> Marketing & Management - 029<br><input type="checkbox"/> Non-Halogen Flame Retardant Tech. - 030 | <input type="checkbox"/> Plastic Pipe & Fittings - 021<br><input type="checkbox"/> Plastics Educators - 018<br><input type="checkbox"/> Plastic in Building and Construction - 027<br><input type="checkbox"/> Quality/Continuous Improvement - 005<br><input type="checkbox"/> Radiation Processing of Polymers - 019<br><input type="checkbox"/> Reaction Injection Molding - 032<br><input type="checkbox"/> Thermoplastic Elastomers - 006 |
|---|--|

Recommended by (optional) \_\_\_\_\_ ID# \_\_\_\_\_

PE15



## RMD Interim Financial Report

SPE's Rotational Molding Division  
Annual Financial Report 2014-2015  
July 1, 2014 to June 30, 2015

	<u>Actual</u> <u>(proposed)</u>	<u>Budget</u>
<b>Cash Balance:</b> Beginning of Period	\$44,687.94	
<b>Cash Receipts in Period:</b>		
SPE Rebate	\$890.64	
Interest	\$49.48	
Newsletter Ads/Sponsorships	\$0	
Scholarships/Grants Fund		
TopCon (TopCon 2014)	\$35,473.77	
Total Income in Period	\$36,413.89	
Total Cash to be accounted for	\$81,101.83	
<b>Cash Disbursements in Period:</b>		
Board Meetings	\$265.81	
TopCon (TopCon 2014)	\$500.00	
e-Newsletter Printing/Mailing	\$0.00	
Awards (Student Papers)	\$0.00	
Scholarships/Grants	\$0.00	
ANTEC Expenses	\$0.00	
Postage	\$45.14	
Awards	\$1023.98	
Memorial	\$331.01	
Website `	\$2799.88	
IDSA	\$1000.00	
Donation—Plastics Pioneers	\$500	
Website Domain name (2013-2022)	\$	
Webinar	\$0.00	
MISC (ARM booth	\$738.83	
Bank Fees		
\$23.48		
Total Disbursements in Period	\$7228.13	
Cash Balance End of Period	\$73,873.70	

The Cash Balance is made up as follows:

Scholarships/Grants (savings acc.)	\$0
Checking Account	\$5,246.83
Savings Account	\$68,626.87
<b>Total Cash Balance</b>	<b>\$73,873.70</b>

Respectfully submitted  
By Russ Boyle

### SPE's **Digitized Presentations**

are multimedia recordings of past e-Live™ Presentations. Available for purchase on CD-ROM, they include presentations on more than 15 different plastics processes. Past e-Live™ Presentations are archived weekly. Go <http://www.4spe.org/elearning/> for more information.



**Interested in sponsoring the RMD Newsletter?**  
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**Russ Boyle at**  
**[Russ.boyle@gulfviewplastics.com](mailto:Russ.boyle@gulfviewplastics.com)** or call at (727) 379-3072



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Past Division Chairman  
2001-2002  
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Barry Aubrey	2000-2001	Ken Wessler	2006-2007
Jon Ratzlaff	2001-2002	Michael Paloian	2007-2008
Marshall Lampson	2002-2003	Greg Stout	2008-2009
Ken Pawlak	2003-2004	C. "Hank" White	2009-2012
Larry Schneider	2004-2005	Rob Donaldson	2012-2015

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Past Division Chairman  
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The Rotational Molding Division would like to acknowledge and thank the following organizations that share their resources with the RMD by allowing and encouraging their employees to serve as members of the RMD Board of Directors.

