

## B. In-Mold Label system



Consider to apply to IML system?  
Packaging is key factor in increasing productivity.  
It contributes to customer's profit by optimized cycle time & improved labeling.

High technical Y-PAC partners provide more economical IML system for increasing productivity.

\* Y-PAC : brand name of YUDO Packaging solution.

**Y-PAC**  
Packaging solution

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### c. The example of IML application

Item	Before	After	Remarks
Type of attaching Label	Sticker Type	IML Type	
Product	Lid – Ice cream (Large size)		-
I.M.M	220TON		-
Cavity	6	6	0
All cycle time(sec)	18	6	-12
Weight (g)	16.5	13.5	-3
Resin	PP	PP	
Resin Price/1ea(KWON)	23.1	18.9	-4.2
Material of Label	Paper	PP, PE	
Label price/ea	17	8	-9
The cost of labor /ea (KWON)	2.31	0	-2.31
Production /day (ea)	28,800	86,400	<b>+57,600</b>
Inferior rate (%)	10%	2%	<b>-8%</b>
Finished production output per day (ea)	25,920	84,672	<b>+58,752</b>
Production /year (ea)	7,776,000	25,401,600	<b>+17,625,600</b>
Product cost/1ea(KWON)	42.4	26.9	<b>-15.51</b>
<b>* Increasing Production</b>			<b>327%</b>
<b>* Reducing Production cost</b>			<b>37%</b>

## B. In-Mold Label System

### e. Check List

#### (1) General specifications

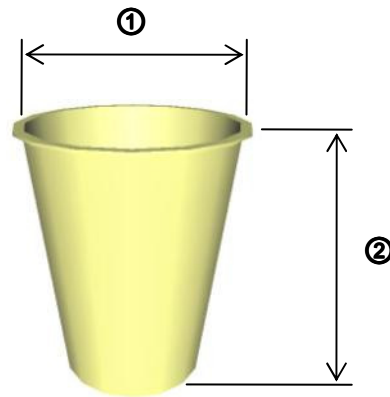
General Specifications					
<b>Date</b>			<b>Consultant</b>		
<b>Customer</b>			<b>Product name</b>		
<b>Part Spec.</b>	Weight	g	<b>Resin</b>	Brand and grade	
	Cavity			Melt flow rate	
	Outer size	mm	<b>Check</b>	Product sample	
	Wall of Thickness	μm		Label sample	
	All cycle Time	sec		Product drawings	
	Take-out Time	sec		Mold drawings	
	Product rate	ea/hr		Film drawings	
<b>Label</b>	Material		IMM drawings		
	Thickness	μm	Power source	AC V phases	
<b>Item</b>					
<input type="checkbox"/> I.M.M <input type="checkbox"/> IML Robot <input type="checkbox"/> Mold <input type="checkbox"/> Film <input type="checkbox"/> Chiller <input type="checkbox"/> Hot runner <input type="checkbox"/> Auxiliary Equipments					
<b>Remarks</b>					

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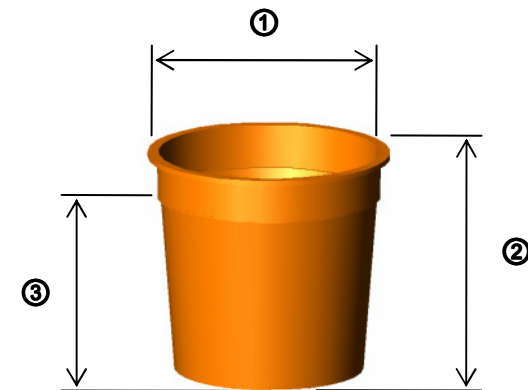
e. Check List

(2) Product check list – Cup / Lid / Container

□ Type A



□ Type B



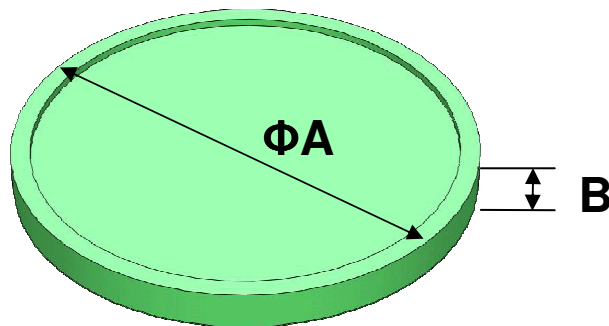
Product Dimension (mm)			
No.	Division	Size	Remarks
①	Upper Diameter	mm	
②	Height 1	mm	
③	Height 2	mm	
	Taper angle		Upper 4 degree

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e. Check List

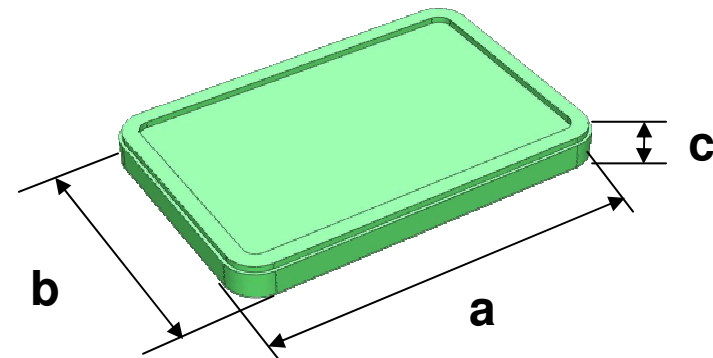
(2) Product check list – Cup / Lid / Container

□ A round shape



Product Dimension (mm)		
No.	Division	Size
A	Diameter	mm
B	Height	mm

□ A square shape

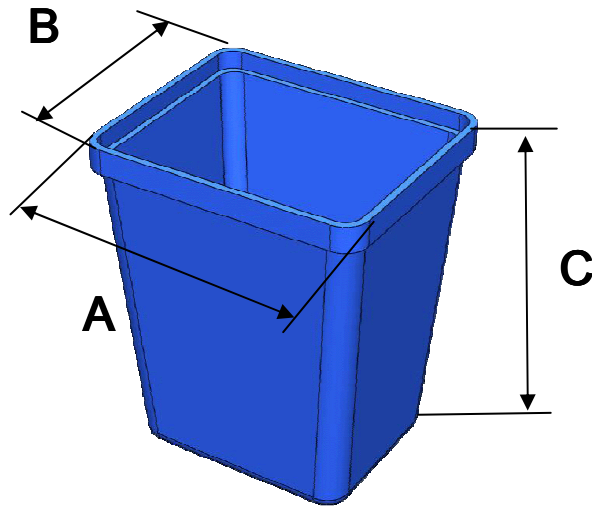


Product Dimension (mm)		
No.	Division	Size
a	Length	mm
b	Width	mm
c	Height	mm

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e. Check List

(2) Product check list – Cup / Lid / Container



Product Dimension (mm)		
No.	Division	Size
A	Length	mm
B	Width	mm
C	Height	mm

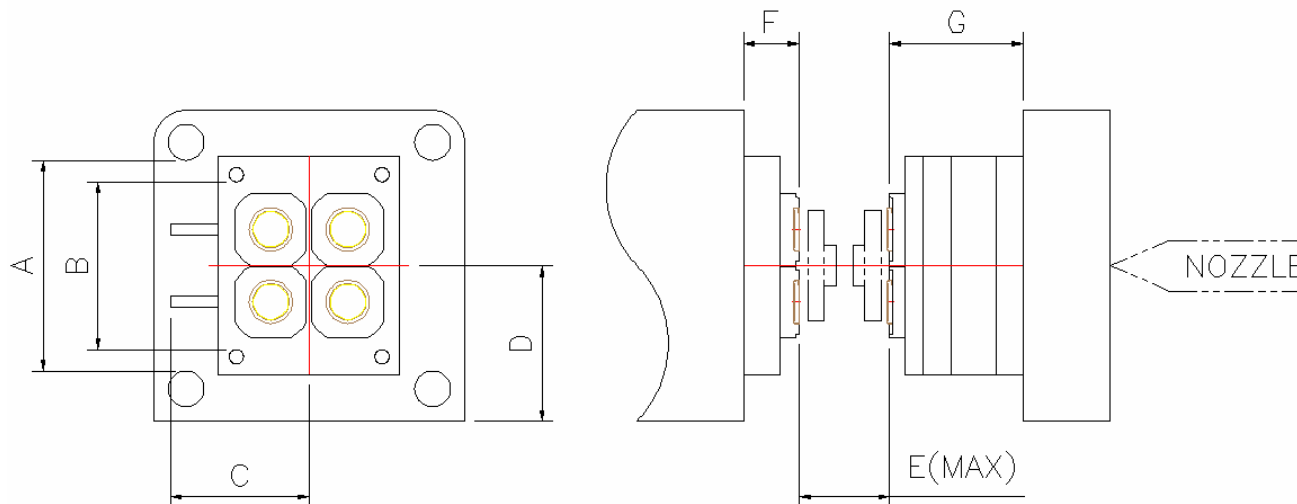
The method for Attaching Film	
3-face IML (Bottom + Front side+ Rear side)	
4-face IML (Front side + Rear side+ Left side + Right side)	
5-face IML (4 faces + Bottom)	
TWO FILM IML(4 faces + Bottom)	

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#### (3) Mold check list

No.	Division	Length	Division	Check
A	Tie bar length	mm	Product Take-out Direction	<input type="checkbox"/> Fixed side <input type="checkbox"/> Moving side
B	Mold Guide pin	mm	Film Insert direction	<input type="checkbox"/> Fixed side <input type="checkbox"/> Moving side
C	Manifold	mm	Fixing method of Film	<input type="checkbox"/> Vacuum <input type="checkbox"/> Static charge <input type="checkbox"/> Other
D	Center	mm	Cavity Matrix	ea(Width) X ea(Height)
E	Mold Open Stroke	mm	Cavity Pitch(Height)	mm
F	Moving side Depth	mm	Cavity Pitch(Width)	mm
G	Fixed side Depth	mm		
	Mold Thickness	mm		



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### e. Check List

#### (4) I.M.M check list

Division		Specification
Injection pressure		ton
Machine Maker		
A	Door of anti-operation side	mm
B	Plate of anti-operation side	mm
C	Inside interval of Tie-Bar	mm
D	Plate size	mm
E	Plate height	mm
F	Height from the ground to the center of Nozzle	mm
G	방진구(?) height	mm
Max. Mold Open stroke		mm

