# Manufacturing of Plastic Crates

<table>
<thead>
<tr>
<th>Name of Project</th>
<th>Facility for Manufacturing of Plastic Crates</th>
</tr>
</thead>
<tbody>
<tr>
<td>Project Location</td>
<td>Gelapukhuri, Tinsukia, Assam</td>
</tr>
</tbody>
</table>
| Area Requirement| 15,000 – 20,000 sq ft (Bakery and Dairy Crate)  
                     20,000- 25,000 sq ft (Fishery Crate) |
| Approx. Project cost| Total cost :  
Machinery and Mould cost for Bakery Crate (20 L) and Dairy Crate (10-12L) : INR 106-125 lakh  
Machinery and Mould cost for Fishery Crate (80L): INR 126-157 lakh |
| Project Scale | Capacity: Production capacity per day @ 120 sec for single crate, for 22 hours  
Bakery Crate: 1,98,000 Components (annually -300 days)  
Dairy Crate: 1,98,000 Components (annually -300 days)  
Production Capacity per day for Fishery Crate @140 seconds for single crate, for 22 hours  
Fishery Crate: 1,69,500 Components (annually -300 days) |
| Process | Process Flow Chart  
PP + Colourant (Optional)  
Fixing of Mould in Machine  
Injection of Molten PP material into the mould  
Cooling and Opening of Mould  
Ejection of Component & Packing |

## Manufacturing Process

In this injection moulding process, the cold, hard plastic material is loaded into the machine via hopper, plasticized by heating and then injected under pressure into a cold mould, where it sets and is then ejected as the finished products.

The three successive main stages that are followed in the procedure of manufacturing:
- Feeding of PP raw material into the hopper
- Injection moulding process
- Finishing of the moulded product

## Utilities

For Bakery & Diary Crates:
- Electricity (Connected Load) 97 kW
- Water about 150 litre/min

For Fishery Crates:
- Electricity (Connected Load): 173 kW
- Water about 200 litre/min

Water will be circulated through fixed tank capacity is 15,000-20,000 litre

## Manpower Requirement

13 workers for 1 shift

## Nodal Agency

Assam Industrial Development Corporation (AIDC)