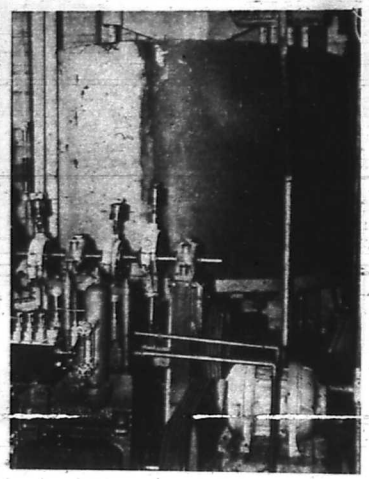
# OUR INDUSTRIAL HERITAGE — Greene Plastics Corporation

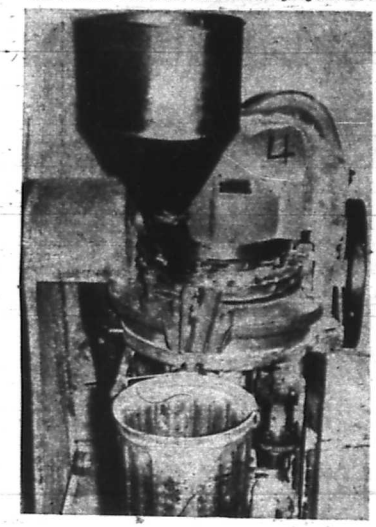
## Canonchet, Rhode Island

THIS IS A PLASTIC INJECTION MACHINE — At the top right of this machine is a supply hopper, from which a measured amount of plastic pellets fall for each injection. The plastic is heated by the central unit (over the large dial) and injected under hydraulic pressure into the mold. Mrs. John J. Thomas has opened the protective door and is removing the molded plastic from between the two parts of the mold. This machine weighs about 20,000 pounds, is water-cooled, automatic in operation, and is the largest piece of equipment at Greene Plastics. Next to Mrs. Thomas is her degating table and regrinding machine.

DEGATING — After a piece of plastic has been molded it must be separated from the runners. This is called degating. Mrs. Thomas is making necklace beads, which she removes with a felt roller. The runners are then reground for reuse.

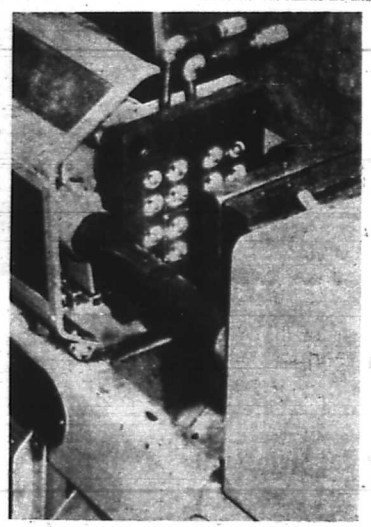


CENTRAL PRESSURE SUPPLY — Located in an outbuilding is the hydraulic accumulator. The smaller and more efficient pump in the foreground has replaced the pistons and shaft in the rear. Hydraulic fluid is pumped into a reservoir supporting the heavy circular weight in the background. When demanded by the compression molding machines in the plant, the heavy weight produces a pressure of 3000 pounds per square inch. Used hydraulic fluid comes back to the pump by a return line.

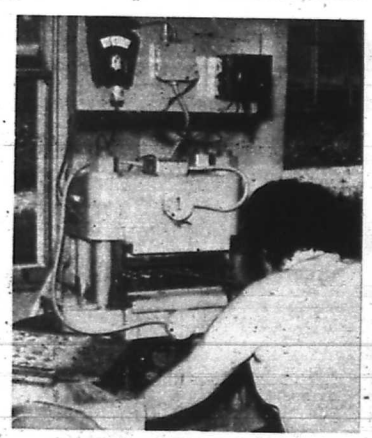


PREPARING PLASTIC FOR COMPRESSION (left) — The plastic used in compression molding starts as a fine powder, with color added when necessary. It must be made into a pill of a certain size and thickness, depending upon the individual job specification. This machine feeds the powder onto a horizontal wheel, into small holes where the powder is compressed, and ejects the tablet into the waiting pail.

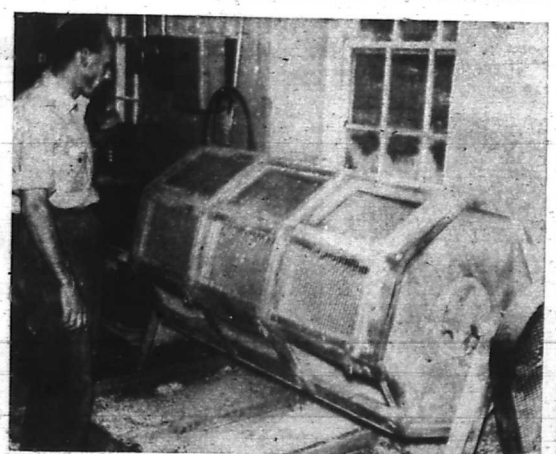
A PLASTIC MOLD IN CLOSE-UP (right) — A plastic mold is a precision-made piece of equipment. The two sections must match perfectly and remain free from any form of corrosion. Each die in the mold is chrome plated. The channels connecting the individual dies indicates that this mold is made for use in the plastic injection process.



A BANK OF COMPRESSION MOLDERS — Molding plastic by compression uses preformed pellets, which are heated to about 340 degrees temperature for 45 seconds at 3000 pounds pressure per square inch. Operating these molders are (front to rear) Mrs. Antonio Cinquegrana, Mrs. Pasquale D'ambriso, James Wedesweiler and Victor DeLoge. (Photo by LaGrua)



CLEARING THE MOLD — Following a molding operation, Mrs. Rudolph Raitano blows the molded material off of the dies and into a cloth bag hung on the back of her press. The next set of plastic pills has been dropped into holes in the wooden board to her left, enabling her to quickly and accurately drop a pellet into each mold for the next compression.



DEFLASHING — This is the process whereby excess material is removed from pieces of plastic following compression molding. Theodore R. Andrews has placed the plastics in a revolving wire-meshed drum along with wood blocks for added weight. Chips fall through the mesh, while the finished product remains inside. These small plastic parts are often polished by being spun in a drum along with a small amount of polish and wooden cobbler's nails.

BARREL AFTER BARREL OF BEADS AND BANGLES — The stock room at Greene Plastics is full of barrels, each containing plastic bags full of various types and shapes of beads. The number of beads in each bag is a matter of record. Plastic beads must be stockpiled in this manner, because most jewelry orders are on a RUSH basis. Mrs. Preston S. Salisbury is the shipping clerk at her desk behind the ladder. Assisting her (no relation) is George L. Salisbury. (Sun Photos)