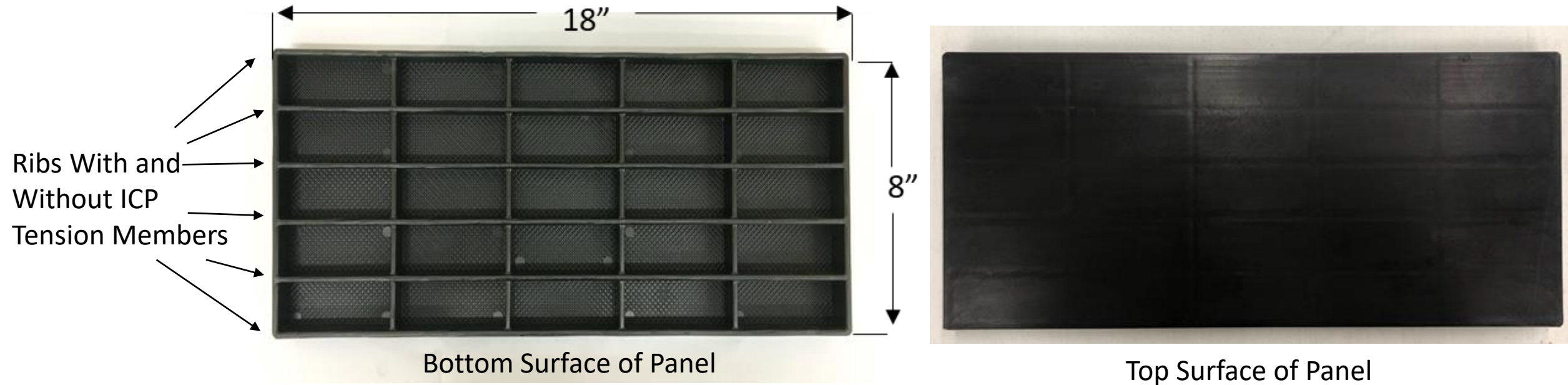


Compression Molded Knit Line Report Using ICP's TMs

Knit lines are difficult to eliminate when molding. Effort is made to design the part and material flow to have the knit lines be in the least structural area within the molded part; however this cannot always be achievable. Using ICP's AFR Tension Member (TM) technology can “Bridge” the knit line making the area stronger than the base molding material, thus improving the overall performance of the molded part.

Compression Molded Knit Line Report Using ICP's TMs

Compression Molded ICP 8x18 Panel Mold



ICP Test Plaque (Compression Molded):

Length – 18 Inches

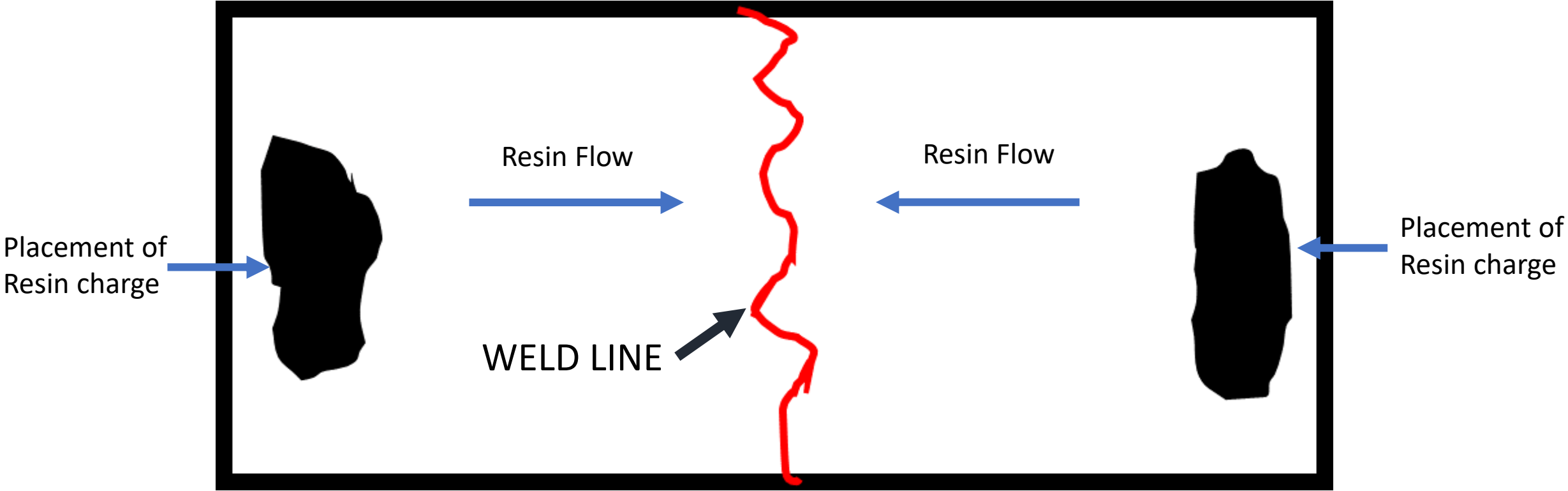
Width – 8 Inches

Height – 1.0 Inches

Top Wall Thickness - .120 Inches

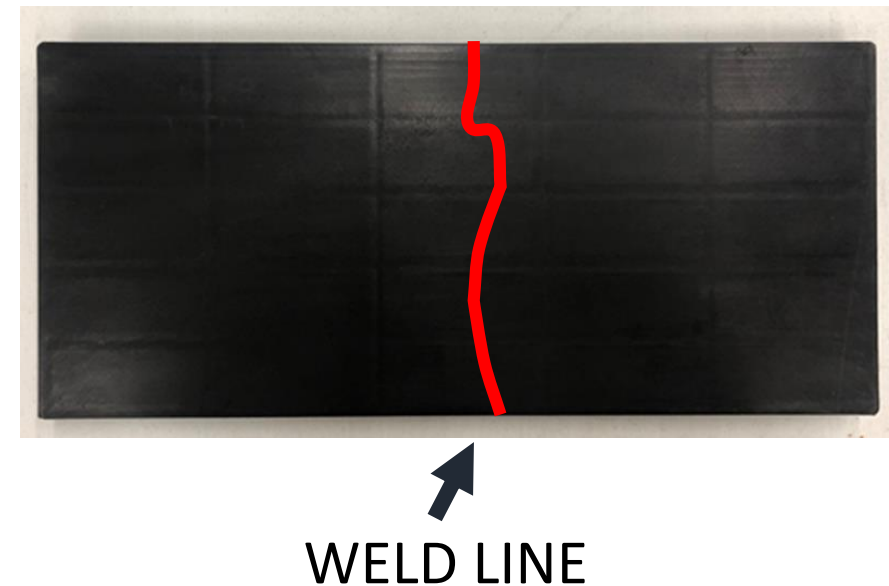
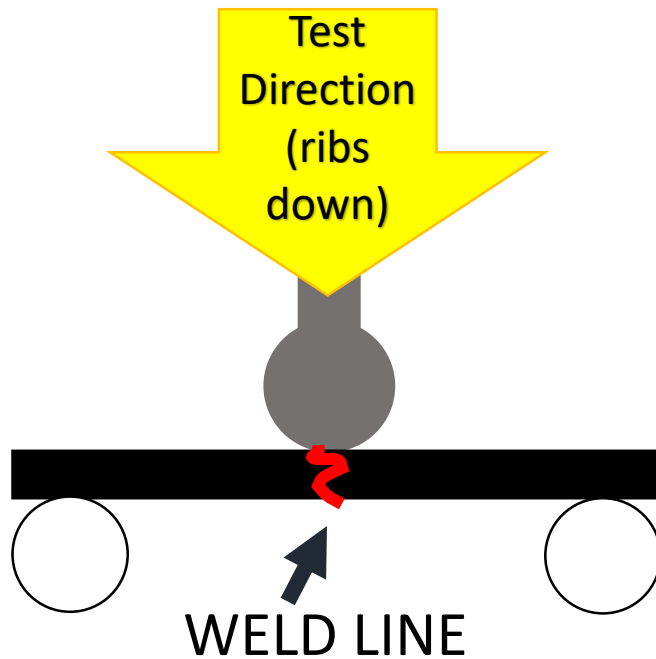
Compression Molded Knit Line Report Using ICP's TMs

Compression Molded ICP 8x18 Panel Mold Showing Flow and Weld Line



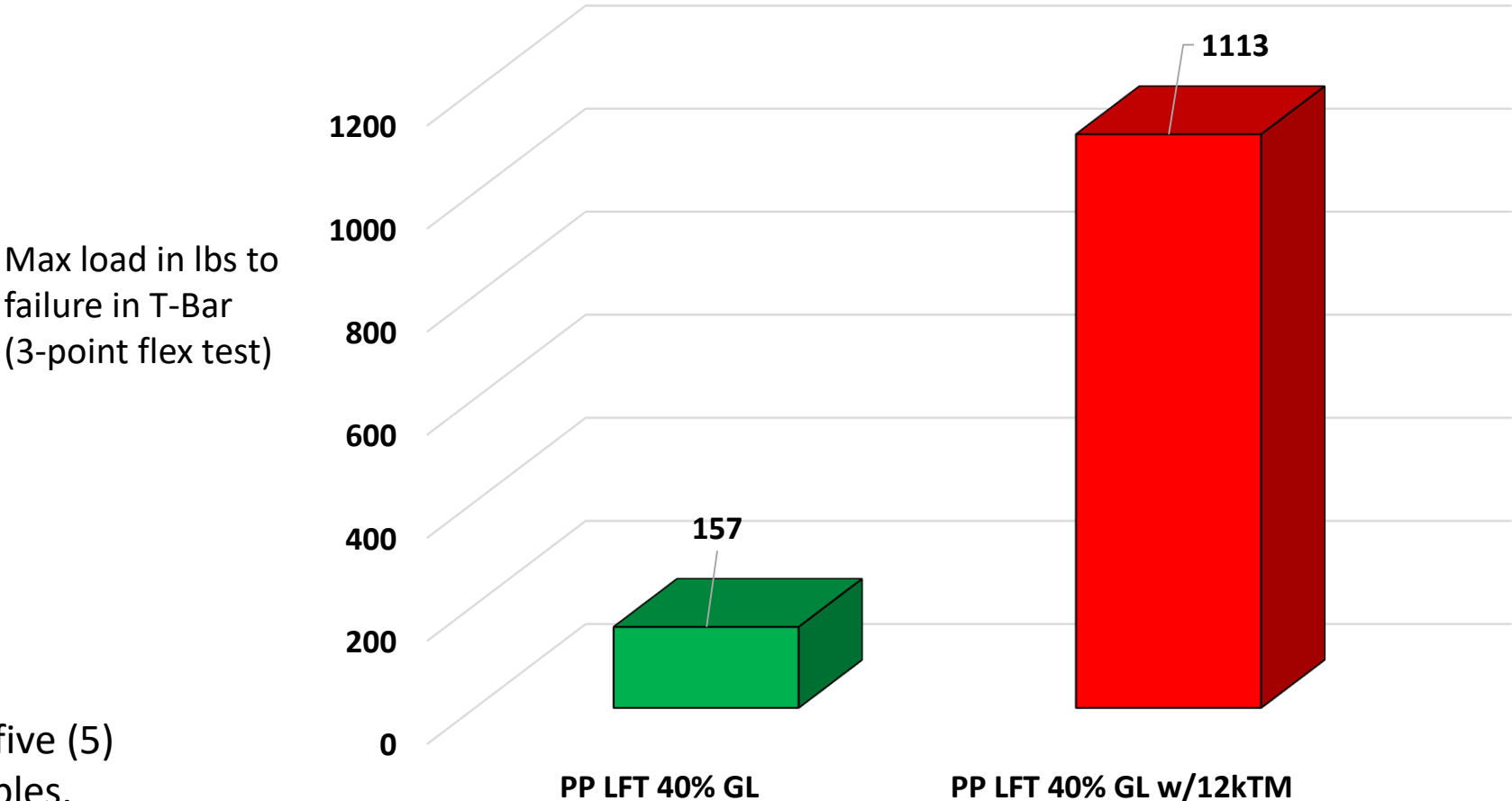
Compression Molded Knit Line Report Using ICP's TMs

Pictures showing how the testing was performed



Compression Molded Knit Line Report Using ICP's TMs

Compression Molded ICP 8x18 Test Panels Strength 3-Point Flex Testing (Ribs Down) WITH Weld-Line

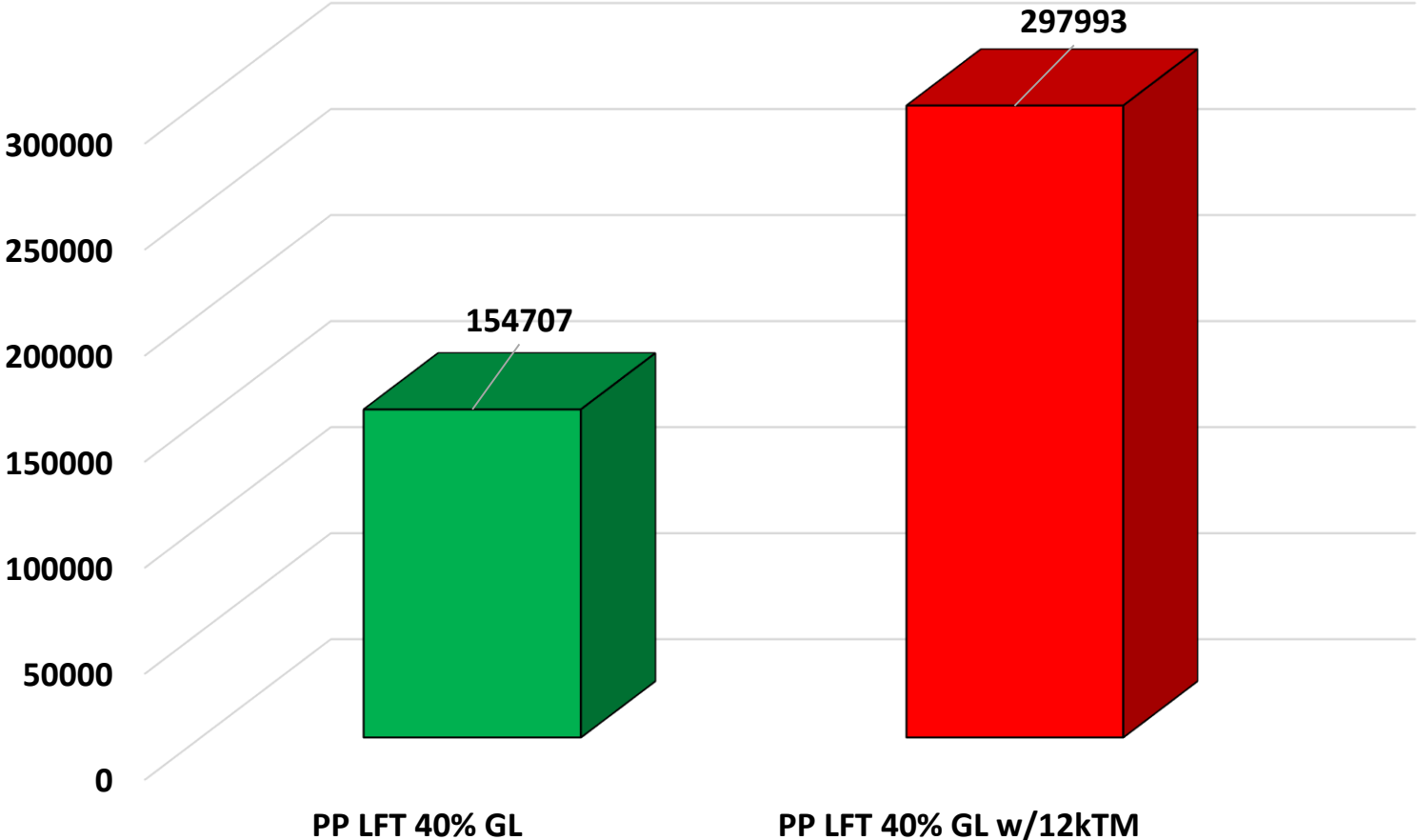


*Average of five (5) molded samples.

Compression Molded Knit Line Report Using ICP's TMs

**Compression Molded ICP 8x18 Test Panels Modulus of Elasticity
3-Point Testing (Ribs Down) WITH Weld-Line**

Modulus of Elasticity
(PSI) Comparison
(3-point flex test)



*Average of five (5) molded samples.

Compression Molded Knit Line Report Using ICP's TMs

Conclusion: Significant part performance improvement can be realized in knit line strength when incorporating ICP's Tension Member (TM) Technology. This is a great "tool" to be used in solving current molded part failures.