

COMPANY PROFILE

Marra Srl was established as a mould-maker in the early 70's and ever since, it has been involved in the production of moulds both for bulding and gas/water industry.

Today, Marra Srl can confidently be considered one of the most avant-garde mould manufacturers in the fitting industry in Europe.

Marra's workshop is equipped with the latest technological tools for the manufacturing of moulds, while its R&D technical department is to be considered one of the most advanced in the trade.

Through its exclusive technological solutions for production of fittings, Marra offers to its customers a variety of advantages when compared with the traditional moulding systems. Some of them are listed hereunder:

- ✓ thanks to their reduced dimensions, the moulds can be mounted on injection machines with lower tonnage; less time is consequently needed for demounting the moulds from the machine.
- ✓ less time is needed for substituting the interchangeable inserts because there is no need to dismantle the hydraulic cylinders.

Furthermore, our techincal solutions offer the following advantages:

- ✓ lower costs for the preservation of the moulds
- ✓ lower damage risks both for moulds and machines
- ✓ longer lasting performance of the moulds with shorter cycle times.

Since the early 90's, beside its ever-increasing success in the fitting industry, Marra Srl has been dedicating itself to the production of moulds for the automotive industry, increasing its business in this market to the extent that today it covers more than 70% of its turnover.

In this domain, the company focuses in the costruction of moulds for outer and inner automobile component parts such as Door, Side and Reinforcement panels, as well as bumper components.

In order to guarantee the highest quality and reliability to its customers, the moulds are designed, manufactured and tested exclusively in our premises.

The testing of the moulds is carried out in the commissioning department, that hosts four injection machines ranging from 250 to 2400 tons. The machines are used exclusively to the moulds commissioning.



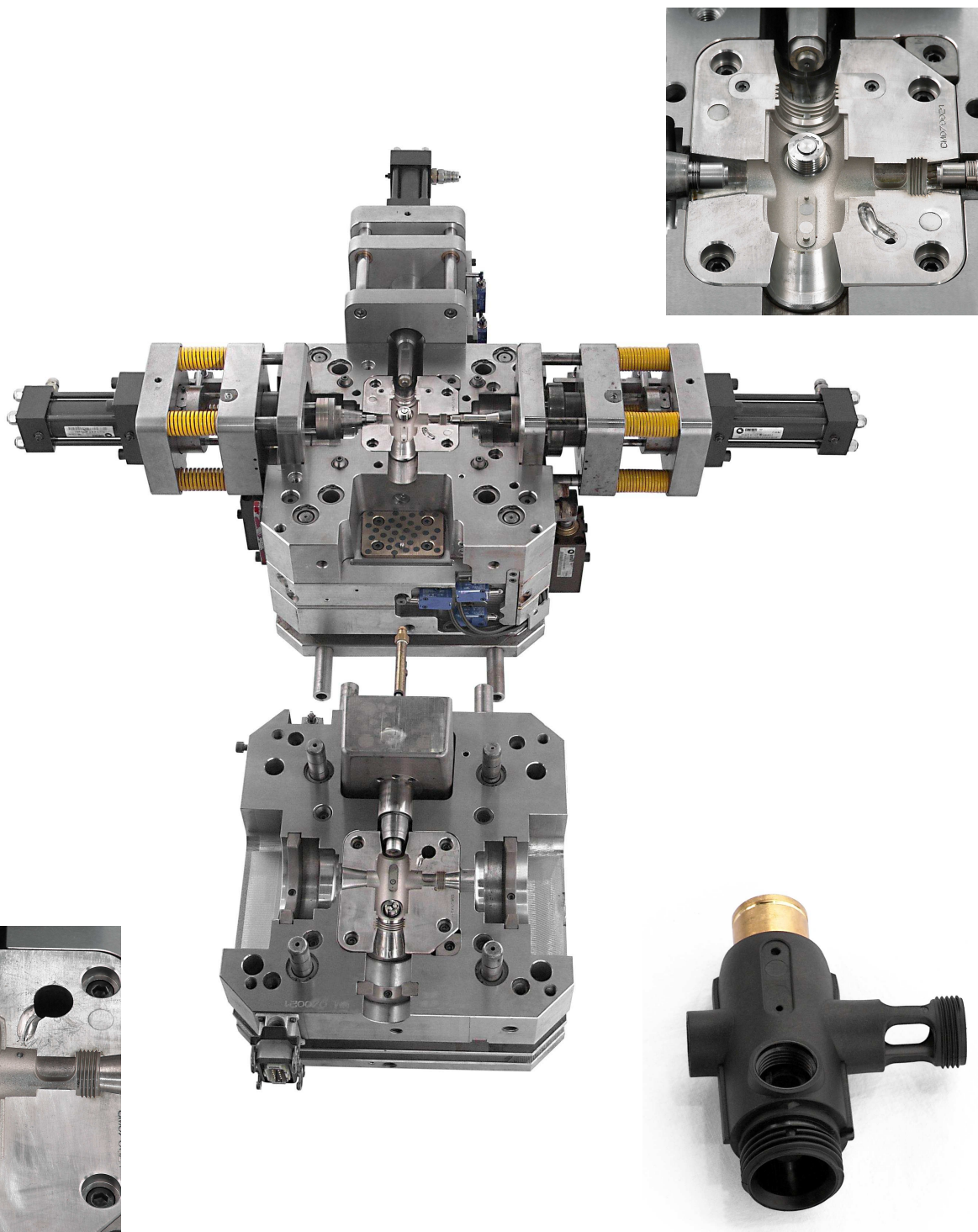
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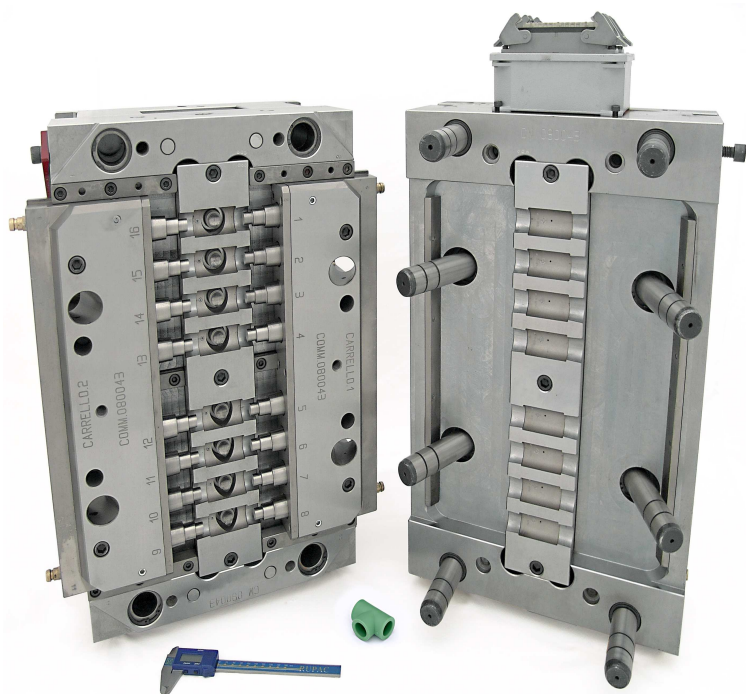
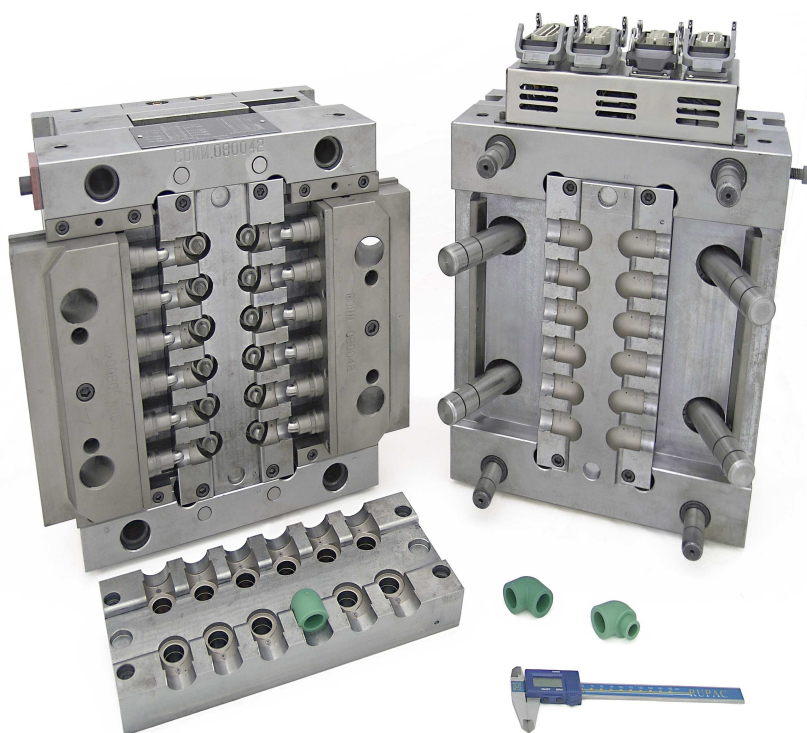
www.igq.it

IGQ2B17

Injection mould equipped with combined mechanic and hydraulic system. The mould produces a modular collector for heating system in ABS. The inner threads of the article measure $\frac{1}{4}$ " and $\frac{3}{8}$ " and are made through four collapsible cores with dovetail joint system. Dimensions of the mould: 430x440x438 mm. Weight of the mould: 800 Kg.

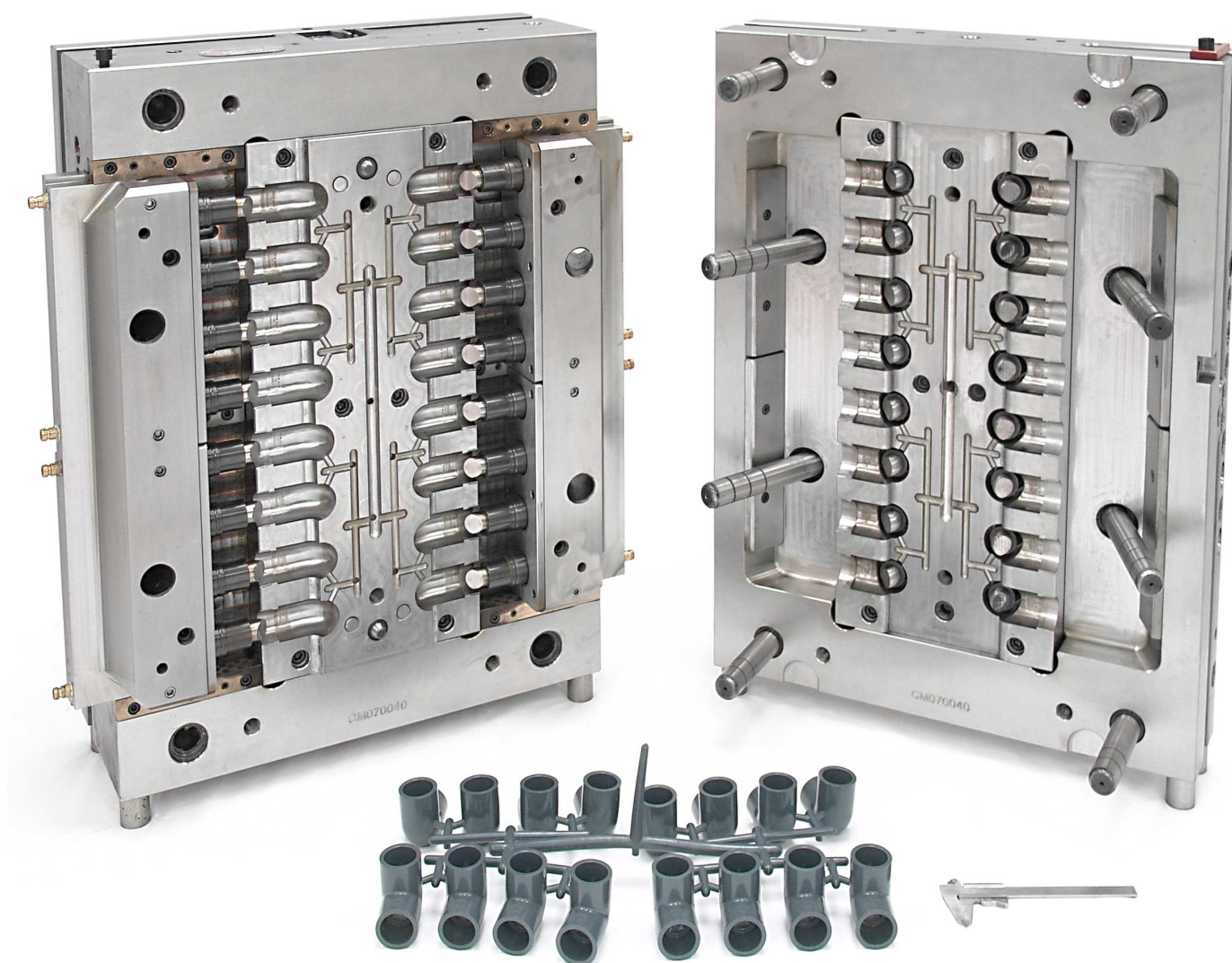


Injection mould equipped with mechanic system through slides and pins, and hot runner injection system to produce 12 PP-r Elbows $\text{\O}20 \times 90^\circ$. The mould is equipped with interchangeable cores and cavities to produce both the versions Male/Male and Male/Female. Dimensions of the mould: 390x440x460 mm. Weight of the mould: 530 Kg.

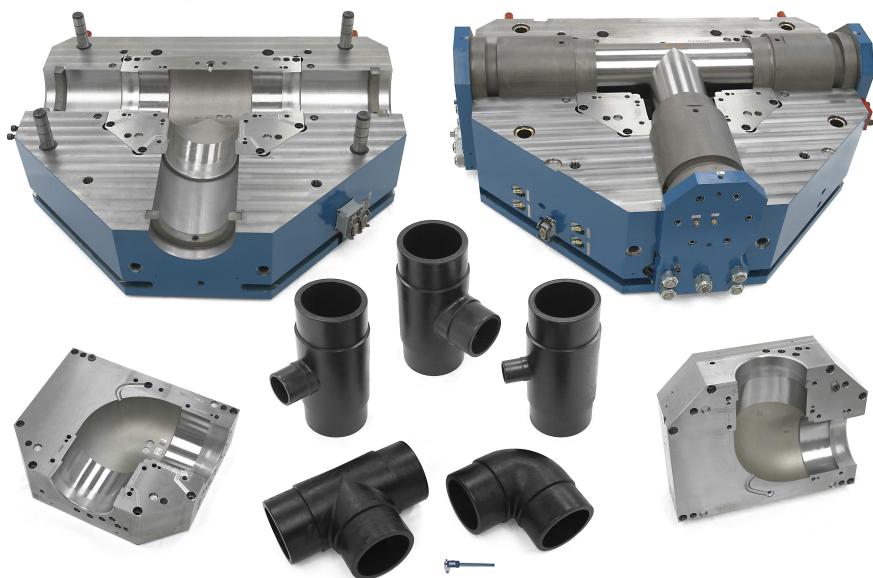


Injection mould equipped with mechanic system through slides and pins, and hot runner injection system to produce 12 PP-r TEE $\text{\O}20$. Dimensions of the mould: 590x440x380 mm. Weight of the mould: 700 Kg.

Injection mould equipped with mechanic system with slides and pins to produce 16 PVC Elbows $\text{\O}1'' \times 90^\circ$ with high wall-thickness. Dimensions of the mould: 860x620x350mm. Weight of the mould: 1260 Kg.

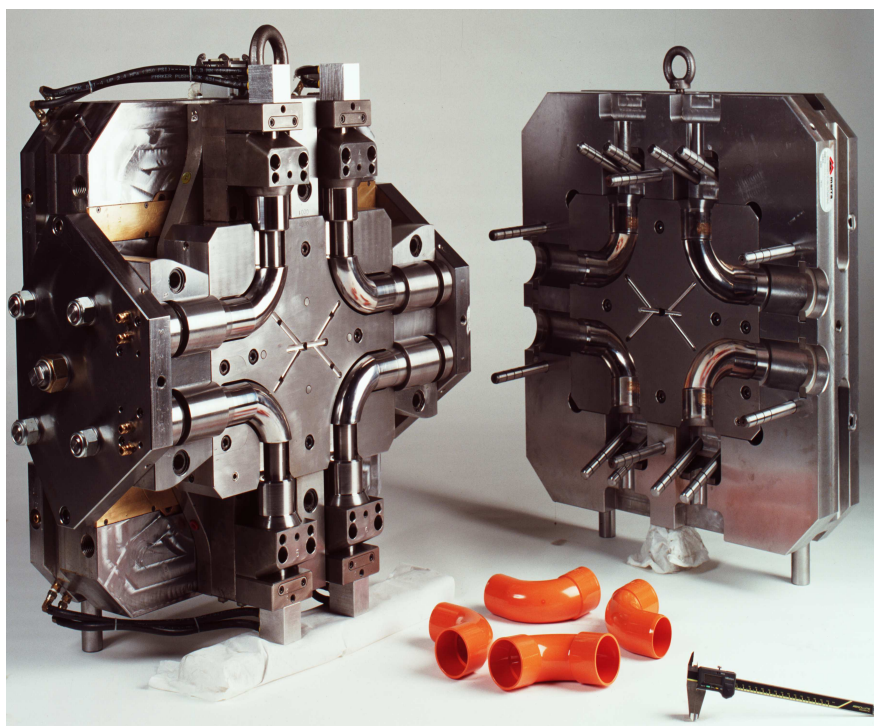


Injection mould with interchangeable core and cavity inserts, to produce HDPE fittings: TEE Ø315, Reduced TEE Ø315/225/160/110 and ELBOW Ø315. The cores of the mould are moved by hydraulic cylinders placed inside the mould. Thanks to this innovatory mould concept (i.e. inner cylinders), the mould dimensions are much smaller if compared to standard moulds with outer cylinders, thus allowing in turn the use of a smaller injection machine as well as the reduction of the time necessary to mount and demount the mould from it. The different mould versions can be directly changed from the machine thanks to a hydraulic device properly manufactured for the removal and montage of the different cavity inserts. Since the molded items are very heavy in weight (the TEE Ø315 weighs 27Kg.), we equipped the mould with a hot runner system to improve the injection process. Cycle time: 15 minutes. Dimensions of the mould: 2060x970x1630 mm. Weight of the mould: 10.000 Kg.

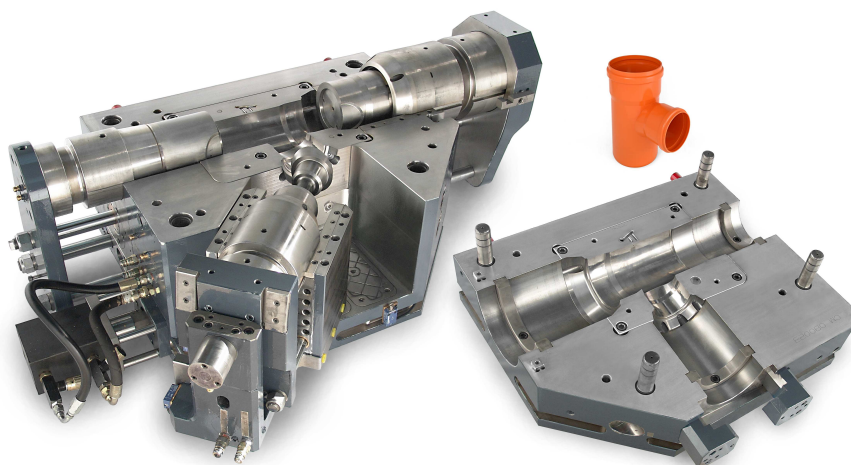


Injection mould for the production of PE100 S-Trap Ø160 with O'Ring seats. The O'Ring seal seats are made through collapsible cores moved by inner hydraulic cylinders; thanks to this innovatory mould concept, the mould dimensions are much smaller than by standard moulds, thus allowing in turn the use of a smaller injection machine, as well as the reduction of the time necessary to mount and demount the mould from it. In order to make the bending radius of the siphon, one of the collapsible cores rotates by 90° during the mould opening. Dimensions of the mould: 1420x1150x640 mm. Weight of the mould: 3.300 Kg. Injection moulding machine: 650 tons

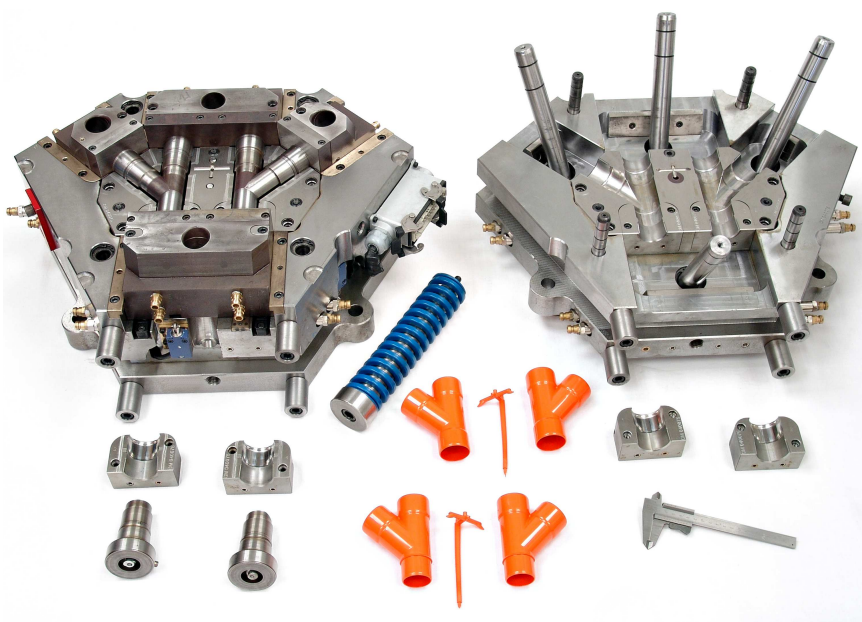
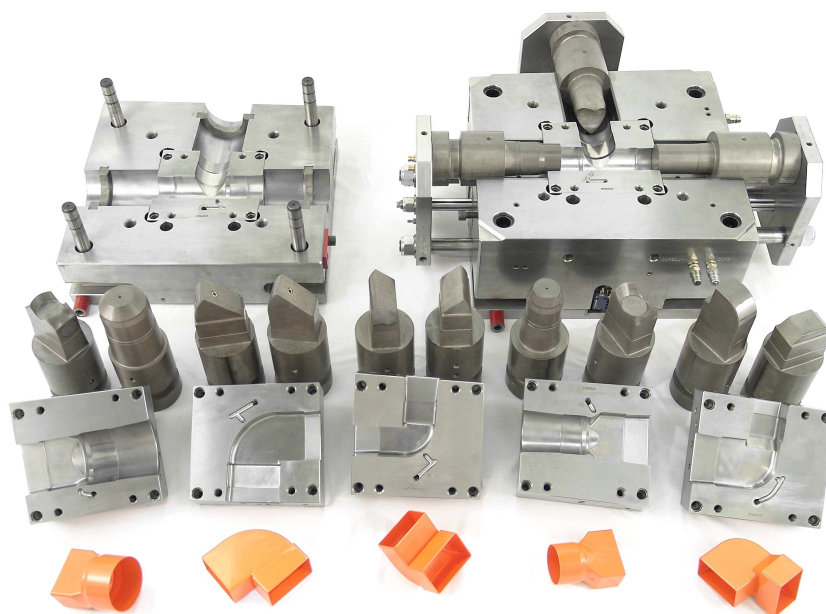
Injection mould equipped with combined mechanic and hydraulic moving system to produce four Swept bend Ø50 in PVC. The cores of this mould, moved by inner hydraulic cylinders, rotate by 90° to allow the ejection of the articles. Dimensions of the mould: 730 x 690 x 456 mm. Weight of the mould: 1.800 Kg.



Injection mould for the production of PVC TEE Ø160/110 with O'Ring seats. The O'Ring seal seats are made through collapsible cores moved by inner hydraulic cylinders; thanks to this innovatory mould concept, the mould dimensions are much smaller than by standard moulds, thus allowing in turn the use of a smaller injection machine, as well as the reduction of the time necessary to mount and demount the mould from it. Dimensions of the mould: 895x745x575 mm. Weight of the mould: 2850 Kg. Injection moulding machine: 650 tons or Engel 400 tons

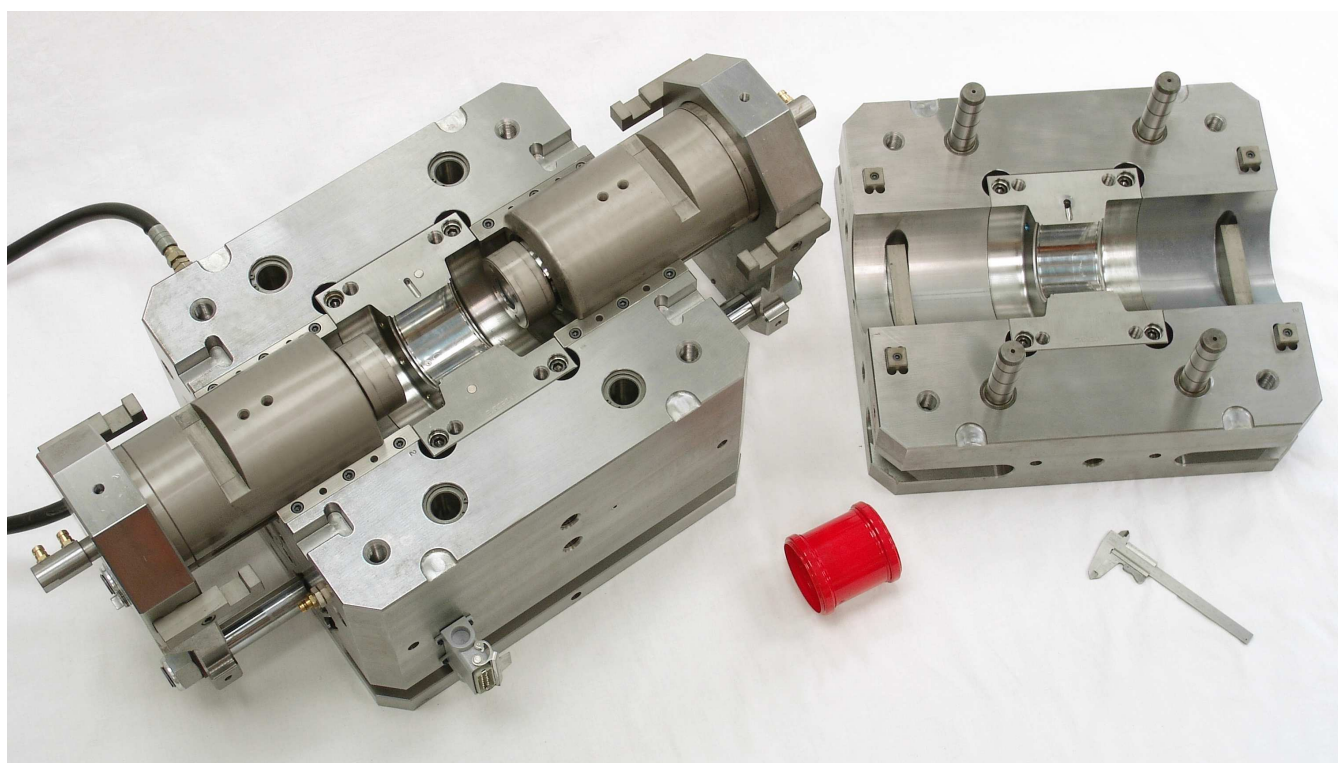


Injection mould equipped with inner hydraulic cylinders. The mould has interchangeable core and cavity inserts, to produce 6 different PVC fittings for the rainwater canalisation. The change of the different versions, can be directly made from the injection machine. Dimensions of the mould: 610x560x425 mm. Weight of the mould: 1150Kg.

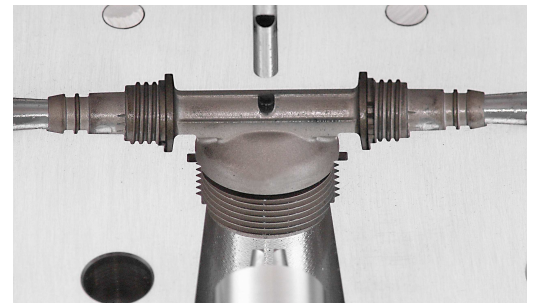
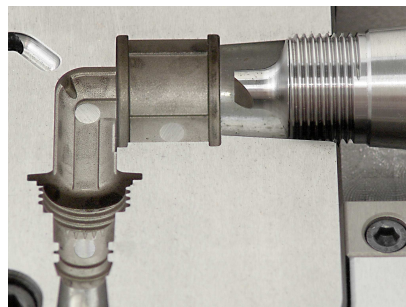
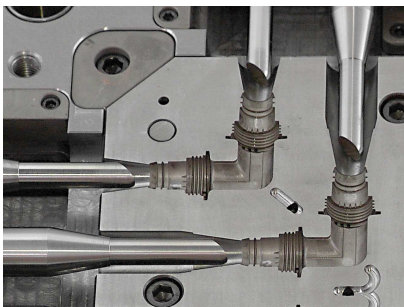
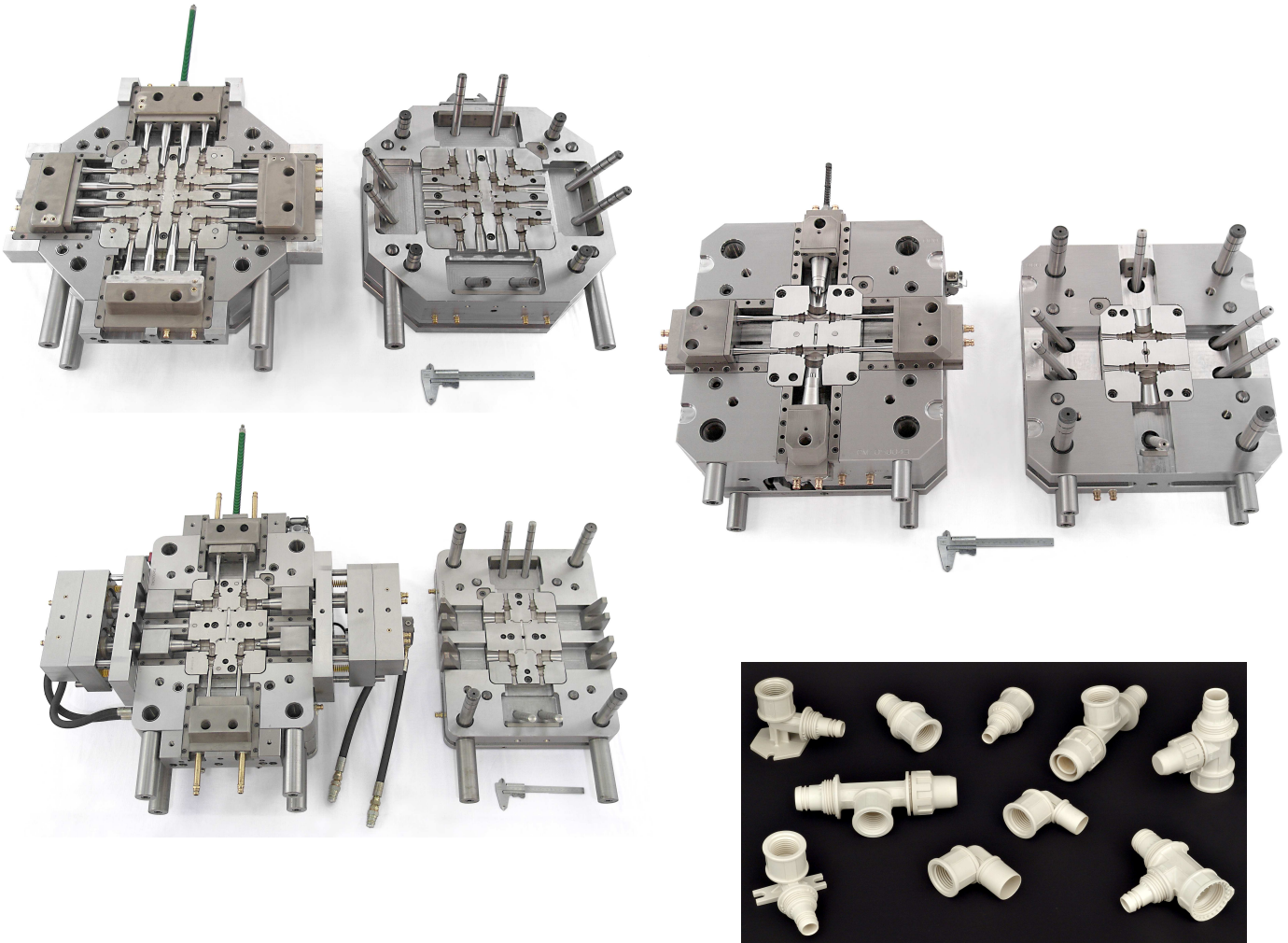


Injection mould with two cavities moving through a mechanic system with slides and pins, to produce the fitting PVC YEE Ø40. The mould has interchangeable core and cavity inserts, to produce both the version male/female and female/female. Dimensions of the mould: 630x325x545 mm. Weight of the mould: 870 Kg.

Injection mould for the production of a PP coupling Ø90 with O'Ring seal seats on both sides. The O'Ring seats are made by collapsible cores moved by inner hydraulic cylinders: thanks to this solution, the dimensions of the mould are reduced and the mould can be used on a smaller injection machine with a short cycle time. Dimensions of the mould: 534x480x473 mm. Weight of the mould: 970 Kg. Injection moulding machine: 150 ton.



Injection mould equipped with a mechanic system with slides and pins for the production of PPSU fittings. All the moulds are pre-heated and equipped with a hot runner injection system. Injection moulding machine: 150 tons





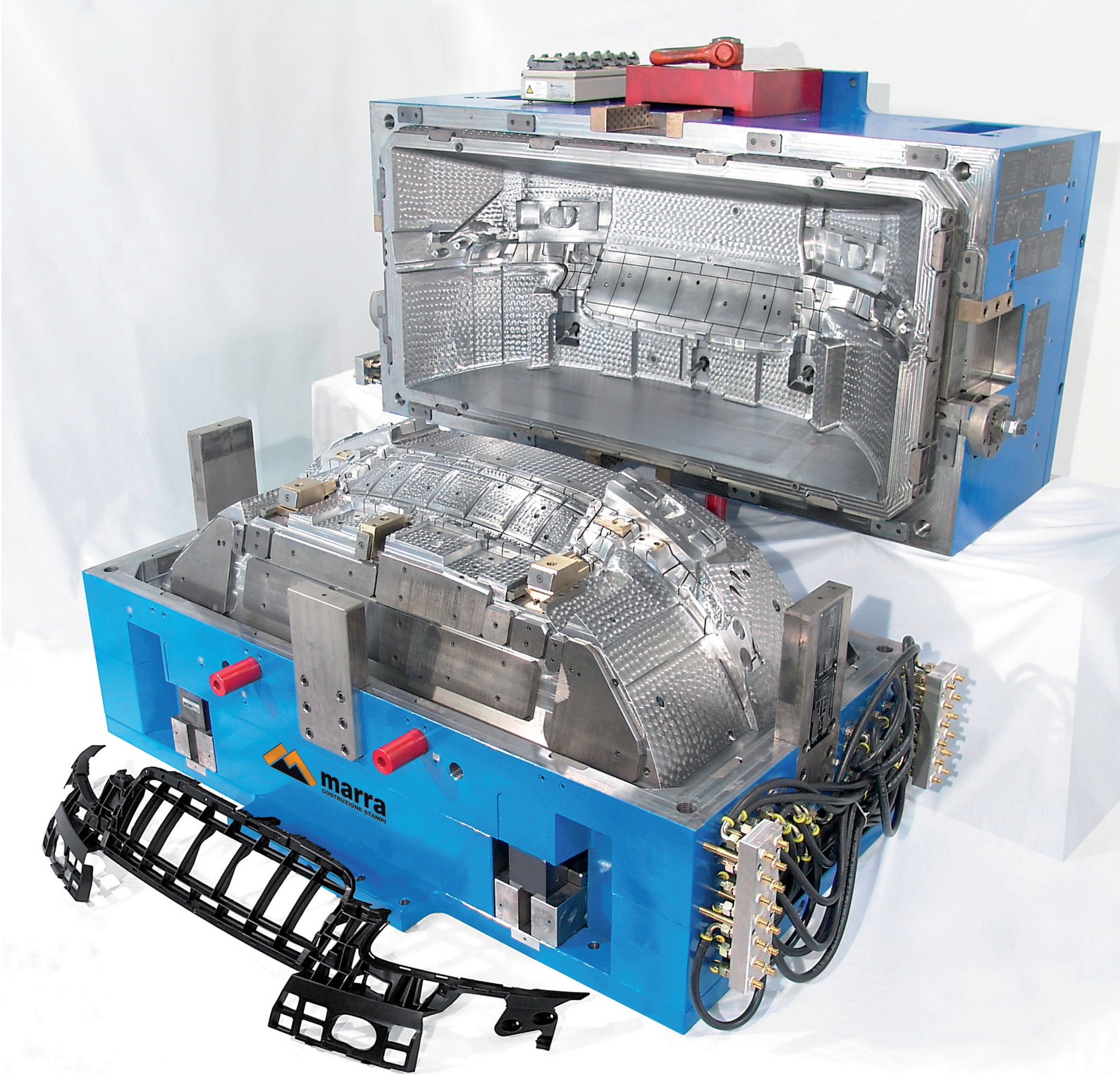
Fittings for canalisation and collection of rainwater



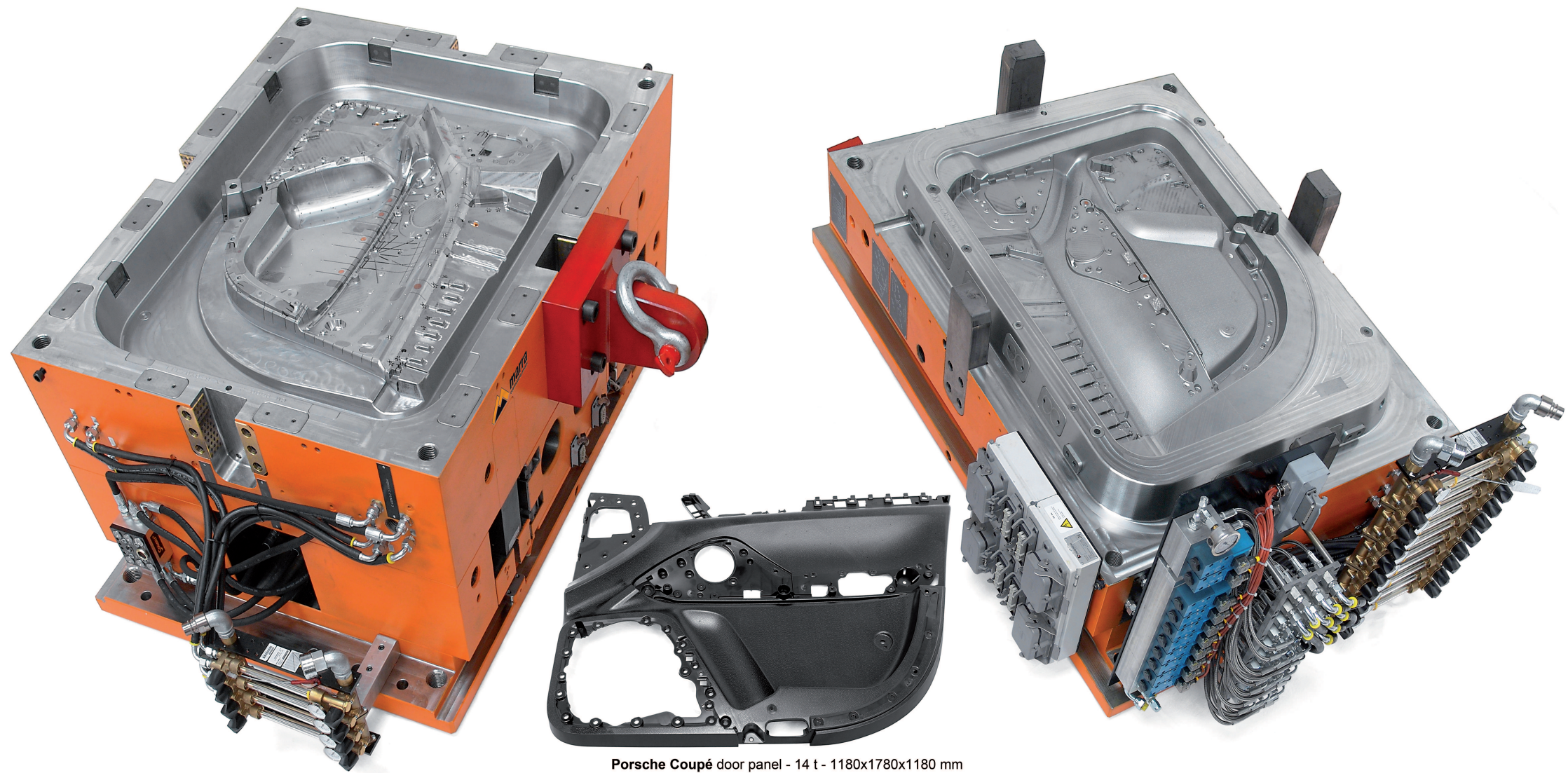
Corrugated fittings

Electro-fusion fittings

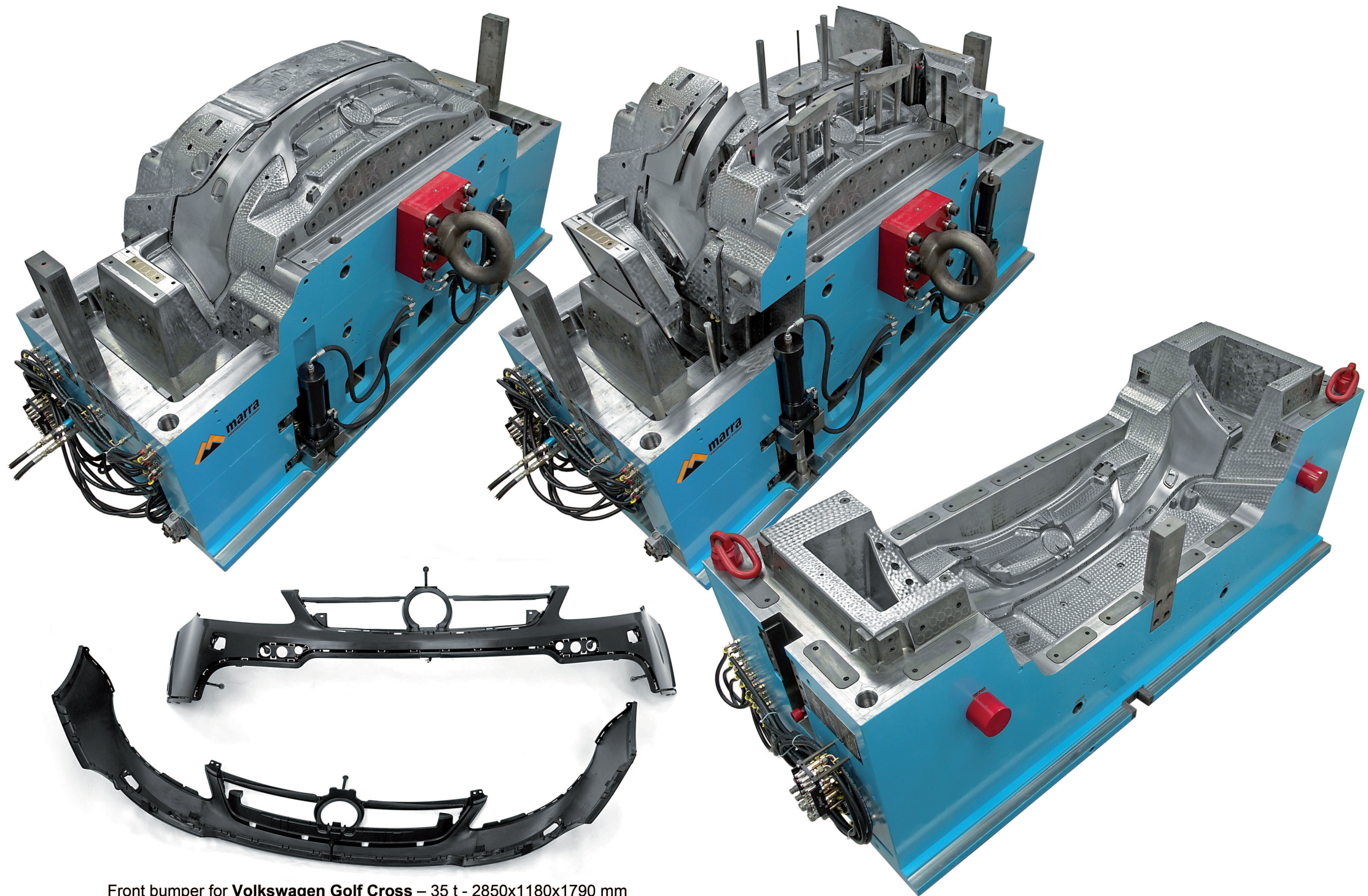




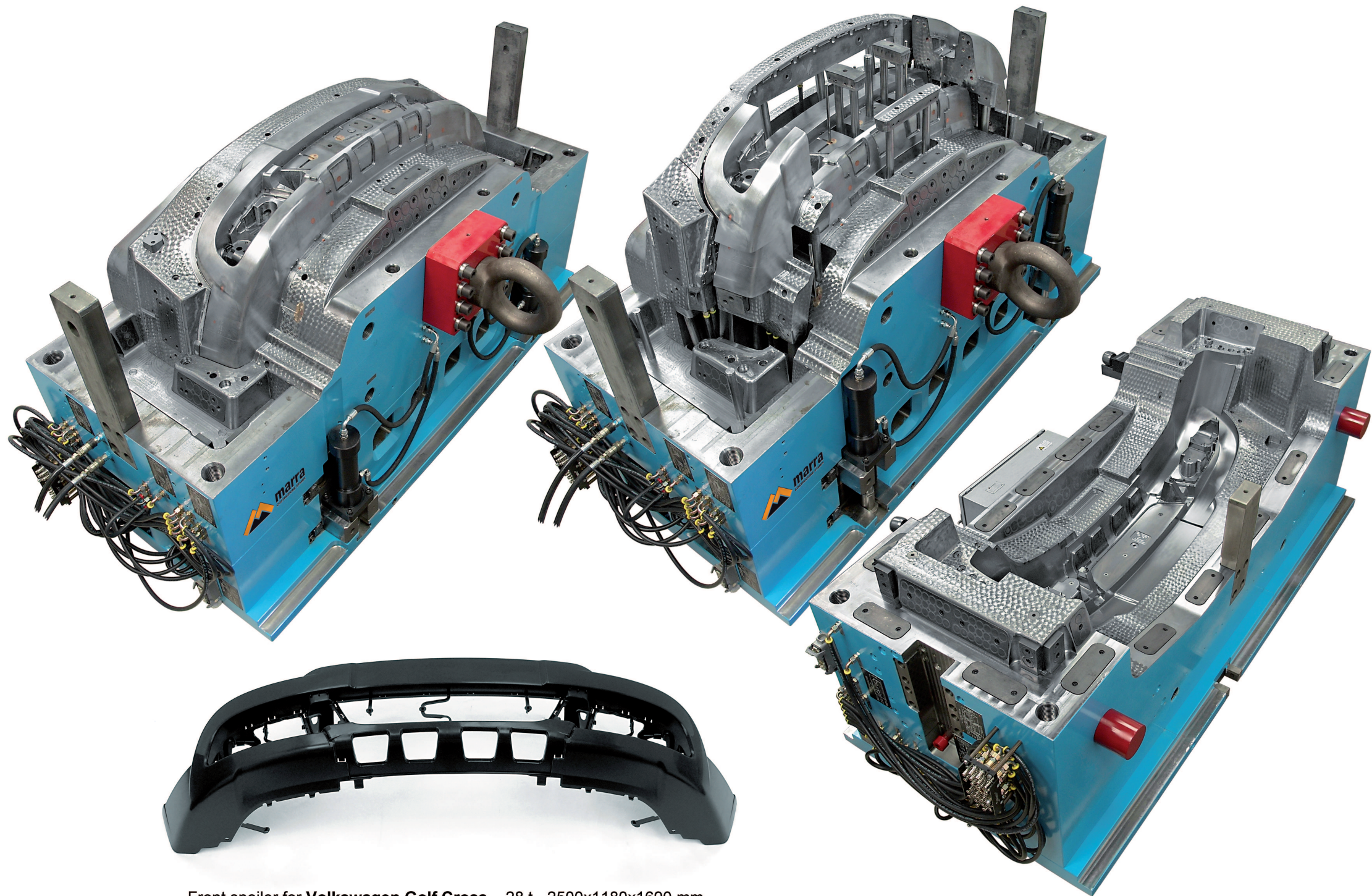
Bumper support for Audi A6 – 18 t - 1940x960x1200 mm



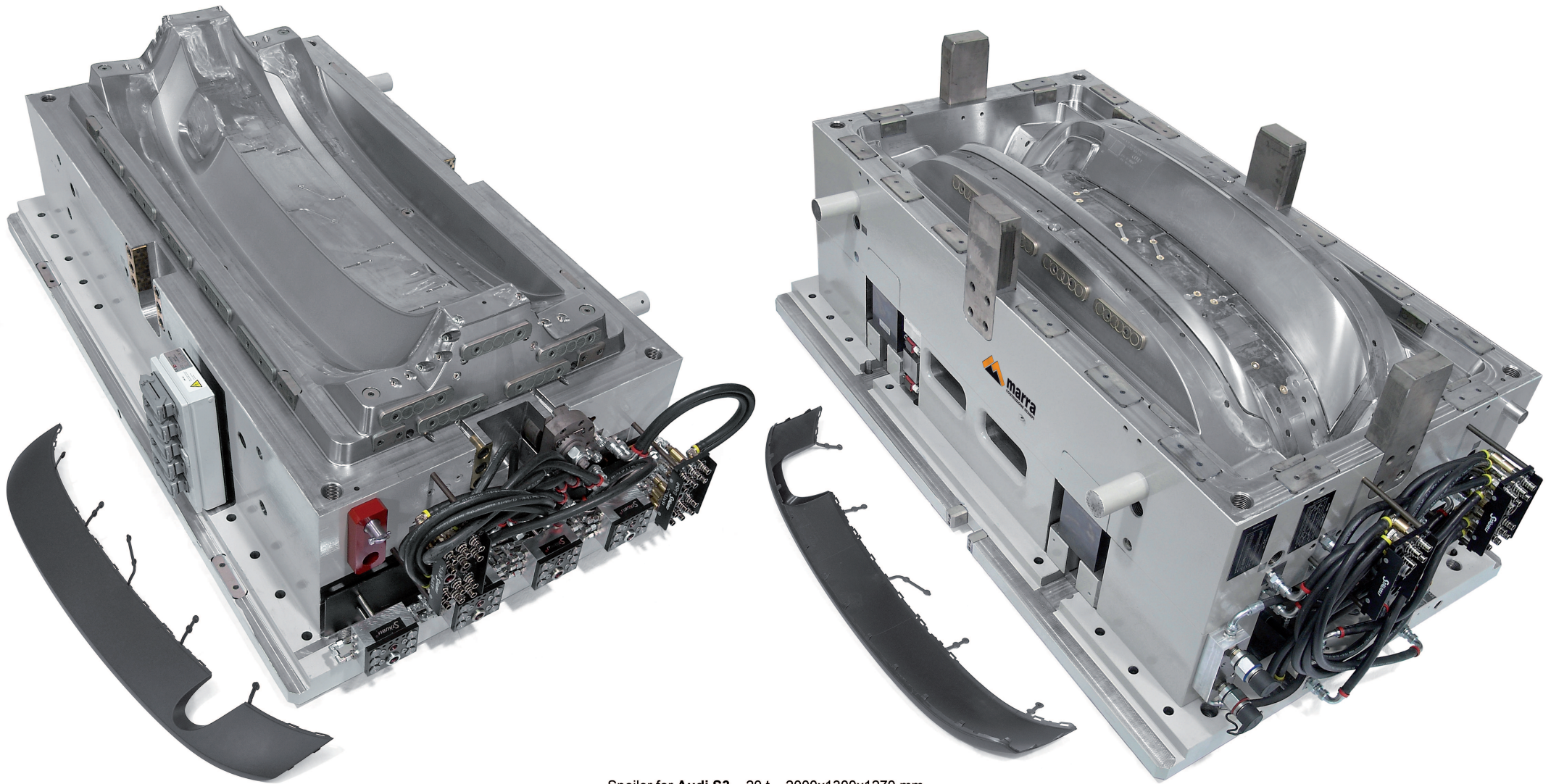
Porsche Coupé door panel - 14 t - 1180x1780x1180 mm



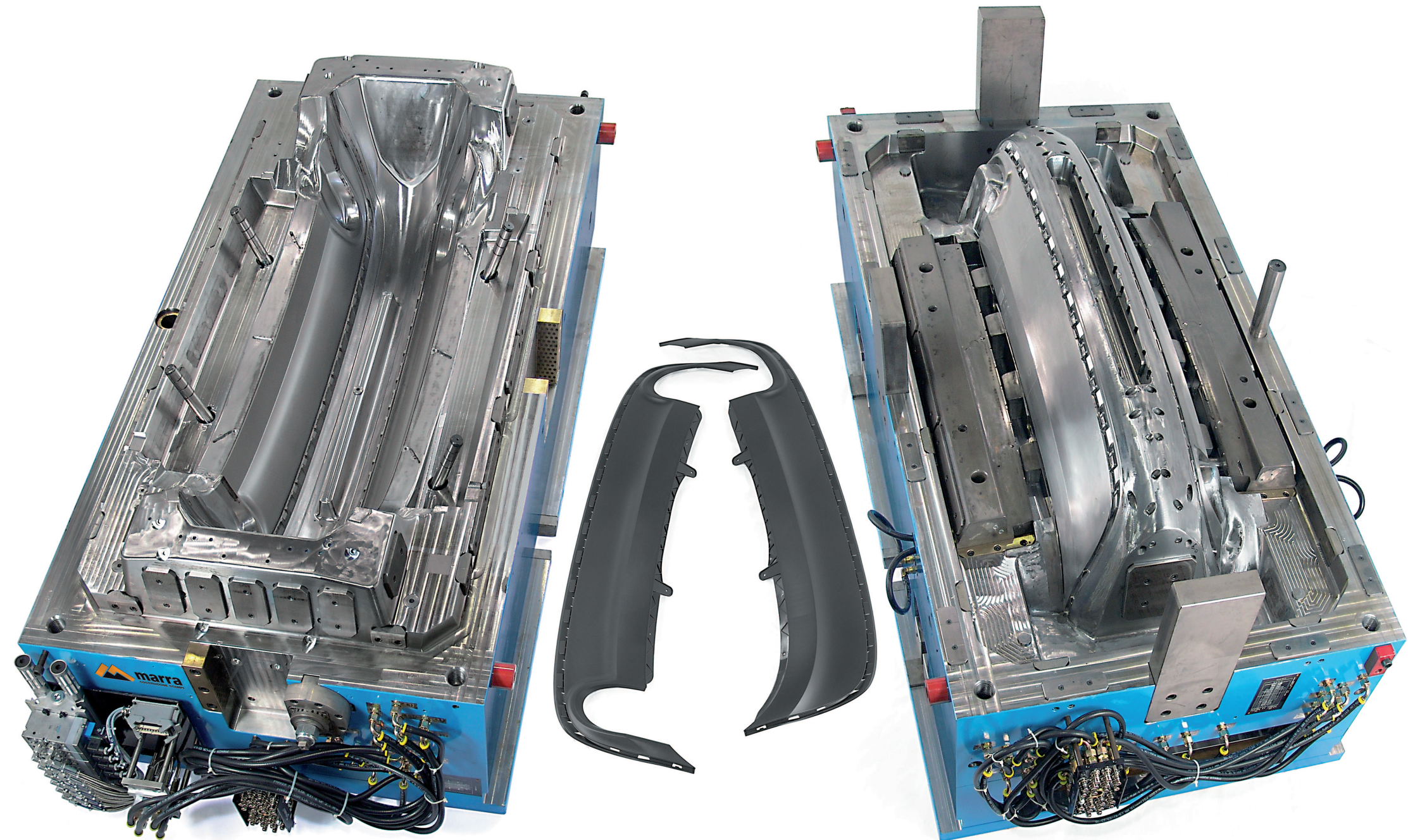
Front bumper for Volkswagen Golf Cross – 35 t - 2850x1180x1790 mm



Front spoiler for Volkswagen Golf Cross – 28 t - 2500x1180x1690 mm



Spoiler for Audi S3 – 20 t – 2000x1300x1270 mm



Underpan for Volkswagen Passat B6 Coupé - 5,2 t - 1300x900x910 mm



Underpan and rear spoiler for Audi TT - 19 t - 1816 x 2400 x 1292 mm



Wheel arches for **Renault Master** - 29 t - 2180 x 1460 x 1200 mm