

Thermoset Injection Mold Design Tips

When designing a mold for an injection molded part, it is important to keep in mind that the goal is to produce parts with the best quality, at the best cycle possible, with minimum scrap. To achieve this goal, you will need a mold that has a uniform mold temperature, balanced fill, is properly vented and is designed to dimensionally compensate for material shrinkage in all axis.

Mold Heating

A **uniform mold temperature** means that the temperature of each half of the mold is within $\pm 5^{\circ}\text{F}$ (3°C) for all locations when the mold is heated by oil or steam. Molds that are heated with electric cartridge heaters can vary by as much as 10°F (6°C). A mold with a uniform temperature will fill easier and produce parts with less warpage, improved dimensional stability and have a uniform surface appearance. Achieving a uniform mold temperature is dependent on the method of mold heating.

A mold that is correctly designed and **heated by steam** or **oil** will have a uniform mold temperature because the heat source maintains a constant temperature. However, oil as a heat source is only about half as efficient as steam. Therefore, when using oil to heat a mold, it is necessary to set the oil temperature higher than the desired mold temperature.

Electrically heated molds are more difficult to maintain a uniform temperature because the cartridge heaters are constantly cycling on and off. Heat is generated when the cartridge heaters turn on. This heat must then evenly migrate throughout the tool.

To determine the amount of wattage needed to heat a mold, the use of the following formula might be helpful: **1.25 – 1.5 kilowatts for every 100 lbs. (45 kg) of mold steel**. Note: This formula typically will allow the mold to be heated to molding temperatures in 1 to 2 hours.

Typically, the **cartridge heaters** are located in the support plates with a distance of $2\frac{1}{2}"$ (64 mm) between heater cartridges. **NOTE:** Deep draw molds may need to also have cartridge heaters in the retainer plate. There should be a minimum of one **thermocouple** to control each half of the mold. In larger molds, it is recommended to have more than one thermocouple in each mold half. This will result in better control and more uniform mold temperatures. The **thermocouples** should be located in the "A" and "B" plates, between two heaters if possible and at a distance of $1\frac{1}{4}" - 1\frac{1}{2}"$ (32 mm - 38 mm) from the closest cartridge heater.

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Jay Carender



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Thomas Register of American Manufacturers and Thomas Register Catalog File, 1997 Vols for 1970-71 includes manufacturers catalogs Plastics World, 1955 **Injection Mold Design Engineering** David Kazmer, 2007 This book provides a vision and structure to finally synergize all the engineering disciplines that converge in the mold design process. The topics are presented in a top down manner beginning with introductory definitions and the big picture before proceeding to layout and detailed design of molds. The book provides very pragmatic analysis with worked examples that can be readily adapted to real world mold design applications. It should help students and practitioners to understand the inner workings of injection molds and encourage them to think outside the box in developing innovative and highly functional mold designs.

Jacket Intelligent Optimization of Mold Design and Process Parameters in Injection Molding Mehdi Moayyedian, 2018-11-02 This book describes an effective framework for setting the right process parameters and new mold design to reduce the current plastic defects in injection molding. It presents a new approach for the optimization of injection molding process via i a new mold runner design which leads to 20 percent reduction in scrap rate 2 5 percent reduction in manufacturing time and easier ejection of injected part ii a new mold gate design which leads to less plastic defects and iii the introduction of a number of promising alternatives with high moldability indices. Besides presenting important developments of relevance academic research the book also includes useful information for people working in the injection molding industry especially in the green manufacturing field.

Understanding Injection Mold Design Herbert Rees, 2001-01-01 Today most molders but also many mold makers specialize in certain areas. There are specialists for thin wall molding screw caps large beverage container crates pre forms for PET bottles small gears and many others. But regardless of size and type of the product to be injection molded whether small or large with single or multiple cavities or who designs or builds the mold the basic mold design principles are always the same.

Computer-Aided Injection Mold Design and Manufacture J.Y.H. Fuh, M. W. Fu, A.Y.C. Nee, 2004-08-02 Examining processes that affect more than 70 percent of consumer products ranging from computers to medical devices and automobiles this reference presents the latest research in automated plastic injection and die casting mold design and manufacture. It analyzes many industrial examples and methodologies while focusing on the algorithms implemented.

The Complete Part Design Handbook E. Alfredo Campo, 2006 This handbook was written for the injection molding product designer who has a limited knowledge of engineering polymers. It is a guide for the designer to decide which resin and design geometries to use for the design of plastic parts. It can also offer knowledgeable advice for resin and machine selection and processing parameters. Manufacturer and end user satisfaction is the ultimate goal.

Injection Molding Reference Guide (4th Edition) Jay Carender, 2011-10-13 This reference guide was originally prepared in 1990 as a convenient pocket sized resource for use in Injection Molding. This information is most useful by personnel who work in the injection molding field including press operators technicians.

engineers designers mold builders etc There are many reference data tables regarding plastics data statistical methods engineering calculations and valuable training for personnel in the IM industry The book includes basic part design trig tables calculations for thermal expansion thermal exp coeffs SHCS data torque specs shrink data cooling time equation mold debug guidelines melt index data resin density data many tables of process guidelines process development techniques calculating heat load water flow requirements pipe data conversion factors transformer motor current PM safety basic statistics equip selection guidelines and more This 4th Edition has been reformatted at 5 5 inches wide x 8 5 inches tall in 2011 for print sales

Injection and Compression Molding Fundamentals Avraam L. Isayev, 2017-11-01 This outstanding reference presents an up to date account of investigations during the last 10 years in the area of injection and compression molding of polymers Injection and Compression Molding Fundamentals considers simulation and experimentation of flow dynamics in the cavity and delivery system discusses rheology and viscoelastic modeling clarifies fiber orientation delineates residual stresses and processing property relationships in molded parts and details computer aided design and manufacture of the mold In addition the book highlights specific features and problems related to the molding of thermoplastics rubbers and thermosets and reveals the current status of the science based technology related to injection and compression molding The most detailed and authoritative reference of its type Injection and Compression Molding Fundamentals is an invaluable resource for plastics mechanical and chemical engineers colloid oil and color chemists polymer engineers and scientists mold designers and manufacturers rheologists and materials scientists The book will also be of value for use in graduate level courses in plastics mechanical chemical and polymer engineering and in short courses and seminars offered by professional societies

How to Make Injection Molds Georg Menges, Paul Mohren, 1993 Here is a comprehensive guide for everyone engaged in the design or manufacture of injection molds Written for engineers plastics professionals and students the book is intended to assist in the mold making process and help avoid costly mistakes The authors cover all aspects including material selection fabricating cavities and cores general mold design hot runner systems venting design demolding techniques and devices maintenance hardware construction procedures and more All topics are presented in a thorough detailed manner based on the authors extensive practical experience The emphasis is on the application of designs and concepts in real manufacturing settings In addition the book can be used as a text for those who have little detailed knowledge or practical experience with injection molding or mold making procedures The new second edition draws on the most recent literature as well as extensive research and development at the Institute for Plastics Processing at the Technical University of Aachen Germany

Injection Mold Design Engineering David O. Kazmer, 2022 This book provides a structured methodology and scientific basis for engineering injection molds The topics are presented in a top down manner beginning with introductory definitions and the big picture before proceeding to layout and detailed design of molds The book provides very pragmatic analysis with worked examples that can be readily adapted to real world product design applications It will help students and

practitioners to understand the inner workings of injection molds and encourage them to think outside the box in developing innovative and highly functional mold designs Injection molding continues to be a core plastics manufacturing process but now has competition from additive manufacturing for certain applications and environmental concerns are in the spotlight The 3rd edition addresses these issues in particular with a new chapter on mold manufacturing strategy to provide an overview of the most common machining and additive manufacturing processes with cost and time models to guide the manufacturing strategy updated and simplified break even cost models to assist in the mold layout design number of cavities and type of mold vs 3D printing a new section on environmental concerns include mold design for recycled resins and updates to the International Tolerance standards and the new technology and simulation sections

Injection Mold Design Engineering Complete Self-Assessment Guide Gerardus Blokdyk, 2017-07-26

How do we Lead with Injection Mold Design Engineering in Mind Does the Injection Mold Design Engineering task fit the client's priorities How will variation in the actual durations of each activity be dealt with to ensure that the expected Injection Mold Design Engineering results are met What will drive Injection Mold Design Engineering change What are the disruptive Injection Mold Design Engineering technologies that enable our organization to radically change our business processes Defining designing creating and implementing a process to solve a business challenge or meet a business objective is the most valuable role In EVERY company organization and department Unless you are talking a one time single use project within a business there should be a process Whether that process is managed and implemented by humans AI or a combination of the two it needs to be designed by someone with a complex enough perspective to ask the right questions Someone capable of asking the right questions and step back and say What are we really trying to accomplish here And is there a different way to look at it For more than twenty years The Art of Service's Self Assessments empower people who can do just that whether their title is marketer entrepreneur manager salesperson consultant business process manager executive assistant IT Manager CxO etc they are the people who rule the future They are people who watch the process as it happens and ask the right questions to make the process work better This book is for managers advisors consultants specialists professionals and anyone interested in Injection Mold Design Engineering assessment All the tools you need to an in depth Injection Mold Design Engineering Self Assessment Featuring 619 new and updated case based questions organized into seven core areas of process design this Self Assessment will help you identify areas in which Injection Mold Design Engineering improvements can be made In using the questions you will be better able to diagnose Injection Mold Design Engineering projects initiatives organizations businesses and processes using accepted diagnostic standards and practices implement evidence based best practice strategies aligned with overall goals integrate recent advances in Injection Mold Design Engineering and process design strategies into practice according to best practice guidelines Using a Self Assessment tool known as the Injection Mold Design Engineering Scorecard you will develop a clear picture of which Injection Mold Design Engineering areas need

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mold specification sheets and mold design engineering for gates cooling sprues runners runner sizing ejection pullbacks KOs SPI KO patterns clamp slots venting hydraulic cylinders slides alignment O rings SHCSs support plate pillars hot runner considerations etc Also included mold design checklist quoting design direction tips to best determine shrinkage values for X Y Z axis mold steels and hardness heat treatment and tempering data thermal conductivity values thermal expansion plating best surface treatments surface finish tables edm roughness table updated list of common suppliers and more This new 2nd EDITION also includes selected additional reference pages from other APEBOOKS which are related to mold engineering

Injection Mold Design Handbook Bruce Catoen, Herbert Rees, 2021-10-11 An injection mold is the heart of any plastics molding workcell Understanding the principles of an injection mold design and its importance to a successful plastic part is fundamental to the success of the product This book helps guide the designer engineer project manager and production manager in making sure that the injection mold to be designed will work as intended This book takes the reader through the process of conceptualizing and designing an injection mold that will produce the desired plastic part Since it all starts with the plastic part the book first focuses on key features and details of the plastic part which are necessary for good mold design The design of the main components of an injection mold are discussed and good design practices are shared Finally the process of testing and gaining customer acceptance of the mold for production is detailed A comprehensive appendix and detailed drawings provide the required detail for completing a mold design Additionally more than 40 detailed examples of mold designs are provided in the book to illustrate the principles and design rules discussed **Practical Injection**

Molding Bernie A. Olmsted, Martin Davis, 2001-03-14 This work focuses on the factors critical to successful injection moulding including knowledge of plastic materials and how they melt the importance of mould design the role of the screw and the correct use of the controls of an injection moulding machine It seeks to provide operating personnel with a clear understanding of the basics of injection **Injection Mold Design** Chester E. Dietrick, North Coast Polymer Consortium, 1992*

Mold Design I Edward P. Allyn, 1988 *Injection Molding Handbook* D.V. Rosato, Marlene G. Rosato, 2012-12-06 This third edition has been written to thoroughly update the coverage of injection molding in the World of Plastics There have been changes including extensive additions to over 50% of the content of the second edition Many examples are provided of processing different plastics and relating the results to critical factors which range from product design to meeting performance requirements to reducing costs to zero defect targets Changes have not been made that concern what is basic to injection molding However more basic information has been added concerning present and future developments resulting in the book being more useful for a long time to come Detailed explanations and interpretation of individual subjects more than 1500 are provided using a total of 914 figures and 209 tables Throughout the book there is extensive information on problems and solutions as well as extensive cross referencing on its many different subjects This book represents the ENCYCLOPEDIA on IM as is evident from its extensive and detailed text that follows from its lengthy Table of CONTENTS

and INDEX with over 5200 entries The worldwide industry encompasses many hundreds of useful plastic related computer programs This book lists these programs ranging from operational training to product design to molding to marketing and explains them briefly but no program or series of programs can provide the details obtained and the extent of information contained in this single sourcebook

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