

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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