

## 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  $\pm 5^{\circ}\text{F}$  ( $3^{\circ}\text{C}$ ) 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  $10^{\circ}\text{F}$  ( $6^{\circ}\text{C}$ ). 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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**S Marginson**



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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, 2016     **Injection Mold Design Engineering** David O. Kazmer, 2012-11-12 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. Contents: Introduction to mold functions, types and components; Review of design for injection molding; Cost estimation and optimization; Mold layout design including cavity layout, sizing and materials selection; Cavity runner system and gating analysis and design; Cooling system analysis and design; Venting, shrinkage and warpage analysis and strategies; Ejection force analysis and ejection system designs; Stress and deflection analysis with structural system designs; A survey of advanced mold designs     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     **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 to academic research, the book also includes useful information for people working in the injection molding industry, especially in the green manufacturing field     **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 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

**How to Make Injection Molds** Georg Menges, Paul Mohren, 1986

**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

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**Injection Molds** Hans Gastrow, 1983      **Injection Mold Design Engineering Complete Self-Assessment Guide**

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Carender, 2011-11-03 This book includes many reference tables and graphics supplying valuable information for injection mold design and engineering The book includes 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      **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 moulding

*Injection Mold Design* Chester E. Dietrick, North Coast Polymer Consortium, 1992\*      **Injection Molding Handbook** Dominick V. Rosato, Donald V. Rosato, Marlene G. Rosato, 2000 Provides reference information concerning the injection molding operation and each of its aspects It examines considerable technological advancements especially those in computer methods that have been made since the second edition was published      *Mold Design I* Edward P. Allyn, 1988

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