

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.

Sect 6 Injection Mold Design Tips Plenco

David O. Kazmer



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Plastics World, 1955 *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

Injection Mold Design Chester E. Dietrick, North Coast Polymer Consortium, 1992* *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 **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 implementation procedures and system architectures that will lead to a fully automated or semi automated computer aided injection mold design system CADIMDS This invaluable guide in this challenging area of precision engineering summarizes key findings and innovations from the authors many years of research on intelligent mold design technologies

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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

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