

Contents

Preface	V
Nomenclature	XIX
1 Introduction	1
1.1 Overview of the Injection Molding Process	1
1.2 Mold Functions	4
1.3 Mold Structures	6
1.3.1 External View of Mold	6
1.3.2 View of Mold during Part Ejection	8
1.3.3 Mold Cross-Section and Function	9
1.4 Other Common Mold Types	12
1.4.1 Three-Plate, Multicavity Family Mold	12
1.4.2 Hot Runner, Multigated, Single-Cavity Mold	14
1.4.3 Comparison	16
1.5 The Mold Development Process	16
1.6 Mold Standards	18
1.7 Chapter Review	21
2 Plastic Part Design	23
2.1 The Product Development Process	23
2.1.1 Product Definition	24
2.1.2 Product Design	25
2.1.3 Development	25
2.1.4 Scale-Up and Launch	27
2.1.5 Role of Mold Design in Manufacturing Strategy	27

2.2	Prototyping Strategy	28
2.2.1	3D Printing by Material Extrusion (Fused Deposition Modeling)	32
2.2.2	3D Printing by Selective Laser Sintering	33
2.2.3	3D Printing by Stereolithography, Digital Light Processing, and Continuous Liquid Interface Production	34
2.2.4	3D Printing by PolyJet and Multi Jet Fusion	37
2.3	Design Requirements	40
2.3.1	Application Engineering Information	41
2.3.2	Computer-Aided Engineering (CAE)	41
2.3.3	Production Planning	42
2.3.4	End-Use Requirements	43
2.3.5	Design for Manufacturing and Assembly	45
2.3.6	Plastic Material Properties	46
2.4	Design for Injection Molding	46
2.4.1	Uniform Wall Thickness	46
2.4.2	Rib Design	48
2.4.3	Boss Design	49
2.4.4	Corner Design	50
2.4.5	Surface Finish and Textures	51
2.4.6	Draft	53
2.4.7	Undercuts	54
2.5	Sustainability	57
2.6	Chapter Review	57
3	Mold Procurement	61
3.1	Overview	61
3.2	The Procurement Process	63
3.3	Molded Part Cost Estimation	65
3.3.1	Mold Cost per Part	67
3.3.2	Material Cost per Part	69
3.3.3	Processing Cost per Part	70
3.3.4	Defect Cost per Part	72
3.4	Mold Cost Estimation	73
3.4.1	Mold Base Cost Estimation	74
3.4.2	Cavity Cost Estimation	76

3.4.2.1	Insert Cost Estimation	76
3.4.2.2	Inserts Discount Factor	77
3.4.2.3	Insert Cost Machining Factors	78
3.4.2.4	Insert Cost Finishing Factors	79
3.4.3	Mold Customization	81
3.5	Rapid and Additive Manufacturing	86
3.5.1	Common Additively Manufactured Materials	87
3.5.2	Additive Manufacturing Process Performance Metrics	89
3.5.3	Design for Additive Manufacturing Guidelines	91
3.5.4	Preferred Workflow and File Formats	98
3.6	Mold Selection by Breakeven Analysis	99
3.7	Chapter Review	102
4	Mold Layout Design	107
4.1	Parting Plane Design	107
4.1.1	Determine Mold Opening Direction	108
4.1.2	Determine Parting Line	111
4.1.3	Parting Plane	112
4.1.4	Shut-Offs	114
4.2	Cavity and Core Insert Creation	115
4.2.1	Height Dimension	115
4.2.2	Length and Width Dimensions	116
4.2.3	Adjustments	117
4.3	Mold Base Selection	119
4.3.1	Cavity Layouts	119
4.3.2	Mold Base Sizing	121
4.3.3	Molding Machine Compatibility	123
4.3.4	Mold Base Suppliers	124
4.4	Material Selection	126
4.4.1	Strength vs. Heat Transfer	127
4.4.2	Hardness vs. Machinability	128
4.4.3	Material Summary	130
4.4.4	Surface Treatments	131
4.5	Chapter Review	133

5	Cavity Filling Analysis and Design	137
5.1	Overview	137
5.2	Objectives in Cavity Filling	138
5.2.1	Complete Filling of Mold Cavities	138
5.2.2	Avoid Uneven Filling or Over-Packing	139
5.2.3	Control the Melt Flow	140
5.3	Viscous Flow	140
5.3.1	Shear Stress, Shear Rate, and Viscosity	140
5.3.2	Pressure Drop	141
5.3.3	Rheological Behavior	143
5.3.4	Newtonian Model	145
5.3.5	Power Law Model	147
5.4	Cavity Filling Analyses and Designs	149
5.4.1	Estimating the Processing Conditions	149
5.4.2	Estimating the Filling Pressure and Minimum Wall Thickness	152
5.4.3	Estimating Clamp Tonnage	155
5.4.4	Predicting Filling Patterns	157
5.4.5	Designing Flow Leaders	160
5.5	Process Simulation	163
5.5.1	Simulation Pre-Processing	163
5.5.2	Simulation Post-Processing	166
5.5.3	Discussion	169
5.6	Chapter Review	171
6	Feed System Design	175
6.1	Overview	175
6.2	Objectives in Feed System Design	175
6.2.1	Conveying the Polymer Melt from Machine to Cavities	175
6.2.2	Impose Minimal Pressure Drop	176
6.2.3	Consume Minimal Material	177
6.2.4	Control Flow Rates	179
6.3	Feed System Types	179
6.3.1	Two-Plate Mold	180
6.3.2	Three-Plate Mold	182
6.3.3	Hot Runner Molds	187

6.4	Feed System Analysis	190
6.4.1	Determine Type of Feed System	191
6.4.2	Determine Feed System Layout	193
6.4.3	Estimate Pressure Drops	196
6.4.4	Calculate Runner Volume	198
6.4.5	Optimize Runner Diameters	199
6.4.6	Balance Flow Rates	203
6.4.7	Estimate Runner Cooling Times	206
6.4.8	Estimate Residence Time	208
6.5	Feed System Simulation	209
6.5.1	Hot Runners	209
6.5.2	Cold Runners	211
6.6	Practical Issues	213
6.6.1	Color Changes with Hot Runners	214
6.6.2	Runner Cross-Sections	215
6.6.3	Sucker Pins	219
6.6.4	Runner Shut-Offs	220
6.6.5	Standard Runner Sizes	222
6.6.6	Steel Safe Designs	222
6.7	Advanced Feed Systems	223
6.7.1	Insulated Runner	223
6.7.2	Stack Molds	225
6.7.3	Branched Runners	227
6.7.4	Dynamic Melt Control	228
6.8	Chapter Review	231
7	Gating Design	235
7.1	Objectives of Gating Design	235
7.1.1	Connecting the Runner to the Mold Cavity	235
7.1.2	Provide Automatic De-gating	235
7.1.3	Maintain Part Aesthetics	236
7.1.4	Avoid Excessive Shear or Pressure Drop	236
7.1.5	Control Pack Times	237
7.2	Common Gate Designs	238
7.2.1	Sprue Gate	238

7.2.2	Pin-Point Gate	239
7.2.3	Edge Gate	240
7.2.4	Tab Gate	241
7.2.5	Fan Gate	242
7.2.6	Flash/Diaphragm Gate	243
7.2.7	Tunnel/Submarine Gate	244
7.2.8	Thermal Gate	247
7.2.9	Valve Gate	250
7.3	The Gating Design Process	251
7.3.1	Determine Gate Location(s)	251
7.3.2	Determine Type of Gate	253
7.3.3	Calculate Shear Rates	255
7.3.4	Calculate Pressure Drop	257
7.3.5	Calculate Gate Freeze Time	258
7.3.6	Adjust Dimensions	261
7.3.7	Gate Verification by Simulation	262
7.4	Chapter Review	265
8	Venting	269
8.1	Venting Design Objectives	269
8.1.1	Release Compressed Air	269
8.1.2	Contain Plastic Melt	270
8.1.3	Minimize Maintenance	270
8.2	Venting Analysis	270
8.2.1	Estimate Air Displacement and Rate	271
8.2.2	Identify Number and Location of Vents	271
8.2.3	Specify Vent Dimensions	274
8.3	Venting Designs	277
8.3.1	Vents on Parting Plane	277
8.3.2	Vents around Ejector Pins	280
8.3.3	Vents in Dead Pockets	281
8.3.4	Vents with Porous Metals	282
8.3.5	3D Printed Porous Inserts	284
8.4	Venting Best Practices	285
8.4.1	Venting Simulation	285

8.4.2	Vent Sensing	287
8.5	Chapter Review	288
9	Cooling System Design	291
9.1	Objectives in Cooling System Design	291
9.1.1	Maximize Heat Transfer Rates	291
9.1.2	Maintain Uniform Wall Temperature	292
9.1.3	Minimize Mold Cost	292
9.1.4	Minimize Volume and Complexity	293
9.1.5	Maximize Reliability	293
9.1.6	Facilitate Mold Usage	293
9.2	The Cooling System Design Process	294
9.2.1	Calculate the Required Cooling Time	294
9.2.2	Evaluate Required Heat Transfer Rate	300
9.2.3	Assess Coolant Flow Rate	301
9.2.4	Assess Cooling Line Diameter	302
9.2.5	Select Cooling Line Depth	305
9.2.6	Select Cooling Line Pitch	308
9.2.7	Cooling Line Routing	310
9.2.8	Cooling Simulation	313
9.3	Cooling System Designs	318
9.3.1	Cooling Line Networks	318
9.3.2	Cooling Inserts	320
9.3.3	Highly Conductive Inserts	321
9.3.4	Cooling of Slender Cores	323
9.3.4.1	Cooling Insert	323
9.3.4.2	Baffles	324
9.3.4.3	Bubblers	325
9.3.4.4	Heat Pipes	326
9.3.4.5	Conductive Pin	327
9.3.4.6	Interlocking Core with Air Channel	328
9.3.5	One-Sided Heat Flow	328
9.4	Conformal Cooling	331
9.4.1	Spiral and Serpentine Designs	332
9.4.2	Network Designs	335

9.4.3	Lattice and Generative Designs	336
9.4.4	Comparison and Discussion	339
9.5	Advanced Temperature Control	341
9.5.1	Pulsed Cooling	342
9.5.2	Conduction Heating	344
9.5.3	Induction Heating	345
9.5.4	Managed Heat Transfer	347
9.6	Chapter Review	348
10	Shrinkage and Warpage	353
10.1	The Shrinkage and Warpage Analysis Process	355
10.1.1	Estimate Process Conditions	356
10.1.2	Model Compressibility Behavior	356
10.1.3	Assess Volumetric Shrinkage	358
10.1.4	Evaluate Isotropic Linear Shrinkage	361
10.1.5	Evaluate Anisotropic Shrinkage	362
10.1.6	Warpage Estimation	365
10.2	Shrinkage and Warpage Simulation	368
10.2.1	Methodology	369
10.2.2	Pressure and Temperature Prediction	370
10.2.3	Shrinkage Prediction	372
10.2.4	Warpage Prediction	374
10.3	Shrinkage and Warpage Design Practices	375
10.3.1	Gating Dependence	375
10.3.2	Injection Compression Molding	377
10.3.3	Processing Corrections	379
10.3.4	Semicrystalline Plastics	380
10.3.5	Effect of Fillers	381
10.3.6	Shrinkage Range Estimation	382
10.3.7	Mold Commissioning and Shrinkage Validation	383
10.3.8	“Steel Safe” Mold Design	388
10.3.9	Warpage Avoidance and Compensation	391
10.4	Chapter Review	392

11	Ejection System Design	395
11.1	Objectives in Ejection System Design	398
11.1.1	Allow Mold to Open	398
11.1.2	Transmit Ejection Forces to Moldings	398
11.1.3	Minimize Distortion of Moldings	399
11.1.4	Maximize Ejection Speed	399
11.1.5	Minimize Cooling Interference	400
11.1.6	Minimize Impact on Part Surfaces	400
11.1.7	Minimize Complexity and Cost	401
11.2	The Ejector System Design Process	402
11.2.1	Identify Mold Parting Surfaces	402
11.2.2	Estimate Ejection Forces	402
11.2.3	Determine Ejector Push Area and Perimeter	409
11.2.4	Specify Type, Number, and Size of Ejectors	411
11.2.5	Lay Out Ejectors	413
11.2.6	Detail Ejectors and Related Components	416
11.3	Ejector System Analyses and Designs	418
11.3.1	Ejector Pins	418
11.3.2	Ejector Blades	420
11.3.3	Ejector Sleeves	423
11.3.4	Stripper Plates	424
11.3.5	Elastic Deformation around Undercuts	426
11.3.6	Core Pulls	428
11.3.7	Slides	433
11.3.8	Early Ejector Return Systems	436
11.4	Advanced Ejection Systems	438
11.4.1	Split Cavity Molds	438
11.4.2	Collapsible Cores	440
11.4.3	Rotating Cores	442
11.4.4	Reverse Ejection	444
11.5	Chapter Review	445
12	Structural System Design	449
12.1	Objectives in Structural System Design	450
12.1.1	Minimize Stress	450

12.1.2	Minimize Mold Deflection	455
12.1.3	Minimize Mold Size	456
12.2	Analysis and Design of Plates	456
12.2.1	Plate Compression	457
12.2.2	Plate Bending	460
12.2.3	Support Pillars	463
12.2.4	Shear Stress in Side Walls	470
12.2.5	Interlocks	471
12.2.6	Stress Concentrations	475
12.3	Analysis and Design of Cores	478
12.3.1	Axial Compression	478
12.3.2	Compressive Hoop Stresses	480
12.3.3	Core Deflection	481
12.4	Fasteners	485
12.4.1	Fits	485
12.4.2	Socket Head Cap Screws	489
12.4.3	Dowels	492
12.5	Chapter Review	494
13	Mold Technologies	497
13.1	Introduction	497
13.2	Coinjection Molds	499
13.2.1	Coinjection Process	500
13.2.2	Coinjection Mold Design	501
13.3	Gas Assist/Water Assist Molding	503
13.4	Insert Molds	505
13.4.1	Low Pressure Compression Molding	506
13.4.2	Insert Mold with Wall Temperature Control	507
13.4.3	Lost Core Molding	509
13.5	Injection Blow Molds	511
13.5.1	Injection Blow Molding	511
13.5.2	Multilayer Injection Blow Molding	513
13.6	Multishot Molds	515
13.6.1	Overmolding	516
13.6.2	Core-Back Molding	517
13.6.3	Multi-station Mold	519

13.7	In-Mold Decoration	521
13.7.1	Statically Charged Film	522
13.7.2	Indexed Film	523
13.8	Chapter Review	525
14	Mold Commissioning	529
14.1	Mold Commissioning Objectives	529
14.1.1	Certify Mold Acceptability	529
14.1.2	Optimize Molding Process and Quality	531
14.1.3	Develop Mold Operation and Maintenance Plans	531
14.2	Commissioning Process	532
14.2.1	Mold Design Checklist	533
14.2.2	Component Verification	535
14.2.3	Mold Assembly	535
14.2.4	Mold Final Test	536
14.2.5	Preliminary Molding Recommendations	536
14.3	Molding Trials	539
14.3.1	Filling Stage	540
14.3.2	Packing Stage	542
14.3.3	Cooling Stage	544
14.4	Production Part Approval	545
14.4.1	Gauge and Process Repeatability & Reproducibility	545
14.4.2	Dimensional Metrology	548
14.4.3	Process Capability Evaluation	549
14.5	Process Automation and Industry 4.0 Support	553
14.5.1	Quality Assurance	553
14.5.2	Recommended In-Mold and Machine Instrumentation	554
14.5.3	Definition of Synthetic Data	558
14.5.4	Multivariate Modeling for On-line Control	561
14.6	Mold Maintenance	568
14.6.1	Pre-Molding Maintenance	570
14.6.2	Molding Observation and Mold Map	570
14.6.3	Post-Molding Maintenance	572
14.6.4	Scheduled Regular Maintenance	572
14.6.5	Mold Rebuilding	573
14.7	Summary	574

Appendix	579
Appendix A: Plastic Material Properties	580
Appendix B: Mold Material Properties	588
Nonferrous Mold Materials	588
Commodity Mold Materials	589
Specialty Mold Materials	590
Appendix C: Properties of Coolants	591
Appendix D: Estimation of Melt Velocity for Adiabatic Mold Filling	592
The Author	595
Index	597