

Contents

Preface to the second edition	V
Preface to the first edition	VI
1 Principles of mold design	1
1.1 Types of injection molds	1
1.2 Types of runners and gates	2
1.2.1 Solidifying systems	2
1.2.2 Hot-runner-systems	4
1.2.3 Cold-runner systems	5
1.3 Temperature control in injection molds	5
1.4 Types of ejectors	5
1.5 Types of undercuts	6
1.6 Special designs	6
1.6.1 Molds with fusible cores	6
1.6.2 Prototype molds of aluminium	6
1.6.3 Prototype molds of plastics	7
1.7 Standard mold components	7
1.8 Status of standardization	7
1.8.1 Standard components	7
1.8.2 Injection mold for producing test specimens of thermoplastic resins	7
1.9 Material selection	7
1.9.1 General	7
1.9.2 Tool steels	8
1.9.2.1 Case-hardening steels	8
1.9.2.2 Heat-treatable steels	8
1.9.2.3 Through-hardening steels (Table 5)	8
1.9.2.4 Corrosion-resistant steels (Table 6)	8
1.10 Surface treatment methods	9
1.10.1 Nitriding	9
1.10.2 Carburizing	10
1.10.3 Hard chrome plating	10
1.10.4 Hard nickel plating	10
1.10.5 Hardcoating	10
1.11 Special materials	10
1.11.1 Metal-carbide	10
1.11.2 Materials with high thermal conductivity	10
1.12 Mold for processing thermosets	11
1.12.1 Mold construction	11
1.12.2 Part-forming surfaces	11
1.12.3 Ejection/venting	11
1.12.4 Heating/insulation	12
1.12.5 Runner/gate design	12
1.13 Molds for processing elastomers	14
2 Overview and classification of mold examples	17
3 Examples	18
3.1 Single-cavity injection mold for a polyethylene cover	18
3.2 Two-cavity unscrewing mold for glass-fiber-reinforced nylon (polyamide) threaded plug	20
3.3 Eight-cavity injection mold for brush handles	22
3.4 Five-cavity injection mold for tablet tubes of polystyrene	25
3.5 Twelve-cavity injection mold for blouse hangers	25
3.6 Mold base with interchangeable inserts to produce standard test specimens	28
3.7 Injection mold for cover components of ABS	30
3.8 Six-cavity mold for measuring spoons	32
3.9 Injection mold for magnifying glass frame with handle	34
3.10 Two-cavity injection mold for a glue dispenser	36
3.11 Four-cavity injection mold for a housing of acrylonitrile-butadiene-styrene (ABS)	38

3.12	Four-cavity injection mold for a nozzle housing of polyamide (nylon)	40
3.13	Single split-cavity mold for a threaded plug of polyoxymethylene	42
3.14	Molding a container with external undercuts	44
3.15	Injection mold with reduced opening stroke for milk crates	45
3.16	Two-cavity injection mold for recessed handles refrigerator handles of polyamide	47
3.17	Injection mold for a grass catcher of polypropylene	50
3.18	Injection mold for hose connectors of polyamide (nylon) 6.6	52
3.19	Two-cavity injection mold for the coil form of an auxiliary relay	54
3.20	Injection mold for a housing of polypropylene	56
3.21	Four-cavity injection mold for producing a thrust screw of polyacetal	58
3.22	Mold for a pump housing and pump piston of polyacetal	60
3.23	Hot-runner injection mold for two film spools of high-impact polystyrene	63
3.24	Injection mold for an angle fitting	65
3.25	Mold for bushings with concealed gating	65
3.26	Injection mold for the valve housing of a water-mixing tap made from polyacetal	66
3.27	Mold for a lid with three threads	68
3.28	Two-cavity injection mold for coupling sleeves of polyamide	70
3.29	Four-cavity injection mold for producing tapered tubes	72
3.30	Four-cavity mold for box and lid	74
3.31	Two-cavity side-action injection mold for wire bobbins	76
3.32	Injection mold for polypropylene container with a threaded neck	78
3.33	Three-plate injection mold with stripping device for a precision magazine	80
3.34	Three-cavity injection mold for a cosmetic cream container with a threaded lid	82
3.35	Mold for a polyamide V-belt pulley	84
3.36	8 + 8-cavity hot-runner stack mold for yoghurt cups of polypropylene	86
3.37	2 + 2-cavity stack mold for covers of polypropylene	88
3.38	5 + 5-cavity stack mold for a case of polypropylene	90
3.39	Four-cavity hot-runner stack mold for producing automotive inner sill trim of polypropylene	94
3.40	Hot-runner stack mold for a water distribution block of polypropylene	98
3.41	8 + 8-cavity stack mold for lozenge box in polystyrene	103
3.42	Two-cavity hot-runner stack mold for trays	106
3.43	2 + 2-cavity stack mold with a hot-runner system for runnerless molding of polystyrene container lids using direct edge gating	108
3.44	4 + 4-cavity hot-runner stack mold for dessert cups of polypropylene	112
3.45	Hot-runner mold for bumper fascia of thermoplastic elastomer	114
3.46	Four-cavity hot-runner mold for threaded covers of SAN	116
3.47	Two-cavity hot-runner mold for trim bezels of ABS	118
3.48	Four-cavity hot-runner mold for control flap of acetal (POM) copolymer	120
3.49	64-cavity hot-runner mold for seals of thermoplastic elastomer (TPE)	122
3.50	Eight-cavity hot-runner mold for PP toothpaste dispenser	124
3.51	Two-cavity hot-runner mold for tubs of polyethylene	126
3.52	Two-cavity hot-runner mold for production of connectors of polycarbonate	128
3.53	Four-cavity hot-runner unscrewing mold for cap nuts of polyacetal (POM)	130
3.54	Four-cavity hot-runner mold with a special ejector system for a retainer of polypropylene	132
3.55	Two-cavity hot-runner mold for fuel tank cap production in polyacetal copolymer	136
3.56	32-cavity hot-runner mold for production of packings of polyethylene	138
3.57	12-cavity hot-runner mold with edge gates for bushings of polyacetal copolymer	140
3.58	Hot-runner mold for a polycarbonate sight glass	142
3.59	Four-cavity hot-runner mold for tumblers of polyacetal copolymer	144
3.60	Four-cavity hot-runner mold for high-strength ski bindings of polyacetal copolymer	146
3.61	Eight-cavity hot-runner mold for closure plugs	148
3.62	Single-cavity injection compression mold for a cover plate of unsaturated polyester resin	150
3.63	Two-cavity injection compression mold for a housing component of a thermosetting resin	152
3.64	Injection compression mold for a plate of melamine resin	154
3.65	Five-cavity unscrewing mold for ball knobs of a thermoset resin	155
3.66	Four-cavity injection mold for a thin-walled housing of a thermosetting resin	156
3.67	20-cavity injection mold for cold-runner manifold for rubber bumpers	158
3.68	Eight-cavity injection mold for manufacturing bellows of silicone rubber	160
3.69	Two injection molds for overmolding of nylon tubing for automobile power window operators	162
3.70	Single-cavity injection mold for a housing base of polycarbonate	164
3.71	Connector of glass-fiber-reinforced nylon with opposing female threads	166

3.72	Cylindrical thermoplastic container with reduced-diameter opening – a study in part release	168
3.73	Single-cavity injection mold for a lighting fixture cover of polymethylmethacrylate (PMMA) . . .	170
3.74	Injection mold for a housing of polycarbonate with a thread insert	172
3.75	Mold for long, thin, tubular parts of polystyrene	174
3.76	16-cavity injection mold with degating for ballpoint pen barrels	177
3.77	Injection mold for parts with several parting lines perpendicular to the direction of opening.	178
3.78	Injection mold for battery caps with undivided external thread and sealing cone	180
3.79	Injection mold for a curved pouring spout	182
3.80	Injection mold for an ABS spectacle frame	184
3.81	Eight-cavity injection mold for the upper halves of cable clamps.	186
3.82	Two-cavity injection mold for pistol grips of polyamide	189
3.83	Injection mold for pipe fittings.	192
3.84	Injection mold with hydraulic core pull for a cable socket.	194
3.85	Two-cavity injection mold for hose connectors	196
3.86	Eight-cavity injection mold for fountain pen caps	198
3.87	Two-cavity mold for water tap handles	200
3.88	Two-cavity injection mold for the automatic molding of conveyor plates onto a wire cable	202
3.89	20-cavity hot-runner mold for producing curtain-ring rollers of polyacetal copolymer	204
3.90	Injection mold with attached hydraulic core pull of automatic measuring tube production	206
3.91	Three-cavity injection mold for liquid-measuring cylinders	208
3.92	16-cavity injection mold for production of tube caps.	210
3.93	Four-cavity injection mold for dials.	212
3.94	Injection mold with air ejection for polypropylene cups	214
3.95	Molds for manufacturing optical lenses	216
3.96	Two-cavity injection mold for a polycarbonate steam iron reservoir insert	218
3.97	Injection mold with pneumatic sprue bushing for headlight housing of polypropylene.	220
3.98	Unscrewing device for an injection mold for a junction box of polyamide	222
3.99	Alternative mold designs for a thermoplastic pump impeller.	224
3.100	Six-cavity injection mold for watch crystals	228
3.101	Four-cavity injection mold for thin-walled sleeves of polyester	230
3.102	Single-cavity injection mold for thermos bottle cups.	232
3.103	Eight-cavity injection mold for producing threaded sleeves.	234
3.104	Four-cavity hot-runner injection mold for 3-liter-bottle closures.	237
3.105	Six-cavity injection mold for retaining nuts with metal inserts'	239
3.106	Single-cavity injection mold for a switch housing of polyacetal	240
3.107	Single-cavity injection mold for a snap ring of polyacetal	242
3.108	Single-cavity hot-runner injection mold for an air vent housing of acrylonitrile butadiene styrene (ABS)	244
4.	The Authors	247