

# Contents

<b>Preface</b> . . . . .	vii
<b>Contributors</b> . . . . .	xix
<b>1 Introduction</b> . . . . .	1
<i>P. J. Gramann, T. A. Osswald</i>	
1.1 Historical Background . . . . .	1
1.2 The Reciprocating Screw Injection Molding Machine . . . . .	9
1.2.1 The Plasticating and Injection Unit . . . . .	9
1.2.2 The Clamping Unit . . . . .	10
1.2.3 The Mold Cavity . . . . .	11
1.3 The Injection Molding Cycle . . . . .	13
1.4 Related Injection Molding Processes . . . . .	17
References . . . . .	18
<b>2 Injection Molding Materials</b> . . . . .	19
<i>T. A. Osswald</i>	
2.1 Historical Background . . . . .	19
2.2 Macromolecular Structure of Polymers . . . . .	23
2.3 Molecular Weight . . . . .	27
2.4 Conformation and Configuration of Polymer Molecules . . . . .	30
2.5 Thermoplastic Polymers . . . . .	34
2.5.1 Amorphous Thermoplastics . . . . .	34
2.5.2 Semi-Crystalline Thermoplastics . . . . .	36
2.5.3 Examples of Common Thermoplastics . . . . .	43
2.6 Thermosetting Polymers . . . . .	46
2.6.1 Cross-Linking Reaction . . . . .	46
2.6.2 Examples of Common Thermosets . . . . .	48
2.7 Copolymers and Polymer Blends . . . . .	49
2.8 Elastomers . . . . .	51
<i>M. DeGreiff</i>	
2.9 Efficient Vulcanizing Systems . . . . .	52
2.10 Thermoplastic Elastomers . . . . .	53
<i>G. Holden</i>	
2.10.1 Service Temperatures . . . . .	54
2.10.2 Examples of Common Thermoplastic Elastomers . . . . .	55
References . . . . .	61

<b>3</b>	<b>Processing Fundamentals</b> . . . . .	63
	<i>T. A. Osswald</i>	
3.1	Processing Data . . . . .	63
3.1.1	Temperature Settings . . . . .	64
3.1.2	Injection and Pack-Hold Pressure Settings . . . . .	64
3.1.3	Drying . . . . .	66
3.1.4	Processing Data for Thermoplastic Elastomers . . . . .	66
	<i>G. Holden</i>	
3.1.5	Processing Data for Thermosets . . . . .	71
3.1.6	Processing Data for Elastomers . . . . .	72
3.2	Rheology of Polymer Melts . . . . .	72
3.2.1	Shear Thinning Behavior of Polymers . . . . .	73
3.2.2	Simplified Flows Common in Injection Molding . . . . .	75
3.2.3	Estimating Injection Pressure and Clamping Force (Stevenson Model) . . . . .	78
3.2.4	Nonisothermal Flows in Polymer Processing . . . . .	83
3.2.5	Normal Stresses in Shear Flow . . . . .	83
3.2.6	Deborah Number . . . . .	84
3.2.7	Rheology of Curing Thermosets . . . . .	85
3.2.8	Suspension Rheology . . . . .	87
3.3	Rheometry . . . . .	87
3.3.1	The Melt Flow Indexer . . . . .	88
3.3.2	The Capillary Viscometer . . . . .	88
3.3.3	Viscosity from the Capillary Viscometer . . . . .	89
3.4	Anisotropy Development During Processing . . . . .	91
3.4.1	Orientation in the Final Part . . . . .	91
3.4.2	Fiber Damage . . . . .	100
3.5	Solidification and Curing Processes . . . . .	102
3.5.1	Solidification of Thermoplastics . . . . .	103
3.5.2	Solidification of Thermosets . . . . .	112
3.5.3	Residual Stresses, Shrinkage, and Warpage . . . . .	117
	References . . . . .	122
<b>4</b>	<b>Plasticating</b> . . . . .	125
	<i>C. Rauwendaal, P. J. Gramann</i>	
4.1	The Plasticating Unit . . . . .	125
4.1.1	The Ram Extruder . . . . .	126
4.1.2	The Reciprocating Screw . . . . .	127
4.2	Functions of the Plasticating Unit . . . . .	140
4.2.1	Solids Conveying . . . . .	140
4.2.2	Melting or Plasticating . . . . .	144
4.2.3	Melt Conveying . . . . .	151
4.2.4	Degassing or Devolatilization . . . . .	157
4.2.5	Mixing . . . . .	158
4.3	Conclusion . . . . .	177
	References . . . . .	178

<b>5 Clamping Unit</b> . . . . .	181
<i>R. Farrell</i>	
5.1 Metal Fatigue and Its Importance in Clamp Design . . . . .	181
5.1.1 Importance in Clamp Design . . . . .	181
5.1.2 A Brief History of Metal Fatigue . . . . .	182
5.1.3 The Three Phases of Metal Fatigue . . . . .	182
5.1.4 Determination of Design Stress for Metal Fatigue . . . . .	183
5.1.5 Determination of Survival Factor (SF) . . . . .	191
5.1.6 Conclusion of Discussion of Metal Fatigue . . . . .	193
5.2 Functions of the Clamping System . . . . .	193
5.3 The Three Types of Clamping Systems . . . . .	194
5.3.1 Hydraulic . . . . .	194
5.3.2 Hydromechanical . . . . .	195
5.3.3 Mechanical . . . . .	196
5.3.4 Types of Toggle Systems . . . . .	198
5.4 Key Elements of a Clamp . . . . .	200
5.4.1 Platens . . . . .	200
5.4.2 Tie Rods and Nuts . . . . .	213
5.4.3 Toggle Pins and Bushings . . . . .	217
5.4.4 Tie-Rod Bushings . . . . .	221
5.4.5 Moving Platen Support . . . . .	222
5.4.6 Shut Height Adjustment . . . . .	222
5.4.7 Ejector Systems . . . . .	226
5.5 A Special Discussion of Tie-Rod Design . . . . .	227
5.5.1 Why This Element Is So Important . . . . .	227
5.5.2 Thread Load Distribution . . . . .	227
5.5.3 Thread Bending Stress . . . . .	230
5.5.4 Thread Axial Stress . . . . .	232
5.5.5 Combined Stresses . . . . .	232
5.5.6 Mitigating Factors . . . . .	233
5.5.7 Ways to Improve the Design . . . . .	234
5.6 Understanding Clamp Spring Rate (Stiffness) . . . . .	236
5.6.1 How to Determine Clamp Spring Rate . . . . .	237
5.6.2 The Importance of Clamp Spring Rate . . . . .	238
5.7 Math Model for a Toggle Clamp . . . . .	239
5.8 The Farrell Square Root Rule . . . . .	243
5.8.1 Relationships That Follow from the Farrell Square Root Rule . . . . .	244
5.8.2 The Whole Machine Can Follow the Square Root Rule . . . . .	246
References . . . . .	246
<b>6 Mold Design</b> . . . . .	249
<i>J. Beaumont</i>	
6.1 Standard Mold Assembly . . . . .	250
6.2 Cold Runner Molds . . . . .	252
6.2.1 Two-Plate Cold Runner Mold . . . . .	252
6.2.2 Three-Plate Cold Runner Mold . . . . .	254
6.3 Hot Runner Molds . . . . .	257
6.3.1 Externally Heated Manifold and Drops . . . . .	259

6.3.2	Externally Heated Manifold with Internally Heated Drops . . . . .	259
6.3.3	Internally Heated Manifold and Internally Heated Drops . . . . .	261
6.3.4	Insulated Manifold and Drops . . . . .	262
6.3.5	Miscellaneous Hot Runner Systems Design . . . . .	263
6.3.6	Hot Sprues . . . . .	264
6.3.7	Hot Drops (Nozzles) . . . . .	265
6.3.8	Special Considerations in the Operation of Hot Runner Molds . . . . .	268
6.3.9	Stack Molds . . . . .	271
6.4	Runner Design . . . . .	272
6.4.1	Cold Runner Design . . . . .	274
6.4.2	Runner Balancing in Geometrically Balanced Runners (Cold and Hot Runners) . . . . .	276
6.4.3	Nongeometrically Balanced Runner Layouts . . . . .	284
6.5	Gate Design . . . . .	286
6.5.1	Gate Types . . . . .	286
6.5.2	Positioning Gates . . . . .	295
6.6	Structural Design of a Mold for Long Life and Rigidity . . . . .	296
6.6.1	Mold Material Selection . . . . .	296
6.6.2	Fatigue . . . . .	297
6.6.3	Deflection of Side Walls . . . . .	298
6.6.4	Core Deflection . . . . .	298
6.6.5	Deflection of Support Plates . . . . .	300
6.7	Mold Cooling . . . . .	302
6.7.1	Practical Considerations . . . . .	303
6.7.2	Thermal Expansion . . . . .	305
6.7.3	Parallel versus Series Cooling Circuits . . . . .	305
6.7.4	Baffles and Bubblers . . . . .	307
6.8	Mold Ejection Systems . . . . .	309
6.8.1	Basic Ejection Problems . . . . .	309
6.8.2	Means of Ejection . . . . .	312
6.8.3	Ejection Considerations . . . . .	315
6.8.4	Ejection Design . . . . .	316
6.9	Vent Design . . . . .	320
	References . . . . .	323

**7 Material Handling and Auxiliary Equipment . . . . . 325**

<i>S. Collins</i>		
7.1	Bulk Material Handling . . . . .	325
7.2	Pneumatic Conveying Systems. . . . .	326
7.3	Receivers and Loaders . . . . .	329
7.3.1	Self-Contained Loaders . . . . .	331
7.4	Material Handling Controls . . . . .	332
7.5	Feeders and Blenders . . . . .	333
7.6	Dryers . . . . .	336
7.7	Integrated Drying and Conditioning System . . . . .	338
7.8	Mold and Process Temperature Control . . . . .	339
7.9	Automation . . . . .	341
7.10	Granulators . . . . .	344

<b>8 Statistical Process Control</b> . . . . .	347
<i>C. Rauwendaal</i>	
8.1 Statistical Process Control . . . . .	347
8.1.1 Implementing Statistical Process Control . . . . .	347
8.1.2 Basic Statistical Concepts . . . . .	350
8.2 Control Charts . . . . .	357
8.2.1 Introduction . . . . .	357
8.2.2 Control Charts for Variables Data . . . . .	357
8.2.3 Control Charts for Attributes Data . . . . .	364
8.3 Process Capability and Special SPC Tools for Molding . . . . .	365
8.3.1 Introduction . . . . .	365
8.3.2 Capability Indexes . . . . .	366
8.3.3 Use of Computers . . . . .	369
8.3.4 Special SPC Techniques for Injection Molding . . . . .	370
References . . . . .	374
<b>9 Special Injection Molding Processes</b> . . . . .	375
<i>L.-S. Turng</i>	
9.1 Coinjection (Sandwich) Molding . . . . .	376
9.1.1 Process Description . . . . .	378
9.1.2 Process Advantages . . . . .	380
9.1.3 Process Disadvantages . . . . .	383
9.1.4 Applicable Materials . . . . .	383
9.1.5 Typical Applications . . . . .	383
9.2 Fusible (Lost, Soluble) Core Injection Molding . . . . .	385
9.2.1 Process Description . . . . .	385
9.2.2 Process Advantages . . . . .	388
9.2.3 Process Disadvantages . . . . .	388
9.2.4 Applicable Materials . . . . .	388
9.2.5 Typical Applications . . . . .	389
9.3 Gas-Assisted Injection Molding . . . . .	389
9.3.1 Process Description . . . . .	390
9.3.2 Process Advantages . . . . .	393
9.3.3 Process Disadvantages . . . . .	395
9.3.4 Applicable Materials . . . . .	395
9.3.5 Typical Applications . . . . .	395
9.4 Injection-Compression Molding . . . . .	398
9.4.1 Process Description . . . . .	398
9.4.2 Process Advantages . . . . .	399
9.4.3 Process Disadvantages . . . . .	400
9.4.4 Applicable Materials . . . . .	400
9.4.5 Typical Applications . . . . .	401
9.4.6 Computer Simulation for Injection-Compression Molding . . . . .	401
9.5 In-Mold Decoration and In-Mold Lamination . . . . .	402
9.5.1 Process Description . . . . .	402
9.5.2 Process Advantages . . . . .	404
9.5.3 Process Disadvantages . . . . .	404
9.5.4 Mold Design and Processing Considerations . . . . .	405

9.5.5	Applicable Materials	406
9.5.6	Typical Applications	407
9.6	Insert and Outsert Molding	409
9.6.1	Insert Molding Process Description	409
9.6.2	Outsert Molding Process Description	410
9.7	Lamellar (Microlayer) Injection Molding	412
9.7.1	Process Description	412
9.7.2	Process Advantages	412
9.7.3	Process Disadvantages	415
9.7.4	Applicable Materials	415
9.7.5	Typical Applications	416
9.8	Low-Pressure Injection Molding	416
9.8.1	Process Description	416
9.8.2	Process Advantages	420
9.8.3	Process Disadvantages	420
9.8.4	Applicable Materials	420
9.8.5	Typical Applications	420
9.9	Microinjection Molding	421
9.9.1	Process Description	421
9.9.2	Process Advantages	426
9.9.3	Process Disadvantages	426
9.9.4	Applicable Materials	427
9.9.5	Typical Applications	427
9.10	Microcellular Molding	427
9.10.1	Process Description	427
9.10.2	Process Advantages	430
9.10.3	Process Disadvantages	431
9.10.4	Applicable Materials	431
9.10.5	Typical Applications	431
9.11	Multicomponent Injection Molding (Overmolding)	431
9.11.1	Process Description	432
9.11.2	Process Advantages	433
9.11.3	Process Disadvantages	434
9.11.4	Applicable Materials	434
9.11.5	Typical Applications	435
9.12	Multiple Live-Feed Injection Molding	436
9.12.1	Process Description	436
9.12.2	Process Advantages	438
9.12.3	Process Disadvantages	440
9.12.4	Applicable Materials	441
9.12.5	Typical Applications	441
9.13	Push-Pull Injection Molding	441
9.13.1	Process Description	441
9.13.2	Process Advantages and Disadvantages	442
9.13.3	Applicable Materials	442
9.13.4	Typical Applications	444
9.14	Powder Injection Molding	444
9.14.1	Process Description	445
9.14.2	Process Advantages	447

9.14.3	Process Disadvantages	447
9.14.4	Typical Applications	448
9.15	Reaction Injection Molding	448
9.15.1	Process Description	448
9.15.2	Process Advantages	450
9.15.3	Process Disadvantages	450
9.15.4	Applicable Materials	450
9.15.5	Typical Applications	451
9.16	Resin Transfer Molding and Structural RIM	451
9.16.1	Process Description	451
9.16.2	Process Advantages	453
9.16.3	Process Disadvantages	453
9.16.4	Applicable Materials	453
9.16.5	Typical Applications	453
9.17	Rheomolding	454
9.17.1	Process Description	455
9.17.2	Process Advantages	456
9.17.3	Process Disadvantages	457
9.18	Structural Foam Injection Molding	457
9.18.1	Process Description	457
9.18.2	Process Advantages	460
9.18.3	Process Disadvantages	461
9.18.4	Applicable Materials	461
9.18.5	Typical Applications	464
9.19	Thin-Wall Molding	464
9.19.1	Process Description	464
9.19.2	Process Advantages	466
9.19.3	Process Disadvantages	466
9.19.4	Applicable Materials	468
9.19.5	Typical Applications	468
9.20	Vibration Gas Injection Molding	468
9.20.1	Process Description	468
9.21	Water Assisted Injection Molding	469
9.21.1	Process Description	469
9.21.2	Process Advantages	470
9.21.3	Process Disadvantages	471
9.21.4	Applicable Materials	471
9.22	Rubber Injection	471
	<i>M. DeGreiff, N. Castaño</i>	
9.22.1	Rubber Molding Processes	471
9.22.2	Curing Systems in Rubber Injection Process	474
9.23	Injection Molding of Liquid Silicone Rubber	476
	Acknowledgement	478
	References	479

<b>10 Part Design</b>	483
<i>J. Beaumont</i>	
10.1 The Design Process	483
10.2 The Four Building Blocks of Plastics Part Design	487
10.2.1 Material	487
10.2.2 Product Design	497
10.2.3 Mold Design and Machining	499
10.2.4 Process	501
10.3 Part Design Guidelines for Injection Molded Plastic Parts	514
10.3.1 Designing the Primary Wall	516
10.3.2 Ribs, Gussets, and Bosses	519
10.3.3 Bosses	522
10.3.4 Corners, Fillets, and Radii	525
10.3.5 Taper and Draft Angles	526
10.3.6 Undercuts and Holes	526
10.3.7 Gating and Process Considerations	529
10.3.8 Cores	530
10.3.9 Avoid Picture Frame Features	531
10.3.10 Integral Hinges	531
10.4 Sample Part Design	533
10.5 Estimating Part Costs	536
References	539
<b>11 Simulation in Injection Molding</b>	541
<i>B. A. Davis, A. C. Rios, V. Yang</i>	
11.1 Introduction	541
11.2 History	542
11.3 Governing Equations	545
11.3.1 Flow Models	545
11.3.2 Orientation Models	548
11.3.3 Heat Transfer Models	549
11.3.4 Constitutive Equations	551
11.4 Numerical Methods	553
11.4.1 Finite Difference Method	554
11.4.2 Finite Element Method	554
11.4.3 Boundary Element Method	555
11.4.4 Finite Volume Method	556
11.5 Simplified Calculations	557
11.5.1 Finite Difference Based Calculations	557
11.5.2 Midplane Model-Based Calculations	558
11.5.3 Solid Model-Based Calculations	559
11.5.4 True 3-D Calculations	563
11.6 Advanced Calculations	564
11.6.1 Commercial Software	565
11.6.2 Specialty Calculations	570
11.7 Injection-Compression Molding	574
11.7.1 IC Molding of Thermoplastic Materials	576
11.7.2 IC Molding of Thermoset Materials	577



11.8	Molding Process Optimization . . . . .	578
11.8.1	Optimal Gating . . . . .	578
11.8.2	Active Process Control . . . . .	578
11.9	Conclusions . . . . .	579
	Acknowledgements . . . . .	580
	References . . . . .	580
<b>12</b>	<b>Process Troubleshooting . . . . .</b>	<b>581</b>
12.1	Introduction to Troubleshooting . . . . .	581
	<i>J. Wickman, T. Springett, and R. Vadlamudi</i>	
12.2	Troubleshooting Guide . . . . .	586
12.2.1	Troubleshooting Table . . . . .	586
	<i>J. Bozzelli</i>	
12.2.2	Troubleshooting on Injection Molding of Rubber . . . . .	627
	<i>M. DeGreiff</i>	
12.2.3	Important Troubleshooting Considerations . . . . .	631
	<i>T. Osswald</i>	
12.3	Technology and Process Troubleshooting . . . . .	632
	<i>J. Wickman, T. Springett, and R. Vadlamudi</i>	
12.3.1	Technology Implications . . . . .	633
12.3.2	Injection Molding Process and Sensors . . . . .	634
12.3.3	Pressure Sensors . . . . .	636
12.3.4	Temperature Sensors . . . . .	638
12.3.5	Process Monitoring . . . . .	638
12.3.6	Automatic Troubleshooting . . . . .	638
12.3.7	Design of Experiments . . . . .	639
12.3.8	Factorial Design of Experiments . . . . .	640
12.4	Conclusions . . . . .	642
	<i>J. Wickman, T. Springett, and R. Vadlamudi</i>	
	References . . . . .	642
<b>13</b>	<b>Materials Troubleshooting . . . . .</b>	<b>645</b>
	<i>M. Sepe</i>	
13.1	Composition Problems . . . . .	646
13.1.1	Diagnostic Tools for the Polymer . . . . .	647
13.1.2	Diagnostic Tools for Fillers and Reinforcements . . . . .	668
13.1.3	Diagnostic Tools for Additives . . . . .	675
13.2	Molecular Weight Problems . . . . .	682
13.3	Performance Problems . . . . .	708
13.3.1	Material Selection Process . . . . .	708
13.3.2	Use of Fillers . . . . .	715
13.3.3	Deflection Temperature Under Load . . . . .	717
13.3.4	Impact Properties . . . . .	720
13.4	A Brief Discussion of Viscoelasticity . . . . .	725
13.5	Conclusion . . . . .	754
	References . . . . .	754
<b>Index . . . . .</b>		<b>755</b>