

Contents

List of Contributors	V
Dedication	VII
Preface	IX
1 Precision Injection Molding: Overview and Scaling Considerations	1
<i>J. Greener, R. Wimberger-Friedl</i>	
1.1 Introduction	1
1.2 The M-Chain of Precision Molding	1
1.3 Dimensional Integrity	4
1.3.1 Pressure History	5
1.3.2 Cooling Stresses	7
1.3.3 Shrinkage	8
1.3.4 Warpage	9
1.4 Dimensional Stability	9
1.5 Simulation	12
1.6 Summary	14
2 Instabilities in Dimensions and Shape	17
<i>L. C. E. Struik</i>	
2.1 Introduction	17
2.2 Creep-Recovery; Isothermal	17
2.3 Creep-Recovery; Nonisothermal	18
2.4 Nonisothermal Creep Recovery Accompanied by Physical Aging	21
2.5 Complicated Loading Patterns During Shaping	22
2.6 Predicting Long-Term Dimensional Instability from Short-Time Tests	24
2.7 Discussion	24
2.7.1 Applicability of the Linear Viscoelastic Theory	24
2.7.2 Factors Determining Instabilities	25
2.7.3 Related Phenomena	26
2.7.4 Volume Relaxation and Cooling Stresses	26
3 Dimensional Accuracy in Injection Molding: State of the Art and Open Challenges	29
<i>R. Pantani, G. Titomanlio</i>	
3.1 Introduction	29
3.2 Generalities on Shrinkage and Thermal Stresses	29
3.3 Parameters Affecting Shrinkage	30
3.4 Some Aspects of Injection Molding of Interest for Shrinkage Predictions ...	31

3.5	State of the Art of Shrinkage Modelling.	32
3.5.1	PVT Approach	32
3.5.2	Statistical Approach	34
3.5.3	Thermomechanical Approach	34
3.6	Elastic Modeling of Shrinkage	36
3.6.1	The Physical Basis of the Model	36
3.6.2	Definitions and Main Equations	38
3.6.3	Derivation of Shrinkage Equations	40
3.7	A Viscoelastic Approach to Shrinkage	44
3.8	A Reliable Solidification Criterion and Relaxation in the Solid State	47
3.8.1	Relevance of Solidification Criterion on Stresses and Shrinkage	50
3.9	Shrinkage and Thermal Stresses of Semicrystalline Polymers	52
3.10	Dimensional Instability After Molding	54
4	Birefringence Modeling in Optical Discs	59
	<i>T. H. Kwon, Y. B. Lee</i>	
4.1	Introduction	59
4.2	Thermal Stress and Birefringence.	60
4.3	Stress-Optical Behavior	63
4.3.1	Stress-Optical Law and Photoelasticity.	63
4.3.2	Linear Viscoelasticity and Photoviscoelasticity.	64
4.3.3	Time-Temperature Superposition.	65
4.3.4	Photoviscoelasticity Experiment	66
4.3.5	Volume Relaxation Phenomena with Free Volume Theory	67
4.4	Material Data	70
4.5	Birefringence in Injection Molded Center-Gated Disks	73
4.5.1	Physical Model	73
4.5.2	Residual Stresses and Birefringence	77
4.5.3	Numerical Modeling	78
4.5.4	Numerical Simulation Results and Discussion	85
4.6	Concluding Remarks	100
5	Shrinkage of Injection Molded Material	105
	<i>P. K. Kennedy, R. Zheng</i>	
5.1	Introduction	105
5.2	Filling and Packing Analysis	105
5.2.1	Material Properties	106
5.2.2	Geometric Considerations	108
5.2.3	Simplification by Mathematical Analysis	108
5.2.4	Solution of the Governing Equations	110
5.3	Cooling Analysis	111
5.4	Shrinkage and Warpage Prediction	111
5.4.1	Residual Strain Methods	112
5.4.2	Residual Stress Models.	113

5.5	The Material Data Problem	115
5.6	Hybrid Model	116
5.6.1	The Contracted Notation	117
5.6.2	Prediction of the b_i	119
5.6.3	Using the Model.	121
5.7	Results for Unfilled Polypropylene.....	122
5.8	Results on Other Materials	125
5.8.1	ABS.....	125
5.8.2	PC.....	125
5.8.3	PC+ABS Blend.....	128
5.8.4	PBT.....	128
5.9	Filled Materials	128
5.9.1	Glass Reinforced PA66.....	131
5.9.2	Talc Filled PBT.....	131
5.10	Conclusion	131
6	Towards the Prediction of Structure Development in Injection Molded Semicrystalline Polymers	137
	<i>G. Eder, H. Janeschitz-Kriegl, E. Ratajski</i>	
6.1	Introduction	137
6.2	Phenomenology of Crystallization Patterns	138
6.3	Suitable Parameters for a Description of Underlying Processes	142
6.4	Fundamental Considerations for Quiescent Melts	145
6.5	Fundamentals of Flow-Induced Crystallization	148
6.6	Outlook	151
7	Deformation of Polycarbonate Optical Discs by Water Sorption and Aging	153
	<i>L. van der Tempel</i>	
7.1	Introduction	153
7.1.1	Water Sorption.....	155
7.1.2	Physical Aging	155
7.2	Disc Warpage by Water Sorption and Volume Relaxation	155
7.2.1	Experimental Introduction	155
7.2.2	Model.....	156
7.3	Water Sorption and Swell in Polycarbonate.....	158
7.3.1	Model.....	159
7.3.2	Measurement Methods for Swell and Diffusivity	161
7.3.3	Swell	162
7.3.4	Water Diffusion	163
7.4	Volume Shrinkage of Polycarbonate Substrates During Hot Storage	163
7.4.1	Measurements	164
7.4.2	Model.....	164
7.5	Conclusions.....	167

8	Injection Molding for Microfluidics Applications	169
	<i>L. J. Lee, L. Yu, K. W. Koelling, M. J. Madou</i>	
8.1	Introduction	169
8.2	Microfluidics	170
	8.2.1 Basic Concepts	170
	8.2.2 Micro- and Nanofluidic Functions	173
8.3	Mold (Master) Making	175
	8.3.1 LIGA	176
	8.3.2 UV-LIGA	184
	8.3.3 Comparison of Various Mold-Making Methods	190
8.4	Microfeature Injection Molding Techniques and Applications	192
	8.4.1 Molding of CDs and DVDs	192
	8.4.2 Thermoplastic Microfeature Injection Molding	194
	8.4.3 Reaction Injection Molding (RIM)	201
	8.4.4 Demolding	204
	8.4.5 Injection Molding with Nanostructures	204
8.5	Experimental Analysis of Microfeature Injection Molding	205
	8.5.1 Experiments of Microfeature Injection Molding	205
	8.5.2 Unidirectional Mold Filling with Microfeatures	210
8.6	Theoretical Analysis of Microfeature Injection Molding	212
	8.6.1 An Analytic Model for Pressure Estimation	214
	8.6.2 Simulation with Commercial Codes	215
	8.6.3 Hybrid Numerical Simulation	222
	8.6.4 Thermal Boundary Conditions	227
	8.6.5 Test of the Hybrid Numerical Scheme and Thermal Boundary Conditions	228
	8.6.6 Other Microfluidic Related Issues	232
8.7	Future Directions	233
9	Introduction to Micromolding	239
	<i>B. R. Whiteside, M. T. Martyn, P. D. Coates</i>	
9.1	Introduction	239
9.2	Technology	240
9.3	Tooling	245
9.4	Materials	248
9.5	Process Monitoring and Assessment	251
9.6	Product Property Measurement	257
9.7	Summary	262
10	Precision Process Control of Precision Injection Molding	265
	<i>D. Kazmer</i>	
10.1	Introduction	265
10.2	Fundamentals	266

10.2.1	Injection Molding Fundamentals	266
10.2.2	Process Control Fundamentals	269
10.2.3	Robust Design Fundamentals	271
10.3	Process Control Technologies	276
10.3.1	Machine Control	277
10.3.2	State Variable Control	278
10.3.3	Set-Point Control	279
10.4	Precision Process Control Development	281
10.4.1	Methodology	281
10.4.2	Example #1: Process Window Determination for DVD Manufacturing	285
10.4.3	Example #2: Dynamic Feed	289
10.5	Conclusions	292
11	Machine Hardware for Precision Injection Molding	299
	<i>J. Border</i>	
11.1	Introduction	299
11.2	Precision Injection Molding Machines	299
11.2.1	Hydraulic Control vs. Electric Control	299
11.2.2	Screw Shutoff	303
11.2.3	Melting Screws	304
11.2.4	Machine Layout	306
11.2.5	Special Material Processing	306
11.2.6	Automated Part Handling	307
11.2.7	Machine Sizes	308
11.2.8	Machine General	308
11.3	Molds	309
11.3.1	Mold Material Selection	309
11.3.2	Machining Precision	310
11.3.3	Plate Interlocks	310
11.3.4	Across the Parting Line	310
11.3.5	Mold Temperature Control	311
11.3.6	Mold Types	314
11.4	Summary	317
Index		319