

# Contents

1	Successful Development and Production of Injection Molded Parts . . . . .	1
1.1	Development of Injection Molded Plastic Products . . . . .	2
1.2	The Design Process . . . . .	4
1.3	Product Specifications (Data Collection and Product Specifications) . . . . .	7
1.4	An Overview of the Four Building Blocks of an Injection Molded Plastic Part . . . . .	14
1.4.1	Material . . . . .	14
1.4.2	Product Design . . . . .	17
1.4.3	Mold Design and Machining . . . . .	19
1.4.4	Process. . . . .	20
1.5	Integration of Product Development Through Computer-Aided Engineering. . . . .	21
1.6	Summary of the Characteristics, Advantages, and Disadvantages of Plastics. . . . .	22
1.6.1	Advantages of Plastics . . . . .	22
1.6.2	Disadvantages of Plastics. . . . .	25
2	Thermoplastics in Injection Molding. . . . .	27
2.1	Polymer Structure. . . . .	27
2.1.1	Thermoplastic Materials . . . . .	28
2.1.2	Amorphous Thermoplastic Polymers . . . . .	29
2.1.3	Semicrystalline Thermoplastic Polymers. . . . .	29
2.1.4	Thermoset. . . . .	30
2.2	Melt Rheology: Polymer Flow During Injection Molding . . . . .	30
2.2.1	Non-Newtonian Flow . . . . .	30
2.2.2	Temperature Effects on Viscosity . . . . .	32
2.2.3	Laminar Flow . . . . .	33
2.2.4	Fountain Flow . . . . .	33
2.2.5	Velocity and Shear Variations Across a Flow Channel . . . . .	34
2.2.6	Common Viscosity Models . . . . .	36
2.2.7	Molecular Weight Distribution Effect on Viscosity. . . . .	37
2.3	Shrinkage of Plastic Materials . . . . .	38
2.3.1	Volumetric Shrinkage . . . . .	38
2.3.2	Volumetric Shrinkage of Semicrystalline Polymers. . . . .	39
2.3.3	Mold Cavity Dimensions. . . . .	41
2.4	Mechanical Properties. . . . .	42
2.4.1	Definitions . . . . .	42
2.4.2	Modulus. . . . .	43

---

2.4.3	Viscoelastic Characteristics of Plastic Materials . . . . .	46
2.4.4	Deriving the Modulus for Plastic Materials . . . . .	48
2.4.5	Other Basic Mechanical Properties and Testing Techniques . . . . .	51
2.4.6	Other Useful Properties for Design . . . . .	52
2.4.7	Sources of Error in Material Data . . . . .	53
2.5	CAE Analyst Material Guidelines . . . . .	53
	References . . . . .	55
3	Injection Molding . . . . .	56
3.1	The Process: An Overview . . . . .	56
3.2	Injection Molding Parameters . . . . .	58
3.3	Mold Filling . . . . .	59
3.4	Assumptions at Start of Filling . . . . .	61
3.5	Process Physics . . . . .	62
3.6	Packing/Hold Stage . . . . .	63
3.7	Cooling . . . . .	64
3.8	Plastification and Melt Temperature Control . . . . .	68
3.9	Ejection . . . . .	68
3.10	Development and Distribution of Melt Pressures . . . . .	69
3.11	Development and Distribution of Forces on the Molding Machine . . . . .	70
3.12	Relationship of Actual Injection Parameters to Injection Molding Analysis . . . . .	71
4	Part Design Guidelines for Injection Molded Plastic Parts . . . . .	73
4.1	Designing the Primary Wall . . . . .	74
4.1.1	Maintain a Constant Wall Thickness . . . . .	74
4.1.2	Minimize Wall Thickness . . . . .	75
4.1.3	Shape of the Wall . . . . .	76
4.1.4	Surface Finish . . . . .	77
4.1.5	Ribs, Gussets, and Bosses . . . . .	77
4.1.6	Corners, Fillets, and Radii . . . . .	82
4.1.7	Taper and Draft Angles . . . . .	83
4.1.8	Undercuts and Holes . . . . .	83
4.1.9	Cores . . . . .	87
4.1.10	Avoid Picture Frame Features . . . . .	88
4.1.11	Integral Hinges . . . . .	89
4.2	Sample Part Design . . . . .	90
5	Mold Design . . . . .	94
5.1	Mold Assembly . . . . .	94
5.2	Mold Classification Based on the Melt Delivery (Runner) Design . . . . .	96
5.2.1	Cold Runner Molds . . . . .	97
5.2.2	Hot Runner Molds . . . . .	100
5.3	Runner Design . . . . .	115
5.3.1	Cold Runner Design . . . . .	117
5.3.2	Runner Balancing in Geometrically Balanced Runners (Cold and Hot Runners) . . . . .	118

5.4	Gate Design . . . . .	128
5.4.1	Gate Types . . . . .	128
5.4.2	Positioning Gates . . . . .	136
5.5	Structural Design of a Mold for Long Life and Rigidity . . . . .	138
5.5.1	Mold Material Selection . . . . .	138
5.5.2	Fatigue . . . . .	139
5.5.3	Deflection of Side Walls . . . . .	140
5.5.4	Core Deflection . . . . .	140
5.5.5	Deflection of Support Plates . . . . .	141
5.6	Mold Cooling . . . . .	143
5.6.1	Practical Considerations . . . . .	144
5.6.2	Thermal Expansion . . . . .	146
5.6.3	Parallel vs. Series Cooling Line Networks . . . . .	146
5.6.4	Baffles and Bubblers . . . . .	149
5.7	Mold Ejection Systems . . . . .	150
5.7.1	Basic Ejection Problems . . . . .	150
5.7.2	Means of Ejection . . . . .	153
5.7.3	Ejection Considerations . . . . .	155
5.7.4	Ejection Design . . . . .	157
5.8	Vent Design . . . . .	162
	References . . . . .	164
6	Mold Filling and Its Effect on the Product and Material . . . . .	165
6.1	Plastic Flow . . . . .	165
6.1.1	Melt Flow in the Part-Forming Mold Cavity . . . . .	165
6.1.2	Pressure Development During Molding . . . . .	166
6.1.3	Thermal Insulation Provided by the Frozen Layer . . . . .	171
6.1.4	Effects of Mold Filling Rate and Mold Filling Pressure . . . . .	171
6.2	Post-Filling or Packing Phase . . . . .	173
6.2.1	Thermal Shrinkage as Plastic Cools . . . . .	173
6.2.2	Compensation Flow to Offset Thermal Shrinkage . . . . .	174
6.2.3	Consequences of Low Flow Rate During the Compensation Phase . . . . .	175
6.2.4	Pressure Distribution During the Compensation Phase . . . . .	175
6.2.5	Gate Freeze-Off . . . . .	176
6.3	Cooling After Gate Freeze-Off . . . . .	177
6.4	Flow Effects on Shrinkage . . . . .	178
6.4.1	Shear-Induced Orientation . . . . .	178
6.4.2	Transient Flow-Induced Orientation . . . . .	179
6.4.3	Extensional Flow-Induced Orientation . . . . .	181
6.4.4	Shrinkage of Fiber-Reinforced Materials . . . . .	182
6.4.5	Shrinkage of Particulate-Filled Materials . . . . .	184
6.5	Warpage and Residual Stresses . . . . .	184
6.5.1	Effect of Shrinkage on Warpage and Residual Stresses . . . . .	184
6.5.2	Cooling Effects on Shrinkage and Warpage . . . . .	187
6.5.3	Residual Stress . . . . .	187
6.5.4	Annealing a Molded Part . . . . .	188
6.6	Processing Effects on Part Quality . . . . .	188

6.6.1	Mechanical Properties . . . . .	188
6.6.2	Weld Lines . . . . .	192
6.7	Defects Introduced by the Process and Mold Design . . . . .	194
6.7.1	Sinks and Voids . . . . .	194
6.7.2	Jetting . . . . .	195
6.7.3	“Flow” Marks . . . . .	196
6.7.4	Air Traps . . . . .	196
6.7.5	Burning . . . . .	197
	References . . . . .	197
7	Design and Process Strategies . . . . .	198
7.1	Maintain Uniform Wall Thicknesses in a Part. . . . .	198
7.2	Use Common Design Guidelines for Injection Molded Plastic Parts with Caution. . . . .	201
7.3	Establish a Simple Strategic Flow Pattern Within a Cavity. . . . .	202
7.4	Balance Filling Throughout a Mold. . . . .	206
7.4.1	Gating Position(s) Within a Cavity . . . . .	206
7.4.2	Multicavity Molds . . . . .	210
7.5	Provide for Uniform Temperatures (Mold and Melt). . . . .	212
7.6	Eliminate, Strategically Place, or Condition Welds. . . . .	213
7.7	Avoiding Flow Hesitation. . . . .	214
7.8	Managing Frictional Heating of the Melt . . . . .	215
7.9	Minimize Runner Volume in Cold Runners. . . . .	215
7.10	Avoid Excessive Shear Rates. . . . .	216
7.11	Avoid Excessive, and Provide for Uniform, Shear Stresses. . . . .	217
	References . . . . .	218
8	Prototyping. . . . .	219
8.1	When to Prototype . . . . .	219
8.2	Prototyping Methods. . . . .	220
8.2.1	Computer-Aided Design and Engineering . . . . .	221
8.2.2	Machining from Rod or Bar Stock . . . . .	222
8.2.3	Sterolithography. . . . .	223
8.2.4	Casting from Liquid Resins . . . . .	224
8.2.5	Thermoforming . . . . .	224
8.2.6	Injection Molding. . . . .	225
9	Introduction to Computer-Aided Engineering . . . . .	228
9.1	Overview of CAE Technologies and Their Application . . . . .	228
9.1.1	Background. . . . .	228
9.2	Pitfalls in Successful Application of Molding Simulation . . . . .	230
9.3	Solution Techniques and Assumptions Effecting Accuracy . . . . .	231
9.3.1	Common Simplifications and Related Errors. . . . .	234
9.3.2	Iterative Solution Techniques . . . . .	238
9.4	2-D Analysis . . . . .	241
9.4.1	Feasibility Studies (Strip Files). . . . .	241
9.4.2	Runner Analysis. . . . .	243

---

9.5	Mid-Plane 2½D Shell Analysis . . . . .	245
9.6	Dual Domain™ Modeling and Analysis . . . . .	247
9.7	Pitfalls from Modeling . . . . .	247
9.8	Pitfalls from Material Data. . . . .	250
9.9	Pitfalls from Process Relationships . . . . .	253
9.10	Non-Technical Aspects . . . . .	255
9.10.1	Who Should Perform Analysis?. . . . .	255
9.10.2	Company Environment and Politics . . . . .	256
9.10.3	Training . . . . .	256
9.10.4	Program Execution . . . . .	256
9.10.5	Interpretation of Results. . . . .	257
9.10.6	Communication . . . . .	257
10	The Process of Performing CAE Analysis . . . . .	259
10.1	An Overview of the Need for Injection Molding Analysis. . . . .	259
10.1.1	Stage 1: Product Development and the Product Designer. . . . .	259
10.1.2	Stage 2: Mold Design . . . . .	262
10.1.3	Stage 3: Processor . . . . .	262
10.2	An Outline of Procedures for Performing Injection Molding Simulation . . . . .	265
10.3	Use Experimental Design with CAE to Optimize the Design and Process. . . . .	274
11	Characterization of Thermoplastic Materials for CAE . . . . .	276
11.1	Characterization of Properties for Simulation . . . . .	276
11.2	Sensitivity Study . . . . .	276
11.2.1	Process Conditions . . . . .	279
11.2.2	Simulation Results . . . . .	280
11.2.3	Interpretation . . . . .	281
11.2.4	Summary. . . . .	284
11.3	Laboratory vs. Production . . . . .	285
11.4	Rheological Testing to Determine Melt Viscosity. . . . .	285
11.4.1	ASTM D 3835, Rheological Properties of Thermoplastics with a Capillary Rheometer . . . . .	286
11.5	Thermal Characterization. . . . .	287
11.5.1	Thermal Conductivity . . . . .	287
11.5.2	Specific Heat . . . . .	287
11.5.3	Density and PVT Relationships. . . . .	288
11.5.4	Transition Temperature . . . . .	290
11.6	Structural Properties . . . . .	291
11.7	Mechanical Properties . . . . .	291
12	Geometry Modeling for Injection Molding Analysis . . . . .	293
12.1	Two-Dimensional Analysis. . . . .	294
12.2	Finite Element Shell Models (2½ Dimensional) . . . . .	297
12.2.1	Guidelines for Mesh Density . . . . .	297
12.2.2	Considerations of Model Detail. . . . .	302
12.2.3	Mesh Density for Filling and Packing Analysis . . . . .	303

---

12.2.4	Mesh Needs for Cooling Analysis . . . . .	303
12.2.5	Shrinkage and Warpage Analysis . . . . .	303
12.3	Three-Dimensional Models Converted to $2\frac{1}{2}$ Dimensional Models for Shell Analysis . . . . .	304
12.4	Three-Dimensional Analysis . . . . .	304
13	Filling and Packing Analysis . . . . .	306
13.1	Theory and Assumptions . . . . .	306
13.1.1	Fluid Dynamics and Laminar Flow . . . . .	306
13.1.2	Fountain Flow . . . . .	306
13.1.3	Symmetry About the Midplane Is Assumed for Preliminary Flow Approximations . . . . .	307
13.1.4	Temperature Gradient Between Mold Wall and Center . . . . .	308
13.1.5	Specific Volume ( $v \sim 1/p$ ), as a Function of Temperature and Pressure . . . . .	309
13.1.6	Specific Heat ( $C_p$ ) as a Function of Temperature . . . . .	310
13.1.7	Thermal Conductivity ( $k$ ) as a Function of Transformation . . . . .	311
13.1.8	Transition and No-Flow Temperatures . . . . .	312
13.1.9	The Melt Viscosity of a Specific Plastic Compound Is a Function of Temperature, Pressure, and Shear Rate. . . . .	312
13.2	Multilaminate Solution . . . . .	313
13.3	Process Optimization . . . . .	314
13.3.1	What Should Be Optimized? . . . . .	314
13.3.2	Relationships to Part Quality . . . . .	318
	Reference . . . . .	324
14	Mold Cooling Analysis; CAE and the Boundary Element Method . . . . .	325
14.1	Uniform Cooling and Its Effect on Warpage . . . . .	326
14.2	Cooling Processing Optimization . . . . .	327
14.3	Modeling Issues . . . . .	332
15	Shrinkage and Warpage Analysis . . . . .	335
15.1	Causes of Warpage . . . . .	335
15.1.1	Differential Shrinkage Through the Part Thickness . . . . .	336
15.1.2	Differential Area Shrinkage; Two-Dimensional Shrinkage . . . . .	338
15.1.3	Differential Shrinkage Produced by Orientation Effects . . . . .	339
15.2	Warpage Stability and Prediction . . . . .	339
15.2.1	Small Deflection Analysis . . . . .	340
15.2.2	Buckling Analysis . . . . .	341
15.2.3	Large Deflection Analysis . . . . .	341
15.3	Warpage Diagnosis . . . . .	342
15.3.1	Diagnosis of Differential Shrinkage Through the Part Thickness . . . . .	343
15.3.2	Diagnosis of Differential Area Shrinkage . . . . .	344
15.3.3	Diagnosis of Orientation-Induced Differential Shrinkage . . . . .	348
15.4	Residual Stress . . . . .	348
15.4.1	Residual Stress Development . . . . .	348

---

15.4.2	Short and Long Term Effects . . . . .	349
15.4.3	Stress Relaxation . . . . .	349
15.5	Shrinkage Prediction for Tight Tolerance Products . . . . .	349
15.5.1	Isotropic Shrinkage versus Anisotropic Shrinkage . . . . .	349
15.5.2	Volumetric versus Linear Shrinkage . . . . .	350
15.6	Interpretation and Application. . . . .	350
15.6.1	Warpage Results Interpretation . . . . .	351
15.6.2	Warpage Diagnosis—Determining the Causes . . . . .	354
15.6.3	Minimizing Warpage—One Approach . . . . .	354
	<b>Index.</b> . . . . .	<b>357</b>