

Index

- A**
- Additives, diagnostic tools for, 675–682
 - Adjusted fatigue strength, 190
 - Advani and Tucker, 548
 - Aerated materials, 327
 - de-aerated, 327
 - Airflow, 337
 - Alternating copolymers, 49
 - Amorphous thermoplastics, 34–36
 - angled receivers, 331
 - Anisotropy development during
 - processing, 91–102
 - fiber damage, 100–102
 - orientation, 91–100
 - processing thermoplastic polymers, 91–99
 - processing thermoset polymers, 99–100
 - Articulated-arm robots, 342
 - Atacticity, 31
 - Automatic troubleshooting, 639
 - Automation, 341
 - robotic, 341
 - Auxiliary Equipment, 325
 - Avrami equation, 107–109
- B**
- Backgrinding, 630
 - Baffles and bubblers, 307–308
 - Bakelite, 20
 - Ball check valve, 134
 - Barrel, 137
 - Barrier screws, 132–133
 - Beam or traverse robots, 342
 - Beck, H., 6, 7
 - Benchmarking, 583–584
 - Bipolymer, 49
 - Birefringence, 91–95
 - Black specks, 586–587
 - Black streaks, 588
 - Blenders, 333
 - Blending ingredients, 68–69
 - Blister ring, 171–172
 - Blisters, 629
 - Block copolymers, 49
 - Blooming, 589
 - Blush, 589–590
 - Bosses, 522–525
 - Boundary element method (BEM), 555–556
 - Brunelle hardness number (BHN), 186
 - Brinkman number, 79, 83
 - Brittleness, 590–591
 - Bubbles, 592–593
 - Bulk Material Handling, 325
 - Burns, 593–595
- C**
- Capability indexes, 366–369
 - process capability shortcut with precontrol, 368–369
 - types of
 - capability index (CPK), 366–369
 - capability ratio (CR), 367
 - process potential index (CP), 366–367
 - Capability ratio (CR), 367–368
 - Capillary viscometer, 88–89
 - Carbon tetravalency, 30
 - Carothers, W., 21
 - Cashew gate, 292–293
 - Castro-Macosko curing model, 115
 - Cellulose nitrate, 20
 - Chaffee, E. M., 20
 - Char content, 662–667
 - chiller, 340
 - Chisel gate, 293
 - Chlorinated olefin interpolymer alloys, 60
 - polyamid/elastomer block copolymers, 61
 - polyester/elastomer block copolymers, 61
 - polyethylene/(polyolefin rubber) block copolymers, 58–59
 - polypropylene/(EPR + oil) blends, 57–58
 - polypropylene/(rubber + oil) dynamic vulcanizates, 58
 - polypropylene/(S-EB-S + oil) blends, 57
 - polystyrene/(S-B-S + oil) blends, 55–56
 - polyurethane/1 block copolymers, 60–61
 - PVC/(NBR + plasticizer) blends, 59–60
 - Clamp, elements of, 200–227
 - ejector systems, 226–227
 - moving platen support, 222
 - platens, 200–213
 - shut height adjustment, 222–226
 - tie-bar-less machines, 215–217
 - tie-rod bushings, 221–222
 - tie-rod design, 227–236
 - tie rods and nuts, 213–217
 - toggle pins and bushings, 217–221
 - Clamp design, 181
 - Clamping system, functions of, 193–194
 - Clamping unit, reciprocating screw injection molding machine, 10–11
 - cooling system, 11
 - ejector system, 11
 - gate, 11, 13
 - mold cavity, 11–13
 - sprue and runner system, 11–13
 - Clamp spring rate, 237–240
 - determination of, 237–238
 - importance of, 238–239
 - Clean rooms, 330–331
 - and apparel, 331
 - entry to, 331
 - FDA standards, 331
 - Cloudiness in clear parts, 594
 - cohesiveness, 327
 - Coinjection (sandwich) molding, 17, 376–385
 - applicable materials, 383
 - process advantages, 380–382

- process description, 378–380
- process disadvantages, 383
- typical applications, 383–385
- Cold runner design, 274–275
- Cold runner molds, 252–257
 - three-plate, 254–257
 - two-plate, 252–254
- Colombo, R., 21
- Colorant, 69
- Color mixing, 594–596
- Color variation, instability, or shift, 596–597
- Compression molding, 471–472
- Computers, use of, 369–370
- Condensation polymerization, 112–113
- Conditioning Systems, 338
- Contiguous solids melting (CSM) model, 145–146
- continuous blenders, 335
- Control charts, 357–365
 - for attributes data, 364–365
 - for variables data, 357–364
 - \bar{X} Bar and R Chart, 358–361
- conveyors, 326
- coolant loops, 340
- Cooling towers, 340
- Copolymers and polymer blends, 49–50
 - alternating copolymers, 49
 - bipolymer, 49
 - block copolymers, 49
 - graft copolymers, 49
 - polymer blends, 49
 - random copolymers, 49
 - styrene-butadiene-rubber, 49
 - terpolymer, 49
- Core pin bending, 597
- Cores, 530–531
- Corners, fillets, and radii, 525–526
- Cracking, 597–598
- Crazing, 598
- CRD mixing section, 173–174
- Cross-linked polyurethanes (PU), 48
- Cross-linking reaction, 71–72
- Cross-WLF viscosity model, 550–551
- Crystallinity, degree of, 37
- Crystallization, 106–109
 - Avrami equation, 107–109
 - deformed crystals, 107
 - degree of, 103–104
 - heat of, 103
 - maximum crystalline growth rate, 109
 - sherulites, 107
 - shish-kebob, 107
 - single crystals, 107
- Cure kinetics during solidification, 113–115
 - Castro-Macosko curing model, 115
 - cure, degree of, 114–115
 - heat activated cure, 113–114
 - heat transfer during cure, 115–117
 - mixing activated cure, 113–114
- Curing reaction during solidification, 112–113
- Cycling Loaders, 325
- Cycle time, 598–599
- D**
- Darnell and Mol, 141–142
- Deborah number, 84–85
 - extrudate swell, 85
 - fluid memory, 85
 - melt fracture, 85
 - Newtonian fluids, 85
 - shark skin, 85
- Deformation, 160
- Degassing or devolatilization, 157–158
 - conditions for, 158
 - two-stage screw, 157
- Delamination, 599–600, 627–628
- Demixing, 163–164
- desiccant dryer, 336
- desiccant wheel-type dryer, 337
- Deviatoric stress, 73–74
- Dewolfe, A. G., 20
- Dewpoint, 337
- Diagnostic tools, 647–668
 - additives, diagnostic tools for, 675–682
 - char content, 662–667
 - complexity and cost, 703–704
 - data analysis, 688
 - differential scanning calorimetry (DSC), 650–655
 - DSC test results, 657–662
 - EVA copolymer, 667–668
 - fillers and reinforcements, 668–675
 - infrared spectroscopy, 647–650
 - molecular size, 701–703
 - molecular weight problems, 682–708
 - shear rates, 688–698
 - shear-thinning effects, 704–708
 - thermogravimetric analysis (TGA), 655–657
 - viscosity, measurement of, 699–701
- Diaphragm gate, 290–291
- Differential scanning calorimetry (DSC), 650–655
- Dimensional variations, 600–602
- Dimensionless clamping force, 79
- Dimensionless injection pressure, 80
- Dimensionless temperature, 79
- Dimensionless time, 79
- Dispersive mixing, 164–166
- Distributive mixing, 159–163
 - deformation, 160
 - demixing, 163–164
 - Erwin's ideal mixer, 162
 - Reynolds number, 160
- Drag-induced solids conveying, 141–144
 - Darnell and Mol, 141–142
 - forces and velocities, 142–143
- Drive, 139–140
- Dryers, 336
- Drying parameters, 66, 68
 - hopper, 336
 - temperature, 337
- DSC test results, 657–662
- Dual-zone coolant temperature control, 340
- E**
- Eichengrün-Buchholz injection molder, 3–4
- Ejection, means of, 312–314
 - air ejection, 314
 - blade ejection, 314
 - pins, 312
 - sleeves, 312
 - stripper plates, 313
 - stripper rings, 314
- Ejection considerations, 314–315
 - and release agents, 315
 - force, minimizing influence of, 315
 - problems, 315

- Ejection design, 316–319
 collapsible cores, 318
 external, 318–319
 hydraulic/pneumatic action, 316
 internal, 317–318
 lifters, 318
 mechanical pull, 316
 mechanical push, 316
 side cores or split cavities, 318
 stripping, 318
 undercuts, 317–319
 unscrewing molds, 318
- Ejector pin or push marks, 602–603
- Ejector systems, 226–227
- Elastomers, 51–52
- Epoxy (EP), 48
- erosiveness, 327
- Erwin's ideal mixer, 162
- EVA copolymer, 667–668
- Experiments, design of, 639–642
- Extrudate swell, 85
- Extrusion plastometer, 88
- F**
- Failure rate factor (FRF), 189–190
- Fan gate, 288–289
- Farrell square root rule, 243–246
- Fatigue data, adjustments to published, 187
 adjusted fatigue strength, 190
 failure rate factor (FRF), 189–190
 loading factor (LF), 187–188
 size-effect factor (SEF), 188–189
 surface finish factor (SFF), 189
 surface treatment factor (STF), 189
- Fatigue data, methods for gathering of, 184–187
 rotating beam tester, 184–186
 uniaxial fatigue testing machine, 186–187
- Feed hopper and opening, 138–139
- Feeders, 333
- Fiber damage, 100–102
- Fillers and reinforcements, diagnostic tools for, 668–675
- Film gate, 289
- Finite difference method (FDM), 553–554
- Finite element method (FEM), 554–555
- Flash, 603–604
- Flexural strength versus melt flow index, 30
- Fluid memory, 85
- Fluted mixing section, 172–173
- Folgar and Tucker, 548
- Fountain flow effect, 95–98
- Frequency distribution, characteristics of, 354–355
 distribution patterns, different, 355–356
 binomial, 355
 central limit theorem, 356
 log normal, 355
 normal, 355–356
 kurtosis, degree of, 355
 modality, 354
 multimodal, 354
 unimodal, 354
 skew, degree of, 354–355
 variability, 354
- Friability, 327
- Frictional and viscous heat generation, 144–145
- Fusible core injection molding, 17, 385–389
 applicable materials, 388–389
 process advantages, 388
 process description, 385–387
 process disadvantages, 388
 typical applications, 389
- G**
- Gas-assisted injection molding, 17, 389–397
 applicable materials, 395
 process advantages, 393–395
 process description, 390–393
 process disadvantages, 395
 typical applications, 395–397
- Gastrow, H., 5
- Gate blush, 604–605
- Gates, types of, 286–294
 cashew, 292–293
 chisel, 293
 diaphragm, 290–291
 fan, 288–289
 film, 299
 hot runner, 294
- jump, 293
 pin point, 293
 positioning, 295–296
 ring, 289–290
 sprue, 286–297
 tab, 287–288
 tunnel, 291–292
- Gating, 529–530
- Gaylord injection machine, 3
- Geometric isomers, 33
- Glass transition temperature, 35
- Gloss, 585
- Goodyear, C., 20
- Graft copolymers, 49
- Granulators, 344
- gravimetric blender, 335
 control, 334
 feeding, 334
- Gravitmetric blenders, 328
- Gravity-induced conveying, 140
- Gray, M., 20
- Gussets, 520
- Guth's equation, 87
- Gutta-percha, 20
- H**
- Heating elements, 144–145
- Heat transfer during solidification, 109–111
 cooling time, prediction of, 110–111
 Neuman solution, 109
 Stefan condition, 110
- Hele-Shaw theory, 545–547
- Hieber and Shen, 543
- Holding pressure flow, 99
- Hot runner gates, 294
- Hot runner molds, 257–271
 externally heated manifold and drops, 259
 heat conducting nozzle, 267
 hot manifold and hot drop combinations, 258
 hot drops, 265–267
 externally heated drops with gate-tip inserts, 265–266
 hot sprues, 264
 multiple hot drops, 267
 problems with, 265
 requirements for, 265
 shut off nozzles, 267
 insulated manifold and drops, 262–263

- internally heated manifold and drops, 261–262
- miscellaneous design, 263–264
- operation of, 268–271
 - back phase characteristics, 268–269
 - heat load and distribution, 268
 - hot runner diameter, 269–270
 - melt compression, 270
 - stack molds, 271
 - startup procedures, 268
- Hot tip stringing, 605–606
- Hyatt brothers' stuffing machine, 2
- Hyatt, I., 20
- Hyatt, J. W., 1, 20
- Hydraulic clamping system, 194–195
- Hydromechanical clamping system, 195–196
- I**
- Indexes and constants for thermoplastics, 75
- Infrared spectroscopy, 647–650
- Injection and pack-hold
 - pressure settings, 64–66
 - drying, 66
 - processing window for various thermoplastic polymers, 66
 - temperature setting for various thermoplastic polymers, 65
- Injection-compression molding (ICM), 17, 398–400
 - applicable materials, 399
 - process advantages, 399–400
 - process description, 398–399
 - process disadvantages, 400
 - typical applications, 401
- Injection molded plastic parts, guidelines for, 514–532
 - bosses, 522–525
 - cores, 530–531
 - corners, fillets, and radii, 525–526
 - gating, 529–530
 - integral hinges, 531–532
 - picture frame features, avoidance of, 531
 - primary wall, design of, 516–519
 - constant wall thickness, maintenance of, 516
 - surface finish, 519
 - wall, shape of, 518
 - wall thickness, minimization of, 517–518
 - ribs, gussets, and bosses, 519–522
 - taper and draft angles, 526
 - undercuts and holes, 526–529
- Injection Molding, 476
- Injection molding cycle, 13–17
 - molding diagram, 16, 17
 - shrinkage, total part, 16
 - time, 14
- Injection molding of rubber, troubleshooting, 627–630
 - air trapping, 629–630
 - backgrinding, 630
 - blisters, 629
 - delamination, 627–628
 - distortion, 627
 - long cure cycles, 628–629
 - oxidation, 630
 - porosity, 629
 - reversion, 630
 - scorch in the barrel, 628
- Injection pressure and clamping force (Stevenson Model), estimating, 78–82
- Brinkman number, 79
- dimensionless clamping force, 79
- dimensionless injection pressure, 80
- dimensionless temperature, 79
- dimensionless time, 79
- isothermal pressure, 79
- In-mold decoration (IMD) and in-mold lamination, 17, 402–408
 - applicable materials, 406–407
 - process advantages, 404
 - process description, 402–404
 - process disadvantages, 404–405
 - typical applications, 407–409
- Insert and outsert molding
 - process description, 17, 18, 408–412
 - insert molding, 404–410
 - outsert molding, 410–412
- Integral hinges, 531–532
- Integrated Drying, 338
- Isochromatics, 92
- Isotactic molecules, 32
- Isothermal force, 79
- Isothermal pressure, 79
- J**
- Jetting, 606–607
- Jump Gate, 609
- L**
- Lamellar crystal, 36
- Lamellar injection molding, 17, 412–415
 - applicable materials, 415
 - process advantages, 412–415
 - process description, 412
 - process disadvantages, 415
 - typical applications, 415
- Laplace equation, 546
- Lee, Folger, and Tucker, 543
- Liquid Silicone Rubber, 476–478
- Loaders, 329
- Loading factor (LF), 183–184
- Long cure cycles, 628–629
- Low-pressure injection molding (LPIM), 17, 416–421
 - applicable materials, 420
 - process advantages, 420
 - process description, 416–420
 - process disadvantages, 420
 - typical applications, 420–421
- M**
- Macromolecular structure of polymers, 23–27
 - polymer applications, 24
 - polymerization, degree of, 25
 - Van-der-Waals forces, 27
- Macromolecules, 19
- Maddock/Leroy mixing sections, 173
- Material Handling, 325
 - Controls, 332
- Material independent variables, 63
- Materials troubleshooting, 645–754
 - composition, 645, 646–682
 - molecular weight problems, 682–708
 - performance, 708–725

- viscoelasticity, 725–754
- Maximum screw speed, 64
- Mean, median, and mode, 351–352
 - central tendency, 351
 - mean (or average), 351–352
 - nominal, 351
- Mechanical clamping system, 196–197
- Melt conveying, analysis of, 151–157
 - degassing or devolatilization, 157–158
 - mixing, 158–175
 - coalescence, process of, 167–169
 - dispersive mixing, 164–166
 - distributive mixing, 159–163
 - economics of mixing, 166
 - flow, types of, 158–159
 - mixing sections, 169–175
 - three-zone screw, 158
- Melt flow index, 30, 88
 - extrusion plastometer, 88
- Melt fracture, 85
- Melting assumptions, 146
- Melting or plasticating, 144–151
 - contiguous solids melting (CSM) model, 145–146
 - frictional and viscous heat generation, 144–145
 - heating elements, 144–145
 - improvements in, 151
 - melting assumptions, 146
 - melting rate, 146–151
 - Newtonian fluid, 146–147
- Melting rate, 146–151
- Metal fatigue, 181–193
 - clamp, elements of, 200–227
 - clamp design, importance in, 181
 - clamping system, functions of, 193–194
 - clamp spring rate (stiffness), 236–239
 - cold runner molds, 252–257
 - design stress for, 183–190
 - Farrell square root rule, 243–246
 - hot runner molds, 257–271
 - standard mold assembly, 250–252
 - survival factor (SF), determination of, 191–193
- tie-rod design, 227–236
 - toggle clamp, math model for, 239–243
- Microcellular molding, 17, 427–431
 - applicable materials, 431
 - process advantages, 430
 - process description, 427–430
 - process disadvantages, 431
 - typical applications, 431
- Microinjection molding, 17, 421–427
 - applicable materials, 427
 - process advantages, 426
 - process description, 421–426
 - process disadvantages, 426
 - typical applications, 427
- Mixing, 158–177
 - coalescence, process of, 167–169
 - dispersive, 164–166
 - distributive, 159–163
 - economics, 166
 - flow, types of, 158–159
 - sections, 169–175
 - three-zone screw, 158
- Mixing sections, 169–175
 - blister ring, 171–172
 - CRD mixing section, 173–174
 - elongated pin mixing (EPM) section, 173–174
 - fluted mixing section, 172–173
 - Maddock/Leroy mixing sections, 173
 - rhomboid mixer, 170
 - slotted flight mixer, 170–171
 - static mixing device, 175
 - Twente mixing ring, 171
 - variable depth mixer, 171
- Moisture content, 66
- Mold, structural design of, 296–302
 - material, selection of, 296–297
 - characteristics of, 297
 - core deflection, 298–299
 - fatigue, 297–298
 - mold steels, applications and properties of, 296–297
 - requirements for, 296
 - side walls, deflection of, 300
 - causes of, 298–299
 - reduction of, 299
 - support plates, deflection of, 300–302
- Mold build up or deposits, 607–608
- Mold cooling, system
 - considerations, 302–308
 - baffles and bubbletraps, 307–308
 - coolant efficiency, 302
 - coolants, 302
 - coolant temperature, 302
 - cooling lines
 - layout of, 302
 - spacing of, 302
 - mold material, 302
 - parallel versus series cooling circuits, 305–307
 - practical considerations, 303–305
 - pressure drop, 302
 - thermal expansion, 305
- Mold ejection systems, 309–319
 - basic ejection problems, 309–312
 - ejection, means of, 312–314
 - ejection considerations, 314–315
 - ejection design, 316–319
- Molecular size, 701–703
- Molecular weight, 27–30, 682–708
 - flexural strength versus melt flow index, 30
 - melt flow index, 30
 - monodispersed polymer, 29
 - polydispersity index, 29
 - Staudinger's rule, 29
 - time–temperature superposition principle, 29
 - viscosity average, 29
- Monodispersed polymer, 29
- Moving platen, 200–201
- Multicavity injection molding, 77
- Multicomponent injection molding (overmolding), 17, 431–435
 - applicable materials, 434–435
 - process advantages, 433–434
 - process description, 432–433
 - process disadvantages, 434
 - typical applications, 435, 436
- Multiple live-feed injection molding, 18, 435–441
 - applicable materials, 441
 - process advantages, 438–440
 - process description, 435–439

- process disadvantages, 440
typical applications, 441
- N**
- Natural rubber, 19–20
Neuman solution, 109
Newtonian flow field, 76
Newtonian fluid, 85, 146–147
Nonisothermal flows in polymer
 processing, 83
 Brinkman number, 83
Nonreturn or check valves,
 134–137, 608
Normal stresses in shear flow,
 83–84
 extrudate swell, 83, 84
 normal stress coefficients,
 primary and secondary, 83
 stress differences, first and
 second, 83
Nozzle, 137–138
Nozzle drool or stringing,
 608–609
Nozzle free or cold slug, 609
Nylon, 21
- O**
- Odor, 609–610
Orange peel, 610
Oxidation, 620
- P**
- Parallel circuit, 305–306
Parallel versus series cooling
 circuits, 305–307
 baffles and bubblers, 307–308
 combining circuits, 307
 parallel circuit, 305–306
 series circuit, 306–307
Parks, A., 1
Part adhesion, 69
Part costs, estimating, 536–539
Part shrinkage, estimating,
 119–120
Performance problems, 708–725
 deflection temperature under
 load, 717–720
 fillers, use of, 715–717
 impact priorities, 720–725
 material selection process,
 708–715
Phelan & Collendar, 1
Phenol formaldehyde (PF), 48
Pinking of the part, 610–611
Pin point gate, 293
Pitting, 611
Plasticating and injection unit,
 reciprocating screw
 injection molding
 machine, 9–10
 heating bands, 9
 hopper, 9
 nozzle, 9, 10
 reciprocating screw, 10
 screw, 9, 10
 valve, 9, 10
Plasticating and screw design,
 127–128, 131–133
 rapid compression screws,
 132
 barrier screws, 132–133
Plasticating unit, injection
 molding machine, 125–140
 functions of, 140–175
Plasticator, rubber, 20
Plastics process equipment,
 history of, 1–9
Platens, 200–213
 moving platen, 204–205
 rear platen, 206
 stationary platen, 200–204
 two platen machines, 206–207
PLC, 333
Pneumatic Conveying Systems,
 326
Polyacetal, 44
Polyamid/elastomer block
 copolymers, 61
Polyamide 6, 44
Polyamide 66, 44
Polyamides, 21
Polycarbonate, 44
Polydispersity index, 29
Polyester/elastomer block
 copolymers, 61
Polyethylene, 45
Polyethylene, crystalline
 structure, 37
Polyethylene/(polyolefin
 rubber) block copolymers,
 58–59
Polymer applications, 24
Polymer blends, 49
Polymer molecules, 30–32
 atacticity, 31
 carbon tetravalency, 30
 geometric isomers, 33
 isotactic molecules, 32
 polypropylene structures, 32
 syntactic molecules, 32
Polymer resin production, 21–22
Polymers, 19
 abbreviations, 23
 history of, 19–23
 properties, 22
 Polymer structural units, 40–42
 Polymer volumetric changes
 with pressure, 104–105
Polymethylmethacrylate, 45
Polypropylene, 45
Polypropylene/(EPR + oil)
 blends, 57–58
Polypropylene structures, 32
Polypropylene/(rubber + oil)
 dynamic vulcanizates, 58
Polypropylene/(S-EB-S + oil)
 blends, 57
Polystyrene, 45–46
Polystyrene/(S-B-S + oil) blends,
 55–56
Polyurethane/block copolymers,
 60–61
Polyvinylchloride, 46
Porosity, 609
Positioning gates, 295–296
Positive-displacement vacuum
 pumps, 328
Powder injection molding, 18,
 444–448
 process advantages, 447
 process description, 445–447
 process disadvantages,
 447–448
 typical applications, 448
Power-law constants, 75
Power-law model, 74
Pressure flow through a slit, 76
Pressure flow through a tube,
 Hagen-Poiseuille Flow,
 76–78
Pressure sensors, 616–618
Pressure settings for various
 thermoplastic polymers, 67
Process capability and molding
 tools, 365–374
 capability indexes, 366–369
 computers, use of, 369–370
 definition of, 365–366
 injection molding, special
 techniques for, 370–314
Processing data, 63–72
 machine settings, 63

- material independent variables, 63
- maximum screw speed, 64
- temperature settings, 64
- Processing data for
 - thermoplastic elastomers, 66–71, 72
 - blending ingredients, 68–69
 - colorant, 69
 - conditions and properties, 70
 - drying parameters for common thermoplastics, 68
 - insert molding, 71
 - parts adhesion, 69
 - pressure settings for various thermoplastic polymers, 67
 - vapor honing, 71
- Processing data for thermosets, 71–72
 - cross-linking reaction, 71–72
 - viscosity, 71–72
- Process potential index (CP), 366–367
- Push–pull injection molding, 18, 441–444
 - applicable materials, 442–444
 - process advantages and disadvantages, 442
 - process description, 441–442
 - typical applications, 444
- PVC/(NBR + plasticizer) blends, 59–60
- R**
- Racetracking, framing, or nonuniform flow front, 611
- Radial flow, 98
- Ram (or plunger) extruder, 125, 126–127
 - ram-assisted screw extruder, 126–127
 - two-stage ram extruder, 126
- Random copolymers, 49
- Range, variance, and standard deviation, 352–354
 - analysis of variances (ANOVA), 354
 - coefficient of variation, 352
 - dispersion, 352
 - range, 352
 - second moment of distribution, 352
 - standard deviation, 352
 - variance, 352
- Rapid compression screws, 132
- Reaction injection molding (RIM), 18, 448–451
 - applicable materials, 450
 - process advantages, 450
 - process description, 448–450
 - process disadvantages, 450
 - typical applications, 451
- Reactive end-groups, 35
- Rear platen, 206
- Receivers, 329
- Reciprocating screw extruder, 125, 127–140
 - ball check valve, 134–135
 - barrel, 137
 - drive, 139–140
 - feed hopper and opening, 138–139
 - nonreturn or check valves, 134–137
 - nozzle, 137–138
 - plasticating, 131–133
 - plasticating screw, 127–128
 - requirements for reciprocating screws, 130–131
 - screw design, 133–134
 - for injection molding, 128–140
 - sliding ring check valve, 135–137
- Reciprocating screw injection molding machine, 9–13
 - clamping unit, 10–11
 - injection molding cycle, 13–17
 - mold cavity, 11–13
 - plasticating and injection unit, 9–10
 - related processes, 17–18
- Reciprocating screws, requirements for, 130–131
- Record groves, ripples, wave marks, 612
- Residence Time, 337
- Residual stress distribution after cooling, 118
- Residual stresses, shrinkage, and warpage, 117–122
 - part shrinkage, estimating, 119–120
 - residual stress distribution after cooling, 118
 - residual stress distribution, estimating, 121
 - sink marks, 117
 - stress cracking, 118
 - warpage due to thermal mold imbalance, estimating, 122
- Resin transfer molding (RTM) and structural RIM, 18, 451–454
 - applicable materials, 453
 - process advantages, 453
 - process description, 451–452
 - process disadvantages, 443
 - typical applications, 453–454
- Reversion, 620
- Reynolds number, 160
- Rheology of curing thermosets, 85–87
 - Guth's equation, 87
 - suspension rheology, 87
 - viscosity model, 85–87
- Rheology of polymer melts, 72–87
 - shear thinning behavior of polymers, 73–75
 - deviatoric stress, 73–74
 - power-law constants, 75
 - power-law model, 74
 - sliding plate thermometer, 74
- Rheometry, 87–91
 - capillary viscometer, 88–89
 - melt flow indexer, 88
 - extrusion plastometer, 88
 - viscosity from the capillary viscometer, 89–91
 - Weissenberg–Rabinowitsch equation, 90
- Rhemolding, 18, 454–457
 - process advantages, 456–457
 - process description, 455–456
 - process disadvantages, 457
- Rhomboid mixer, 170
- Ribs, 519–521
- Rigid screw conveyors, 340
- Ring gate, 289–290
- Rotating beam tester, 184–186
- Rubber injection, 471–479
- Rubber molding processes, 471–474
 - building blocks of part design, 487–514
 - material, 487–497
 - mold design and machining, 499–500

- process, 501–514
 - product design, 497–499
 - compression molding, 471–472
 - curing systems for, 474–476
 - design process, 483–487
 - data collection and production specifications, 488
 - project plan, 488–479
 - Runner design, 271–285
 - cold runner design, 274–275
 - gate design, 286–296
 - types, 286–294
 - runner balancing in
 - geometrically balanced runners, 276–284
- S**
- Salt core technique, 385
 - Sample part design, estimating costs of, 533–536
 - Schönbein, C., 1
 - Scorch in the barrel, 628
 - Screw design, 128–140, 613–614
 - Screw press, 20
 - Screw recovery, slow recovery, and screw slips, 613
 - Selecting a Cooling System, 341
 - Self-Contained Loaders, 331
 - Semi-crystalline thermoplastics, 36–42
 - crystallinity, degree of, 37
 - lamellar crystal, 36
 - polyethylene, crystalline structure, 37
 - polymer structural units, 40–42
 - spherulites, 36
 - transition temperatures, 39
 - Series circuit, 302–303
 - Shark skin, 85
 - Shear modulus, 34
 - Shear rates, 688–698
 - Shear-thinning effects, 704–708
 - Shish-kebob, 107
 - Shorts, 614–616
 - Shrinkage, 616–617
 - Silos, 325
 - bolted, 325
 - spiral, 326
 - welded, 326
 - Simple shear flow, 75–76
 - Simplified flows common in injection molding, 75–78
 - indexes and constants for thermoplastics, 75
 - pressure flow through a slit, 76
 - Newtonian flow field, 76
 - pressure flow through a tube (Hagen-Poiseuille Flow), 76–78
 - multicavity injection molding, 77
 - simple shear flow, 75–76
 - Simulation, 541–580
 - active process control, 578–579
 - calculations, advanced, 564–574
 - commercial codes, 565–570
 - calculations, simplified, 557–564
 - finite difference based calculations, 557–558
 - old-based calculations, 558–563
 - equations, 545–553
 - constitutive equations, 545–553
 - flow models, 545–547
 - heat transfer models, 549–550
 - orientation models, 548–549
 - history of, 542–544
 - injection-compression molding, 574–578
 - of thermoplastic materials, 576–577
 - of thermoset materials, 577–578
 - molding process, optimization of, 578–579
 - numerical methods, 553–556
 - boundary element method (BEM), 555–556
 - finite difference method (FDM), 553–554
 - finite element method (FEM), 554–555
 - solid model-based calculations, 559–563
- Single-screw extruder, 125
- Sink marks, 117
- Sinks, 617–618
- Six Sigma Organization, values of, 584, 585
- Size-effect factor (SEF), 188–189
- Sliding plate thermometer, 74
- Sliding ring check valve, 135–137
- Slotted flight mixer, 170–171
- Solidification and curing processes, 102–122
- Solidification of thermoplastics, 103–111
 - crystallization, 106–109
 - heat transfer during solidification, 109–111
 - morphological structure of thermoplastic polymers, 105
 - thermodynamics of thermoplastics during cooling, 103
- Solidification of thermosets, 112–117
 - cure kinetics, 113–115
 - curing reaction, 112–113
 - heat transfer during cure, 115–117
- Solids conveying, 140–144
 - drag-induced solids conveying, 141–144
 - gravity-induced conveying, 140
 - improving, 143–144
 - starve feeding, 140–141
- Soluble core technique, 385
- Spherulites, 36, 107
- Splay and silver streaks, 618–620
- Sprue bushing, 251
- Sprue gate, 286–297
- Sprue pickers, 342
- Sprue puller, 251–252
- Sprue sticking, 620–621
- Standard injection molding screw, 128–130
 - compression ratio, 129
 - flight clearance values, 128–129
 - square pitch geometry, 128
- Standard mold assembly, 250–252
 - cross-sectional view, 250–251
 - parallels (or rails), 252
 - sprue bushing, 251
 - sprue puller, 251–252
- Starve feeding, 140–141
- Static mixing device, 175
- Stationary platen, 200–204

- Statistical process control (SPC), 347–374
- basic statistical concepts, 350–356
 - basic statistical terms, 351
 - capable process,
 - determination of, 349–350
 - characteristics of a frequency distribution, 354–355
 - control charts, 357–365
 - distribution patterns, 355–356
 - for attributes data, 364–365
 - for variables data, 357–364
 - mean, median, and mode, 351–352
 - range, variance, and standard deviation, 352–354
 - six steps to achieving, 347–348
 - variability, causes of, 350–351
- Statistical process control, implementation of, 347–350
- capable process,
 - determination of, 349–350
 - environment, creation of problem-solving, 347
- Statistical process control (*cont.*)
- key process problems and variables, determination of, 350–351
 - measurement system capability, 349
 - process capability,
 - determination of, 349
 - training and process technology, 347
- Staudinger, H., 20
- Staudinger's rule, 29
- Stefan condition, 110
- Stereolithography (STL), 559
- Sticking, 621–623
- Stress cracking, 118
- Structural foam injection molding, 18, 457–464
- applicable materials, 461–463
 - process advantages, 460
 - process description, 457–460
 - process disadvantages, 461
 - typical applications, 464
- Structural reaction injection molding, 18
- Styrene-butadiene-rubber, 49
- Surface finish, 621
- Surface finish factor (SFF), 189
- Surface treatment factor (STF), 189
- Survival factor (SF),
 - determination of, 191–193
- Suspension rheology, 87
- Syndiotactic molecules, 32
- T**
- Tab gate, 287–288
- Tadmor, Broyer, and Gutfinger, 543
- Tait equation, 552
- Taper and draft angles, 526
- Technology and process
 - troubleshooting, 632–642
 - automatic troubleshooting, 639
 - experiments
 - design matrix, 642
 - design of, 639–640
 - design worksheet, 641
 - factorial design of, 640–642
 - injection molding process and sensors, 634–635
 - pressure sensors, 636–638
 - process monitoring, 638
 - technology, implications for, 633–634
- Temperature Control, 339
- Temperature sensors, 638
- Temperature settings, 64–65
- Terpolymer, 49
- Thermal expansion, 305
- Thermogravimetric analysis (TGA), 655–657
- Thermoplastic elastomers, 53–61
- abbreviations, 54
 - chlorinated olefin
 - interpolymer alloys, 60
 - phase-separated systems, 54
 - service temperatures, 54–55
 - thermoplastic elastomers,
 - examples of common, 55–61
- Thermoplastic polymers, 34–46
- amorphous thermoplastics, 34–36
 - semi-crystalline
 - thermoplastics, 36–42
 - thermoplastic elastomers, 34
- Thermoplastics, examples of common, 43–46
- polyacetal, 44
 - polyamide 6, 44
 - polyamide 66, 44
 - polycarbonate, 44
 - polyethylene, 45
 - polymethylmethacrylate, 45
 - polypropylene, 45
 - polystyrene, 45–46
 - polyvinylchloride, 46
- Thermoset polymers,
 - reinforcement of, 99–100
- Thermosets, examples of common, 48
- cross-linked polyurethanes (PU), 48
 - epoxy (EP), 48
 - phenol formaldehyde (PF), 48
 - unsaturated polyester (UPE), 48
- Thermosetting polymers, 46–48
- cross-linking reaction, 46–47
- Thin-wall molding, 18, 464–468
- applicable materials, 468
 - process description, 464–466
 - process advantages, 466
 - process disadvantages, 466–468
 - typical applications, 468
- Thread axial stress, 232
- Thread bending stress, 230–232
- Thread load distribution, 227–230
- Tie-bar-less machines, 215–217
- Tie-rod bushings, 221–222
- Tie-rod design, 227–236
- combined stress, 232–233
 - factors, mitigating, 233–234
 - improvements to, 234–236
 - thread axial stress, 232
 - thread bending stress, 230–232
 - thread load distribution, 227–230
- Tie rods and nuts, 213–217
- Time-temperature
 - superposition principle, 29
- Toggle clamp, math model for, 239–243
- Toggle clamping systems, types of, 198–200
- Toggles, pins, and bushings, 217–221
- Transfer molding, 472
- Transition temperatures, 39

- Troubleshooting, fundamentals
of, 581–586
American Society for Quality
(ASQ), 584
benchmarking, 582
breakthrough strategy, 584
checklist, 581
data collection and analysis,
582
personnel, training of, 583
problems, 582
service and manufacturing,
factors in, 584–585
set-up sheet, 581
Six Sigma Organization,
values of, 584, 585
- Troubleshooting guide, 586–632
black specks, 586–587
black streaks, 587–588
blisters on the part's surface,
588–589
blooming, 589
blush, 589–590
brittleness, 590–591
bubbles, 592–593
burns, 593–595
cloudiness in clear parts, 594
color mixing, 594–596
color variation, instability, or
shift, 596–597
core pin bending, 597
cracking, 597–598
crazing, 598
cycle time, 598–599
delamination, 599–600
dimensional variations,
600–602
ejector pin or push marks,
602–603
flash, 603–604
gate blush, 604–605
gloss, 605
hot tip stringing, 605–606
jetting, 606–607
mold build up or deposits,
607–608
nonreturn valve, 608
nozzle drool or stringing,
608–609
nozzle free or cold slug, 609
odor, 609–610
orange peel, 610
pinking of the part, 610–611
pitting, 611
racetracking, framing, or
nonuniform flow front,
611
record grooves, ripples, wave
marks, 612
screw design, 613–614
screw recovery, slow recovery,
and screw slips, 613
shorts, 614–616
shrinkage, 616–617
sinks, 617–618
splay and silver streaks,
618–620
sprue sticking, 620–621
sticking, 621–623
surface finish, 621
voids, 623
warp, 623–625
weldlines, 625–626
tube loaders, 331
Tunnel gate, 291–292
Twente mixing ring, 171
Two platen machines, 206–207
Two-roll, steam-heated mill,
20
- U**
Undercuts and holes, 508–511
Uniaxial fatigue testing
machine, 186–187
Unsaturated polyester (UPE),
48
- V**
Vacuum material receivers, 329
Van-der-Waals forces, 27
Vapor honing, 71
Variability, causes of, 350–351
Variable depth mixer, 171
Vent design, 320–323
Vibration gas injection molding,
468–469
process description, 468–469
Viscoelasticity, 725–754
complex modulus, 730
creep (cold flow), 728
glass transition, 749–754
master curve, 744
modulus, 728
stress relaxation, 728
Viscosity, 71–72
Viscosity, measurement of,
699–701
Viscosity average, 29
Viscosity model, 85–87
Voids, 603
volumetric blenders, 335
Vulcanization process, 20
- W**
Wang and Hieber, 542–544
Warp, 623–625
Warpage, estimating, 122
Water-Assisted Injection
Molding, 469–471
Weissenberg–Rabinowitsch
equation, 90
Weldlines, 625–626
Willert, W. H., 6–8
- X**
X Bar and *R* Chart, 358–361