

Contents

The Author	VII
Preface to the Third Edition	IX
Preface to the Second Edition	XI
Preface to the First Edition	XIII
1 Introduction to Scientific Processing	1
1.1 The Evolution and Progress of Injection Molding	1
1.2 The Molding Process	2
1.3 The Three Types of Consistencies Required in Injection Molding	3
1.4 Scientific Processing	6
1.5 The Five Critical Factors of Molding	9
1.5.1 Part Design	9
1.5.2 Material Selection	10
1.5.3 Mold Design and Construction	10
1.5.4 Machine Selection	11
1.5.5 Molding Process	11
1.6 Concurrent Engineering	12
1.7 Variation	12
1.8 The Molding Parameters and a Recommended Process Development Procedure	14

2	Properties of Polymers and Plastics That Influence Injection Molding	17
2.1	Polymers	17
2.2	Molecular Weight and Molecular Weight Distribution	19
2.3	Polymer Morphology (Crystalline and Amorphous Polymers)	21
2.4	Role of Morphology in Injection Molding	26
2.4.1	Differences in Shrinkage between Amorphous and Crystalline Materials	26
2.4.2	Melt Processing Range	27
2.4.3	Mold Filling Speed	28
2.4.4	Mold Temperatures	28
2.4.5	Barrel Heat Profile	29
2.4.6	Screw Recovery Speeds	29
2.4.7	Nozzle Temperature Control	30
2.4.8	Cooling Times	30
2.4.9	Mechanical Properties	30
2.4.10	Optical Clarity	30
2.5	Exceptions of Morphology Rules to Polyolefins	31
2.6	Thermal Transitions in Polymers	32
2.6.1	Relationship between the Glass Transition Temperature and Post Mold Shrinkage	38
2.6.2	Importance of Mold Temperatures in Injection Molding	41
2.7	Shrinkage of Polymers in Injection Molding	44
2.8	The Plastic Pressure–Volume–Temperature (PVT) Relationship	46
2.8.1	Importance of Plastic Density in Injection Molding	47
2.8.2	Residence Time and Maximum Residence Time of a Plastic	49
2.8.3	Plastic Datasheets	50
2.9	References	52
3	Polymer Rheology	55
3.1	Viscosity	55
3.2	Newtonian and Non-Newtonian Materials	57
3.3	Viscosity in Polymer Melts	58
3.4	Effect of Temperature on Viscosity	61
3.5	Velocity and Shear Rate Profiles	62

3.6	Application to Injection Molding	64
3.6.1	Flow Imbalance in an 8-Cavity Mold	64
3.6.2	Racetrack Effect in a Part with Constant Thickness	66
3.6.3	Stress Build-Up in Molded Parts	67
3.6.4	Warpage Difference between Cavities	67
3.7	Solving Flow Imbalances Using Melt Rotation Techniques	67
3.8	Fountain Flow	69
3.9	Effect of Fountain Flow on Crystallinity, Molecular Orientation, and Fiber Orientation	72
3.10	Characterization of Polymer Viscosity	73
3.11	References	75
4	Plastic Drying	77
4.1	Problems in Melt Processing Related to the Presence of Moisture	79
4.1.1	Degradation of Plastic	79
4.1.2	Presence of Surface Defects	80
4.2	Hygroscopic Polymers	83
4.3	Drying of Plastics	85
4.3.1	Drying Temperatures and Times	85
4.3.2	Relative Humidity and Dew Point	87
4.3.3	Air Flow Rate	88
4.4	Equipment for Drying Plastics	88
4.4.1	Oven Dryers	88
4.4.2	Hot Air Dryers	89
4.4.3	Desiccant Dryers	89
4.4.4	Classifications Based on the Location of the Dryer	89
4.5	Determination of the Amount of Moisture	90
4.5.1	The Glass Slide Technique (TVI Test)	90
4.5.2	The Karl Fischer Titration Method	91
4.5.3	Electronic Moisture Analyzer	91
4.5.4	Measurement of the Dew Point	92
4.6	'Overdrying' or Overexposure to Drying Temperatures	93
4.7	Cautions	100
4.8	Prevention of Overexposure to Longer Drying Times	100
4.9	Overdrying Controller	100
4.10	References	102

5	Common Plastic Materials and Additives.....	103
5.1	Classification of Polymers	103
5.2	Commercially Important Plastics	105
5.2.1	Polyolefins	105
5.2.2	Polymers from Acrylonitrile, Butadiene, Styrene, and Acrylate	106
5.2.3	Polyamides (PA)	107
5.2.4	Polystyrenes (PS)	108
5.2.5	Acrylics	109
5.2.6	Polycarbonates (PC)	109
5.2.7	Polyesters	109
5.2.8	Polyvinyl Chloride (PVC)	109
5.2.9	Polyoxymethylene (POM or Acetal)	110
5.2.10	Fluoropolymers	111
5.3	Additives	111
5.3.1	Fillers	111
5.3.2	Plasticizers	112
5.3.3	Flame Retardants	112
5.3.4	Anti-Aging Additives, UV Stabilizers	113
5.3.5	Nucleating Agents	113
5.3.6	Lubricants	113
5.3.7	Processing Aids	114
5.3.8	Colorants	114
5.3.9	Blowing Agents	114
5.3.10	Other Polymers	115
5.4	Closing Remarks	115
5.5	Reference	116
6	Injection Molding and Molding Machines	117
6.1	The History of Injection Molding	117
6.2	Injection Molding Machines and Their Classifications	118
6.3	Machine Specifications	120
6.3.1	Clamp Force (Tonnage)	121
6.3.2	Shot Size	121
6.3.3	Screw Diameter and L/D Ratio	121

6.3.4	Plasticating Capacity	122
6.3.5	Maximum Plastic Pressure	122
6.4	The Injection Molding Screw	122
6.5	Screw Designs	125
6.6	The Check Ring Assembly	126
6.7	Intensification Ratio (IR)	126
6.8	Obtaining Intensification Ratios	128
6.9	Selecting the Right Machine for the Mold	129
6.9.1	Physical Size of the Mold	130
6.9.2	Calculating the Required Machine Tonnage for a Mold	132
6.9.3	Percentage Shot Size Used and Number of Shots in the Barrel ...	137
6.9.4	Residence Time of the Material in the Barrel	140
6.9.5	Practical Methods to Find Percentage Shot Size, Shots in a Barrel, and Residence Time	141
6.9.6	Residence Time Distribution	142
7	Scientific Processing, Scientific Molding, and Molding Parameters.....	143
7.1	Introduction	143
7.2	What Scientific Molding and Scientific Processing Are Not!	145
7.3	Process Robustness	145
7.4	Process Consistency	146
7.5	The Injection Molding Cycle	149
7.6	The Injection, Pack, and Hold Phases of Injection Molding	150
7.7	Speed and Pressure	153
7.8	The 11 + 2 Plastic Injection Molding Machine Input Parameters	154
7.8.1	Barrel Temperatures	155
7.8.2	Mold Temperatures	156
7.8.3	Shot Size	158
7.8.4	Transfer Position	158
7.8.5	Injection Speed (Velocity)	158
7.8.6	Injection Pressure	159
7.8.7	Pack Pressure	159
7.8.8	Pack Time	159
7.8.9	Hold Pressure	160

7.8.10	Hold Time	160
7.8.11	Screw Rotation Speed	160
7.8.12	Back Pressure	161
7.8.13	Cooling Time	164
7.9	Additional Settings	165
7.9.1	Decompression or Suck Back Position	165
7.9.2	Pack Speed	166
7.9.3	Tonnage	166
7.10	Process Outputs	166
7.10.1	Actual Melt Temperature	167
7.10.2	Actual Mold Temperature	168
7.10.3	Injection (Fill) Time	170
7.10.4	Peak Injection Pressure	170
7.10.5	Pressure at Transfer	171
7.10.6	Cushion Value	171
7.10.7	Screw Rotation Time	173
7.10.8	Cycle Time	173
7.10.9	Injection Only Shot Weight (Including Runners)	174
7.10.10	Full Part(s) Weight	175
7.10.11	Runner Weights	175
7.11	Decoupled Molding SM	176
7.12	References	177
8	Introduction to Process Development	179
8.1	Introduction	179
8.2	Process Development Fundamentals	179
8.3	Premolding Setup	182
8.3.1	Storage and Drying of Resin	182
8.3.2	Plastic Drying	182
8.3.3	Machine Selection	185
8.4	Importance of Adding Charge Delay Time	185
8.5	Filling in Injection: Weight or Volume?	187

9	Process Development Part 1: The Melt Preparation	189
9.1	Setting of the Barrel Temperatures	191
9.2	Optimization of Screw Rotation Speeds	195
9.3	Screw Rotation Speed Rule of Thumb That Should Not Be Used	199
9.4	Optimization of Back Pressure	200
10	Process Development Part 2: The 6-Step Study – Exploring the Cosmetic Process	205
10.1	The 6-Step Study	205
10.1.1	Step 1: Optimization of the Injection Phase – Rheology Study	205
10.1.1.1	Procedure to Determine the Viscosity Curve at the Molding Machine	210
10.1.1.2	Interpreting the Data	212
10.1.1.3	Cautions and Exceptions	213
10.1.1.4	Profiling of Injection Speeds	214
10.1.1.5	When a Short Shot Sticks	215
10.1.1.6	Selecting Melt Temperature for Viscosity Graphs	217
10.1.2	Setting the Shot Size and the Transfer Position	217
10.1.3	Step 2: Determining the Cavity Balance – Cavity Balance Study	219
10.1.3.1	Procedure to Determine the Cavity Balance	221
10.1.3.2	Reasons for Cavity Imbalance	222
10.1.3.3	Determining the Cause of Cavity Imbalances	225
10.1.3.4	Calculating Cavity Imbalance	226
10.1.3.5	Acceptable Level of Cavity Imbalance	227
10.1.4	Step 3: Determining the Pressure Drop – Pressure Drop Studies	229
10.1.4.1	Procedure to Determine Pressure Drop	231
10.1.4.2	How to Use the Information from the Study	235
10.1.4.3	Effect of Pressure Drop on the Pack and Hold Phase	236
10.1.5	Step 4: Determining the Cosmetic Process Window – Process Window Study	237
10.1.5.1	Procedure for Determining the Process Window for Amorphous Materials	241
10.1.5.2	Procedure for Determining the Process Window for Crystalline Materials	242
10.1.5.3	How to Use This Information	243

10.1.5.4	Shape of the Process Window	244
10.1.5.5	Cautions and Exceptions	245
10.1.5.6	Relationship between Cavity Balance and Process Windows	245
10.1.5.7	The Pack and Hold Pressure Rule Not to Be Used	246
10.1.6	Step 5: Determining the Gate Seal Time – Gate Seal Study	246
10.1.6.1	How to Use This Information	249
10.1.6.2	Cautions and Exceptions	249
10.1.7	Differentiating between the Pack and the Hold Phase	249
10.1.7.1	Hot Runner and Valve Gated Molds	253
10.1.8	Step 6: Determining the Cooling Time – Cooling Time Study	253
10.1.8.1	Procedure to Determine Cooling Time	255
10.2	Optimization of Tonnage	257
10.3	The Cosmetic Scientific Process	260
10.4	Post-Mold Shrinkage Studies	261
10.4.1	Procedure to Measure Shrinkage	263
10.4.2	How to Use This Information	264
10.5	Completion of Part 2 of the Recommended Process Development Procedure	264
10.6	Recommended Adjustments to Maintain Process Consistency and Robustness	266
10.7	Process Documentation	267
10.8	References	267
11	Process Development Part 3: Exploring the Dimensional Process via Design of Experiments.	269
11.1	Why Perform DOEs?	271
11.2	The PVT Diagram and Injection Molding Relationship	271
11.2.1	Design of Experiments: Definition	272
11.3	Terminology	274
11.3.1	Factor	274
11.3.2	Response	275
11.3.3	Level	275
11.3.4	Designed Experiment	276
11.4	Relationships between the Number of Factors, Levels, and Experiments	277

11.5	Balanced Arrays	278
11.6	Interactions	280
11.7	Confounding or Aliasing	282
11.8	Factorial Experiments	284
11.9	Data Analysis	285
11.9.1	Tornado Charts	286
11.9.2	Contour Plots	288
11.9.3	Prediction Equation	289
11.9.4	Process Sensitivity and Outliers Charts	289
11.10	Using the Results from DOE	291
11.10.1	Process Selection	291
11.10.2	Cavity Steel Adjustment	291
11.10.3	Process Adjustment Tool	292
11.10.4	Setting Process Change Tolerances	292
11.10.5	Reducing Inspection	293
11.11	The Dimensional Process Window (DPW)	293
11.12	Selection of Factors for DOEs	295
11.13	Analysis of Variance (ANOVA)	299
11.14	Collecting Shots for a Quality Check	301
11.15	Choosing the Highs and Lows for DOEs from the Process Window	302
11.16	Randomization	302
11.17	DOE Application to Optimize Pack and Hold Times	303
11.18	Setting Acceptable Machine Tolerances and Alarms during Production ..	308
11.19	Summary	310
12	Mold Qualification Flowchart, Production Release, and Troubleshooting.....	311
12.1	Process Development Flowchart	311
12.1.1	Stage 1: Development of the Cosmetic Process	312
12.1.2	Stage 2: Mold and Part Quality Qualification Procedure	313
12.2	Mold Qualification Checklist	313
12.3	Process Documentation	314
12.3.1	Process Sheet	314
12.3.2	Waterline Diagrams	315
12.3.3	Mold Temperature Maps	316

12.3.4	Setup Instructions	317
12.3.5	Operator Instructions	317
12.4	Documentation Books	318
12.5	Qualification Production Runs	319
12.6	Mold Specific Troubleshooting Guide	319
12.7	Molding Startup and Shutdown	320
12.7.1	Purging	320
12.7.2	Startup of a Molding Machine	321
12.7.3	Shutdown of a Molding Machine	322
12.8	Troubleshooting	322
12.9	Important Equipment and Tools for Qualifications and Troubleshooting	325
12.10	Common Defects, Their Causes, and Prevention	326
12.10.1	Splay: What Is It? How to Get Rid of It?	327
12.10.2	Defects in Molding	329
13	Role of Mold Cooling, Venting, and Regrind in Process Development	335
13.1	Mold Cooling	335
13.1.1	Number of Cooling Channels	336
13.1.2	Reynolds Number of the Coolant Flow	336
13.1.3	Type of Coolant	337
13.1.4	Series and Parallel Cooling	338
13.2	Venting	339
13.2.1	Dimensions of the Vent	340
13.2.2	Primary Vent Depths	341
13.2.3	Location of Vents	344
13.2.4	Forced Venting or Vacuum Venting	345
13.3	Regrind	346
13.3.1	Effect of the Molding Process on the Part Properties	347
13.3.2	Using Regrind	348
13.3.3	Batch and Continuous Processes of Incorporating Regrind	349
13.3.4	Estimating the Amount of Regrind from Different Generations ..	350
13.3.5	Effect of Regrind on Processing	352
13.3.6	Closing Remarks	353

14	Related Technologies and Topics	355
14.1	Cavity Pressure Sensing Technology	355
14.1.1	Sensors and Output Graphs	356
14.1.2	Types and Classification of Pressure Sensors	357
14.1.3	Use of Information from the Pressure Graphs	359
14.1.4	Controlling the Process with Cavity Pressure Sensors	361
14.1.5	Sensor Locations	363
14.2	Building a Knowledge Base	364
14.3	Concurrent Engineering in Injection Molding	366
14.3.1	The Product Designer	368
14.3.2	The Tooling Engineer	369
14.3.3	The Mold Designer and Mold Maker	369
14.3.4	The Material Supplier	370
14.3.5	The Process Engineer	370
14.3.6	The Quality Engineer	371
14.3.7	The Sales Team at the Molder	371
14.3.8	Mandatory for All Departments	372
14.3.9	Implementing Concurrent Engineering	372
15	Quality Concepts	375
15.1	Basic Concepts	375
15.2	Histogram	376
15.3	Normal Distribution	377
15.4	Standard Deviation	378
15.5	Specification Limits and Standard Deviation	379
15.6	Capability Index	380
15.7	Process Capability	382
15.8	Statistical Quality Control (SQC) and Statistical Process Control (SPC)	383
15.9	References	384
Appendix A	Materials Data Sheet	385
Appendix B	Conversion Tables for Commonly Used Process Parameters	391
Appendix C	Water Flow Tables	393

Appendix D Part Design Checklist 395

Appendix E Mold Design Checklist..... 397

Appendix F Mold Qualification Checklist..... 399

Appendix G Regrind Tables – Percentage of Regrind in Total Shot 401

Appendix H Calculation of Melt Density 405

Index 407