

Contents

Preface	V
Acknowledgments	VII
The Author	IX
1 Introduction	1
1.1 Benefits of Injection Molding	4
1.2 The Injection Mold	6
1.2.1 The Role of the Injection Mold	6
1.3 What Is an Injection Mold?	7
1.3.1 Elements of an Injection Mold	9
1.4 Classification of Molds	13
1.5 Continued Innovation in Molds and Hot Runners	14
1.6 The Injection Molding Machine	14
2 Overview of Plastics for Mold Design	17
2.1 What Is Plastic?	17
2.2 Plastics Terminology	18
2.3 Polymer Orientation	20
2.3.1 Shrinkage	20
2.3.2 Multiple Shrinkages	22
2.4 Additives	23
2.5 Mechanical Properties of Plastics	24
2.6 How Molten Plastics Behave	25
2.6.1 How Plastics Flow	25

2.6.1.1	Pseudo-Plastic Behavior	26
2.6.2	Plastic Flow in Runners and Cavities	28
2.7	Degradation	30
2.8	Selection and Requirements for Plastic Materials	31
3	Plastic Part Design for Mold Designers	33
3.1	Plastic Part Drawing	35
3.2	Product Shape: How Can the Product Best Be Molded?	38
3.3	Parting Line (P/L)	41
3.4	Uniform Wall Thickness	43
3.5	L/t Ratio (Length of Flow Divided by Wall Thickness)	46
3.6	Drafts	47
3.7	Corners, Fillets, and Chamfers	48
3.8	Ribs and Bosses	49
3.9	Rim Designs	51
3.10	Stripped Undercuts	52
3.11	Sidewall Windows in the Part	52
3.12	Gate Location and Number of Gates	53
3.12.1	CAE Filling Analysis for Gate Location Optimization	57
3.12.2	Two or More Gates per Cavity – Large Products	59
3.12.3	Gate Dimple	61
3.12.4	Recessed Gate	61
3.12.5	Deep Undercuts and Mold Design Complexity	62
3.13	Re-Design of the Product to Avoid the Need for Side Cores	63
3.13.1	Selecting Other than the Conventional Parting Line	63
3.14	Shape of Threads and Undercuts	64
3.15	Need for Multi-Stage Ejection	67
3.16	Post-Molding Operations versus Mold Complexity	69
3.17	Plastic Part Tolerances and Effect on Mold Design	70
3.17.1	General and Specific Plastic Part Tolerances	72
3.17.2	Are Special Fits with Matching Products Required?	73
3.17.3	Tolerances for the Filling Volume	73
3.18	Stacking of Products and Free Dispensing	74

3.19	Deliberate Mismatches for Easy Mold Design	78
3.19.1	Mismatch at the Parting Line	78
3.19.2	Mismatch between Two Matching Pieces, such as Box and Lid	80
3.20	Surface Finish	81
3.20.1	Finish of Molding Surfaces	82
3.20.1.1	Molding Surface Finish for Ease of Ejection	84
3.20.2	Texturing of Surfaces	85
3.21	Fitting Surfaces of Mold Parts	86
3.22	Engravings	86
3.22.1	Engravings versus Applied Labels	86
3.22.2	Two-Color and Two-Material Engraving	87
3.22.3	Depth of Engravings	89
3.22.4	Font Style and Size of Artwork	90
3.22.5	Polarity of Engraving	91
3.22.6	Are the Locations Selected for Engraving Practical?	91
3.22.7	Engravings in the Walls and Bottoms of Products	92
3.22.7.1	Engravings on the Outside of the Product (Engraved Cavities)	92
3.22.7.2	Engravings on the Inside of the Product (Engraved Cores)	94
3.23	General Appearance of the Product	95
3.23.1	Flatness	95
3.23.2	Sinks and Voids	99
3.23.3	Witness Lines	101
3.23.3.1	Parting Line Flash	102
3.23.3.2	Gaps between Cavity and/or Core Parts and Inserts	102
3.23.3.3	Clearance of Ejector Pins and Ejector Sleeves	104
3.23.3.4	Hiding the Gate Mark	105
3.23.4	Weld Lines	105
3.23.4.1	Location of Weld Lines	106
3.23.5	Surface Defects (Flow Marks, Splay, Record Grooves, Haze, Jetting, Hooks, and Ripples)	107

3.24	Identification of the Molded Piece	109
3.25	Product Strength Requirements	110
3.25.1	The Role of Gate Location in Increasing Product Strength ...	111
3.26	Special Features	112
3.26.1	Holes and Counter-Bores for Assembly Screws or Rivets	113
3.26.2	Hinges and Snaps	114
4	Specifying the Right Machine for the Mold	117
4.1	Required Clamp Size (Tonnage)	120
4.2	Required Opening Stroke and Shut-Height	125
4.3	Platen Mounting Pattern and Ejector Positions	127
4.4	Locating Ring Size and Machine Nozzle Size	127
4.5	Extruder Sizing and Specification	127
4.5.1	Extruder Shot Size Calculation	128
4.5.1.1	Shot Size Calculation for Cold Runners	129
4.5.1.2	Shot Size Calculation for Hot Runners	131
4.5.1.3	Extruder Sizing Calculation	131
4.5.2	Requirements for Machine Plasticizing Capacity	132
4.5.2.1	Impact of Light-Weighting the Product	135
4.5.3	Screw Selection	136
4.6	Machine Nozzle Selection	136
4.6.1	Open Nozzles	137
4.6.2	Shut-off Nozzles	139
4.7	Injection Unit Selection	143
4.7.1	Reciprocating Screw versus Two-Stage Injection Units	143
4.7.2	Injection Speed and Pressure Requirements	145
4.7.2.1	Need for High Injection Pressures	149
5	Factors Affecting the Design of an Injection Mold	151
5.1	Total Equipment Productivity (TEP) Objectives	151
5.2	Cycle Time	153
5.3	Projected Annual Requirements	153
5.4	Purpose of the Mold	154
5.4.1	Prototype Mold	155

5.4.2	Experimental Mold	156
5.4.3	Combination of Prototype and Experimental Mold	157
5.4.4	Production Mold	158
5.4.5	New Products	158
5.4.6	Existing Product, Large Quantities	159
5.4.7	Limited Quantities, Limited Product Lifecycle	160
5.4.8	Short Runs, Small Production Requirements	160
5.5	The Injection Molding Machine	161
5.6	The Plant Environment	162
5.6.1	Condition of Ambient (Shop) Air	163
5.7	Coolant Supply	165
5.7.1	Is the Cooling Water Clean?	166
5.7.2	Chiller Sizing Guidelines	167
5.8	Power Supply	168
6	Cycle Time Estimation	171
6.1	Factors Impacting Cycle Time	172
6.1.1	Type of Plastic	172
6.1.2	Wall Thickness of Product	174
6.1.3	Mold Materials	175
6.1.4	Efficiency of Cooling	176
6.1.4.1	Molds for Small-Scale Production (Fewer than Approx. 1000 Pieces)	177
6.1.4.2	Molds for Large-Scale Production of Products 0.4–1.3 mm (0.015–0.050") Thick	177
6.1.4.3	Molds for Large-Scale Production of Products >3 mm (0.120") Thick	178
6.1.4.4	Molds for Most Other Products	181
6.1.5	Venting	182
6.1.6	Ejection	182
6.1.7	Molding Machine	183
6.1.7.1	Machine Dry Cycle	183
6.1.7.2	Timing of Ejection and Stroke Required	186
6.1.8	Impact of Cold Runners versus Hot Runners on Cycle Time ..	195
6.2	Estimating Cycle Time	196

7	Product Cost Estimation	201
7.1	Machine Hour Cost per Unit Molded	201
7.2	Mold Cost per Unit Molded	204
7.3	Labor Costs	206
7.4	Estimating Product Cost	207
8	Mold Layout, Drawings, and Inspection	217
8.1	Steps to Designing the Mold	217
8.2	Information and Documentation	218
8.2.1	Machine Specifications	220
8.2.1.1	Mechanical Features	220
8.2.2	Productivity Features	223
8.2.3	Additional Requirements	224
8.3	Determining the Mold Cavitation	227
8.3.1	Minimum Number of Cavities	228
8.3.2	Preferred (Practical) Number of Cavities	230
8.4	Assembly and Detail Drawings	231
8.4.1	Drawings and Views	231
8.4.2	Arrangement of Views	232
8.4.3	Notes on Drawings	233
8.4.4	Additional Information on the Drawings	233
8.5	Mold Layout and Assembly Drawings	233
8.5.1	Machine Platen Layout	233
8.5.2	Symmetry of Layout, Balancing of Clamp	234
8.5.3	The Views	234
8.5.4	Completing the Assembly Drawing	234
8.5.5	Bill of Materials (BOM) and “Ballooning”	235
8.5.6	Finishing Touches	235
8.6	Inspection Features on Drawings	236
8.6.1	Rollers or Roller Balls	236
8.6.2	How to Inspect Tapers	237
8.6.2.1	External Tapers	237
8.6.2.2	Internal Tapers	237

	8.6.2.3	Angled Surfaces	238
	8.6.2.4	Construction (Checking) Balls	239
8.7		Chamfers and Radii	240
	8.7.1	General Information	240
	8.7.2	Specifying Chamfers	241
	8.7.3	Radii in Corners	242
9		Mold Shoe Design	243
9.1		Mold Plates	245
9.2		Mold Hardware	247
9.3		Location of Fittings, Hoses, and Cables	248
9.4		Forces Affecting Mold Shoes	248
	9.4.1	Deflection of Mold Plates	249
	9.4.2	Calculation of Plate Deflection and Stress	250
9.5		Selection of Materials for Mold Plates	252
9.6		Guiding of Moving Plates	253
	9.6.1	Gibs	253
	9.6.1.1	Pillars and Bushings	254
	9.6.1.2	Dowel Pins and Bushings	254
	9.6.1.3	Leader Pins with Piston and Stroke Limiters	255
9.7		Mounting Holes and Clamp Slots	256
9.8		Locating Rings	257
9.9		Mold Handling – Lift Holes, Lift Bars, and Latches	257
	9.9.1	Lift Bars	257
	9.9.2	Latches	260
	9.9.2.1	Latches for Mold Servicing	260
9.10		Mold Identification Nameplates	263
10		Cavity and Core Design Overview	265
10.1		Mold Cavity Space	265
10.2		Plastic versus Steel Part Drawing	266
10.3		The Preliminary Stack Layout	267
	10.3.1	Where Should the Parting Line Be Located?	267
	10.3.1.1	Primary Parting Line	268

10.3.1.2	Secondary Parting Lines: Split Molds and Side Cores	270
10.3.2	Will the Product Pull out of the Cavity and Stay on the Core?	271
10.3.3	Will the Product Eject Easily from the Core?	273
10.3.4	Is the Cavity Balanced?	275
10.4	Determining the Method of Cavity Construction	276
10.4.1	Cavity and/or Core Are Cut Right into the Mold Plate	277
10.4.2	Individual Cavities and Cores	277
10.5	Stack Sizing and Total Area of the Stack	278
10.6	Forces on the Cores and Cavities	279
10.6.1	Checking for Sufficient Steel Shut-off Area in Stack	280
10.6.2	Checking for Stack Compression due to Clamp Tonnage	281
10.6.3	Checking for Acceptable Hoop Stress in the Cavity	283
10.7	Core and Cavity Material Selection	285
10.8	Determining the Stack Construction	286
10.9	Venting	287
10.9.1	Parting Line (P/L) Venting	289
10.9.2	Vent Grooves and Channels	289
10.9.3	Vent Pins	290
10.9.4	Venting of Ribs	291
10.9.5	Venting the Bottom of a Cavity	291
10.9.6	Core Cap and Core Sidewall Venting	292
11	Ejection	293
11.1	Manual or Semi-Automatic Ejection	294
11.2	Automatic Ejection	295
11.3	Basic Requirements for Ejection	297
11.3.1	Machine Opening Stroke for Ejection	297
11.3.2	Venting for Ease of Ejection	300
11.3.3	Surface Finish Forces on Ejection	301
	11.3.3.1 Mold Surface Roughness	301
	11.3.3.2 Molding Surface Finish Guidelines for Ejection ...	302
11.4	Force Required for Ejection	303

- 11.5 Where to Eject the Product 303
 - 11.5.1 Ejection of Deep Cup-Shaped Parts 305
 - 11.5.2 Ejection of Parts with Deep Ribs 305
 - 11.5.3 Ejection of Bosses 307
 - 11.5.4 Ejection of Shallow Parts 308
 - 11.5.5 Ejection of Rim Shapes 309
 - 11.5.6 Ejection of Cold Runners 311
- 11.6 Ejector Pins, Blade Ejectors, and Sleeves 315
 - 11.6.1 Ejector Pin Clearance (Fit) and Length of Land 317
 - 11.6.2 Blade Ejectors 318
 - 11.6.3 Number, Size, and Location of Ejector Pins 320
 - 11.6.3.1 Ejector Pin Sizing 320
 - 11.6.3.2 Ejector Pin Locations 321
 - 11.6.4 Finish of Ejector Pins and Bores 322
 - 11.6.5 Preventing Ejector Pins from Turning 323
- 11.7 Ejector and Ejector Retainer Plates 324
 - 11.7.1 Ejection Forces 324
 - 11.7.2 Injection Forces 325
 - 11.7.3 Number and Location of Machine Ejectors to Be Used 325
 - 11.7.4 Calculation of Ejector Plate Deflection 325
 - 11.7.5 Ejector Pin Retainer Plate 326
 - 11.7.6 Ejector Return Pins 328
 - 11.7.7 Ejector Box 329
 - 11.7.7.1 Guiding Ejector Plates 331
 - 11.7.8 Returning the Ejector Plate 332
 - 11.7.8.1 Tie Ejector Plate to Machine's Ejector Plate 333
 - 11.7.8.2 Linkages Attached to the Mold 333
 - 11.7.8.3 Return Springs 333
 - 11.7.8.4 Air Cylinders (Air Springs) for Ejector Return 336
 - 11.7.8.5 Early Ejector Return Systems 337
- 11.8 Stripper Ejection 338
 - 11.8.1 General Rules for Stripper Ejection 339
 - 11.8.2 Guiding the Stripper Plate 341

11.8.3	Stripper Rings	343
11.8.3.1	Fixed Stripper Rings or Stripper Inserts	343
11.8.3.2	Floating Stripper Rings	344
11.8.4	Stripper Bars	346
11.8.5	Stripper Ring Ejection of Lids	347
11.8.6	Stripping from the Injection (Cavity) Side	348
11.9	Air Ejection	348
11.9.1	Requirements and Timing for Air Ejection	350
11.9.2	Poppet Air Ejection	351
11.9.3	Core Air	355
11.9.3.1	Fixed Core Air	355
11.9.3.2	Stroking Core Air	357
11.9.3.3	Combination of Air Poppet and Stroking Core Air	358
11.9.4	Blow-off Jets	359
11.9.5	Blow-down Jets	360
11.9.6	Air Ejection from the Cavity Side	361
11.10	Ejection of Significant Undercuts	363
11.10.1	Cam Ejection (Internal and External) Using Neck Rings	363
11.10.2	Core Pull Ejection	365
11.10.3	Collapsible Cores	367
11.10.4	Lifter Ejection	369
11.10.5	Sliders	371
11.10.5.1	Split-Cavity Movement on Angled Pins	374
11.10.6	Unscrewing Ejection	375
11.10.7	Cam and Harmonic Linkage Ejection	376
11.11	Multiple Ejection Strokes	377
11.12	Multi-Stage Ejection	378
11.12.1	Why and When to Use Multi-Stage Ejection	378
11.12.2	Typical Two-Stage Ejection Actuations	379
11.12.2.1	Latch Locks (Internal and External)	381
11.12.2.2	Two-Stage Ejection with Levers	383
11.12.3	Moving-Cavity Ejection Assist	384

12	Mold Cooling	387
12.1	Injection and Mold Temperatures for Common Plastics	390
12.2	Coolant Requirements for a Mold	391
12.3	What Affects Mold Cooling Performance?	392
12.3.1	Temperature of the Cooling Medium	393
12.3.2	Achieving Steady-State Temperature in the Mold	393
12.4	Principles of Heat Transfer and Thermodynamics	395
12.4.1	Heat Transfer Basics	396
12.4.2	Melting and Cooling Behavior of Plastics	398
12.4.3	Conduction and Thermal Conductivity	399
12.4.3.1	Thermal Conductivity Values	400
12.4.4	Convective Heat Transfer	401
12.4.4.1	Reynolds Number (Re)	401
12.4.4.2	Pressure Drop of Coolant Supply and Return Lines	403
12.4.4.3	Cross-Section of Channels	403
12.4.4.4	Length of Cooling Lines	403
12.4.4.5	Coolant Viscosity	403
12.4.4.6	Condition of Channels	404
12.5	Calculation of Cooling Requirements for a Mold	404
12.5.1	Heat Input Required to Condition the Plastic for Injection	404
12.5.2	Cooling Required to Remove the Inputted Heat	405
12.5.3	Temperature of Cooling Water	406
12.5.4	Quantity of Cooling Water Required	407
12.5.5	Efficiency of Cooling on Required Water Flow	408
12.6	General Cooling Design Rules	409
12.7	Cooling Channels in Plates	411
12.7.1	Series and Parallel Plate Cooling	412
12.7.2	Distance of Waterlines from Holes and Surfaces	415
12.7.3	Plugging of Cooling Channels	416
12.7.4	Plugs and Baffles in Plates	417
12.7.5	Cooling of Hot Runner Plates	419
12.7.5.1	Calculation of the Sizes of Cooling Channels for Hot Runner Plates	420

12.8	Layout of Cooling Channels in Inserts	422
12.8.1	Shrinkage of Plastic and Cooling Layout	424
12.8.2	Preventing Water Leakage in the Mold	426
12.8.3	Cooling Channel Distances in Inserts	428
12.8.4	Distance to Pipe Threads and Fittings	430
12.8.5	Cooling Channels Split between Inserts	430
12.8.6	Design of Insert Cooling for Flat Products	431
12.8.6.1	Drilled and Milled Cooling Circuits in Flat Parts ..	431
12.8.7	Cooling Design for Cup-Shaped Products	433
12.8.7.1	Cavity Cooling in Cup-Shaped Products	433
12.8.7.2	Core Cooling of Cup-Shaped Products	439
12.8.7.3	Cooling of Inserts	448
12.8.8	Use of CAE Molding Simulation for Cooling Design and Warpage Analysis	449
12.9	Supplying Water to the Mold	452
12.10	Thermal Expansion	453
13	Mold and Stack Alignment	455
13.1	Leader Pin and Bushing Alignment	457
13.2	Taper or Straight Interlock Alignment between Plates	459
13.3	Taper Lock between Each Cavity and Core	462
13.3.1	Backing up a Taper	466
13.3.2	Core Lock and Cavity Lock Alignment	467
13.4	Preloads	470
13.4.1	Restoring Preload by Grinding of the Tapers	474
13.4.2	Preload Stresses	475
13.4.3	Mounting of Stacks to Mold Plates	475
13.5	Over-Constrained Alignment	476
14	Melt Distribution and Gate Design	479
14.1	Cold Runners	481
14.1.1	Cold Runner, Single-Cavity Molds	481
14.1.2	Cold Runner, Two-Plate Molds	481
14.1.3	Cold Runner, Three-Plate Molds	483

14.1.4	Cold Runner Gate Types and Configurations	484
14.1.4.1	General Features of a Cold Runner Gate	484
14.1.4.2	Edge, Fan, Tab, and Diaphragm Gates	485
14.1.4.3	Tunnel Gates	487
14.1.4.4	Multiple Tunnel Gating	489
14.1.4.5	Curved or Submarine Tunnel Gating	489
14.1.4.6	Three-Plate Gates	490
14.1.4.7	Optimizing the Cold Runner Gate Placement	491
14.1.5	Layout and Balancing of Cold Runner Melt Channels	493
14.1.5.1	Multi-Cavity Runner Layouts (One Gate per Part)	496
14.1.5.2	Single-Cavity Multi-Gate Runner Layouts	499
14.1.6	Cold Runner Ejection	499
14.2	Insulated Runners	499
14.3	Hot Runners	500
14.3.1	Considerations for Specifying a Hot Runner	505
14.3.2	Overview of Hot Runner Design	506
14.3.3	Layout and Balancing of Hot Runner Melt Channels	507
14.3.3.1	Bridge and Sub-Manifolds	513
14.3.4	Melt Channel Sizing	514
14.3.4.1	Plastic Inventory in the Hot Runner	515
14.3.5	The Hot Runner Manifold	516
14.3.5.1	Locating the Manifold	516
14.3.5.2	Thermal Expansion of the Manifold, Sealing the Hot Runner Systems, and Nozzle Tip Position	517
14.3.5.3	Manifold Supports (Back-up Insulators)	518
14.3.5.4	Manifold Plate and Manifold Backing Plate	520
14.3.6	Heating of the Hot Runner	522
14.3.6.1	Basics of Resistance Heaters	523
14.3.6.2	Heaters	523
14.3.6.3	Heat Input per Mass of the Hot Runner Manifold ..	525
14.3.6.4	Thermocouples (T/Cs)	526
14.3.7	Hot Runner Nozzles	528

- 14.3.8 Nozzle Tips and Gating in Hot Runners 529
 - 14.3.8.1 Hot-Tip Gates 530
 - 14.3.8.2 Valve Gates 533
 - 14.3.8.3 Slot Gating 537
- 14.3.9 Hot Runner Temperature Controls 538
- 14.3.10 Hot Runner Gate Location 539
- 14.3.11 Hot Runner Gate Sizing 539
 - 14.3.11.1 Gate Sizing Methods 540
 - 14.3.11.2 Gate and Melt Channel Size Calculation 541
 - 14.3.11.3 Empirical Calculation of Gate Size 542
 - 14.3.11.4 Gate Land Length 543
- 14.3.12 Gate Inserts (Gate Pads) 543
- 14.4 Hot and Cold Runner Molds in Combination 544
- 14.5 Selection of Hot Runner or Cold Runner System 546
- 15 Selection of Mold Materials 549**
 - 15.1 Forces on the Mold Affect Material Choices 550
 - 15.1.1 Characteristics of Steels and Other Mold Materials 551
 - 15.2 Steel Properties 554
 - 15.2.1 Types of Steels 558
 - 15.2.1.1 Pre-Hardened Steels 558
 - 15.2.1.2 Tool Steels 558
 - 15.2.1.3 Stainless Steels 559
 - 15.2.1.4 Copper Alloys 559
 - 15.3 Quality of Materials 559
 - 15.4 Manufacturing Considerations for Choosing Materials 560
 - 15.4.1 EDM 560
 - 15.4.2 Welding 560
 - 15.5 Heat Treatment 560
 - 15.6 Overview of Surface Treatments 562
 - 15.7 Hardness of Mating Parts 563

- 16 Fasteners 565**
 - 16.1 How Screws Work 567
 - 16.2 Rolled versus Cut Threads 568
 - 16.3 Holding Action and Preload of Screws 569
 - 16.4 Influence of Temperature on Screws 573
 - 16.5 Effect of Cyclical Loads on Screws 574
 - 16.6 Screw Standards and Properties 574
 - 16.7 Length of Thread Engagement 575
 - 16.8 Additional Recommendations Regarding Screws 576
 - 16.8.1 Always Use Standard Available Screw Sizes and Lengths 576
 - 16.8.2 Increase the Depth of the Counter-Bore 577
 - 16.9 Use of Set Screws 578
 - 16.10 Holding Screws in Place (if Needed) 578
 - 16.10.1 Lock Washers 578
 - 16.10.2 Screw-Securing Compounds 579
 - 16.10.3 Screws Secured by Plastic Inserts (Nylok™, etc.) 579
- 17 Dimensioning and Tolerancing 581**
 - 17.1 Conventional versus Geometric Tolerancing 583
 - 17.2 Limitations of Conventional Dimensions and Tolerances 584
 - 17.2.1 Origins of Measurement 585
 - 17.2.2 Non-Repeatable Sizes and Centers 586
 - 17.2.3 Orientation and Angles 587
 - 17.2.4 Tolerance Accumulation 589
 - 17.3 Geometric Dimensioning and Tolerancing 591
 - 17.3.1 Three Core Steps for Applying or Inspecting GD&T 592
 - 17.3.2 Geometric Tolerancing Benefits versus Conventional Tolerancing 593
 - 17.3.2.1 Clear Setup and Origins of Measurement 593
 - 17.3.2.2 Geometric Controls Apply to Features, not to Dimensions 595
 - 17.3.2.3 Repeatable Sizes and Centers 597
 - 17.3.2.4 Tolerance Accumulation Is Minimized 597
 - 17.3.2.5 Tolerance Zones Are Uniform 598

17.3.2.6	Control of Patterns of Features	598
17.3.2.7	A Single Interpretation	598
17.4	Implementation of Geometric Tolerancing	598
17.4.1	Implementation of GD&T-Lite (not Recommended)	599
17.4.2	Implementation of GD&T Integration	599
17.4.3	Implementation of Model-Based Definition	600
17.5	Considerations for Tolerancing	601
17.5.1	CAD Modelling Practices	601
17.5.2	Materials, Manufacturing, and Inspection	602
17.5.3	Thermal Expansion and Tolerancing	603
17.6	Application of GD&T to Mold Components	603
17.6.1	GD&T Applied to an Injection Mold Core	604
17.6.2	GD&T Applied to an Injection Mold Lock Ring	606
17.6.3	GD&T Applied to an Injection Mold Core Plate	608
17.6.4	GD&T and Mold Engineering	611
18	Mold Design References	613
18.1	Plastic Housing (Using Shut-offs)	613
18.2	Facemask	615
18.3	Plastic Cutlery	618
18.4	Vial	621
18.5	Open-Ended Floss Spool Tube	623
18.6	Overcap Lid (Using Stripper Ring Ejection)	626
18.7	Plug Lid	628
18.8	Urine Tub Cap (Using Stripper Ring Ejection)	634
18.9	Deli or Yellow Fats Container (Using Air Ejection and with Cavity Lock Alignment)	637
18.10	Stadium Cup (Using Core Lock Alignment)	640
18.11	Polystyrene Tumbler (Using Stripper Ring Ejection)	643
18.12	False-Bottom Cup (Using Moving Cavity and Air Ejection)	648
18.13	Round Closure (Using Stripper Ring (Bump-off) Ejection)	649
18.14	Paint Pail with Handle Inserts	652
18.15	Rectangular Container with Tamper-Evident Skirt	654
18.16	Power Tool Housing	657

18.17	Rear Hatch Door	662
18.18	Crinkle Bag	663
18.19	Preform (Using Neck Ring Ejection)	665
18.20	Living Hinge Cap	670
18.21	Rectangular Box with Undercuts (Using Split-Cavity Mold)	673
18.22	Detergent Cap (Using Unscrewing Ejection)	674
18.23	Folding Crate	679
18.24	Automotive Panel Cover	682
18.25	Pallet	683
18.26	Automotive Covers	685
18.27	Double-Walled Threaded Cap (Using Collapsible-Core Mold)	687
18.28	Automotive Cover	689
18.29	Externally Threaded Cap Mold	690
18.30	Oxygen Mask (with Side Core Retraction)	692
18.31	Living-Hinge Case	694
18.32	Iron Housing (Using Split-Cavity Mold)	697
18.33	Oral Care Product (Using Split-Cavity Mold)	699
18.34	Actuator (Using Split Cavity with Multi-Stage Ejection)	705
19	Mold Testing, Approval, and Troubleshooting	707
19.1	Information to Be Supplied to the Mold Tester	707
19.2	Dry-Cycle Testing before Injecting Plastic	708
19.2.1	Bluing to Ensure Proper Shut-off, Venting, and Taper Fit	710
19.2.2	Procedure for Aligning Mold Halves in the Injection Molding Machine	712
19.2.3	Lead Test Procedure to Check Wall Thicknesses and Alignment	712
19.3	Initial Mold Start-up and First Shots	713
19.3.1	Mold Start-up Procedure	714
19.4	Changing Materials or Colors	718
19.4.1	General Color Change Procedure	719
19.5	Mold Test Information and Data to Be Collected	720
19.5.1	Core Shift Mapping	721

19.6 APQP and PPAP 722

19.7 Mold Test Troubleshooting Guide 723

20 Appendix 733

Appendix 1: Mold Material Properties 733

Appendix 2: Frequently Used Conversion Factors 735

Appendix 3: Plastics and their Abbreviations 737

Appendix 4: Mold Design Review Checklist 739

Appendix 5: Contents of a Mold Manual 745

Appendix 6: Mold Setup Guide Template 746

Appendix 7: Order Confirmation Template 751

Appendix 8: General Properties of Plastics 753

Appendix 9: Thermal Properties of Plastics 755

Appendix 10: Mechanical Properties of Plastics 757

Appendix 11: Thermal and Processing Properties of Plastics 761

Appendix 12: Mold Preventative Maintenance Checklist 766

Appendix 13: Surface Finishes 767

Index 769