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INJECTION MOLDING  
GUIDE



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# INTRODUCTION

## Objective

This document provides guidelines for part design, mold design and processing of styrenic block copolymer (SBC) TPEs. The GLS product families that include styrenic TPEs are Kraton compounds, Dynaflex TPE compounds and Versaflex TPE alloys.

## SBC Rheology

One major characteristic of SBCs is that they are shear dependent. A material is shear dependent when its viscosity is higher at low shear rates (such as extrusion) and lower at high shear rates (as in injection molding). Therefore, SBC compounds will flow more easily into thin areas of the mold at high shear rates. The shear thinning behavior of SBCs should be considered when designing injection molds and also when setting mold conditions during processing.

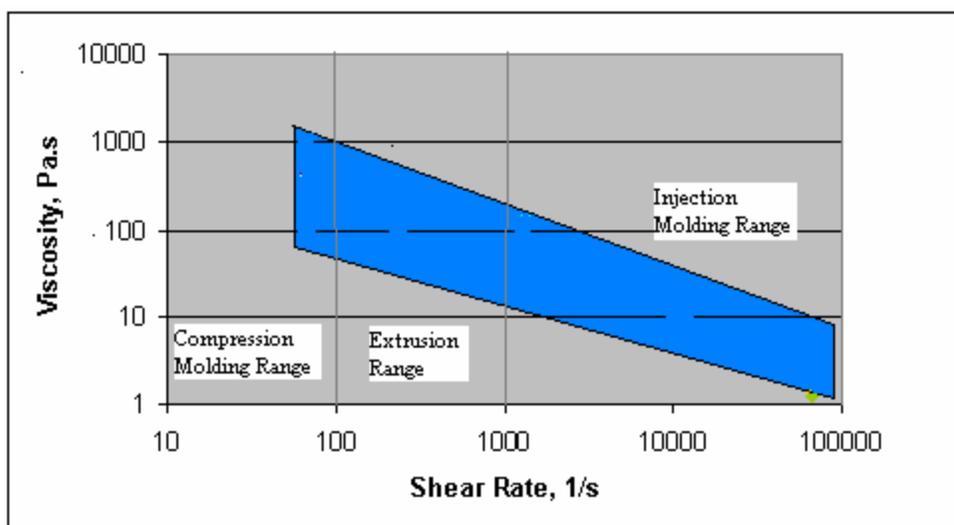


Figure 1. The effect of shear rate on the viscosity of GLS styrenic TPE compounds (measured at 390° F (200° C)).

To obtain information regarding the viscosity of an individual grade, refer to the Product Technical Data Sheet, available at [www.glscorporation.com](http://www.glscorporation.com) or contact your GLS representative.

# **PART DESIGN**

## **General Part Design Concepts**

When designing a TPE part, there are a few general rules to follow:

- The part wall thickness should be as uniform as possible. Transitions from thick to thin areas should be gradual to prevent flow problems, back fills, and gas traps.
- Thick sections should be cored out to minimize shrinkage and reduce part weight (and cycle time).
- Radius / fillet all sharp corners to promote flow and minimize no-fill areas.
- Deep unventable blind pockets or ribs should be avoided.
- Avoid thin walls that cannot be blown off the cores by air-assist ejection.
- Long draws with minimum draft may affect ease of ejection.

## **Flow Length and Wall Thickness**

The maximum achievable flow length is dependent on the specific material selected, the thickness of the part, and processing conditions. Generally, GLS compounds will flow much further in thinner walls than other types of TPEs. The flow to thickness ratio should be 200 maximum, however this is dependent on the material and the part design. High flow GLS TPE compounds (such as Versalloy) have been used successfully to fill flow ratios up to 400.

The measurement of spiral flow offers a comparative analysis of a material's ability to fill a part. The spiral flow test is performed by injecting a material into a spiral mold (similar to a ribbon formed into a spiral). The distance the material flows is measured in inches. In this case, the spiral flow test was conducted using two different injection speeds (3 in/sec and 5 in/sec). The typical spiral flow lengths for the various GLS product families are summarized in Table 1. With specific compounds, flow lengths of up to 40 inches (at 5 in/sec injection speed) are possible.

**Table 1. Typical Spiral Flow Lengths for GLS Compounds\***

<b>Series</b>	<b>Flow length, in</b>	
	<b>3 in/sec</b>	<b>5 in/sec</b>
Dynaflex <sup>®</sup> D	13 – 15	18 – 20
Dynaflex <sup>®</sup> G	12 – 22	18 – 30
Versaflex <sup>®</sup>	9 – 16	13 – 26

\*Spiral flow tests performed using 0.0625 in thickness and 0.375 in width channel at 400°F.

For spiral flow information about a specific grade or additional details about the spiral flow test procedure, please refer to the GLS Corporation TPE Tips Sheet #7, available at [www.glscorporation.com](http://www.glscorporation.com) or by contacting your GLS representative.

## Undercuts

The flexibility and elastic nature of TPEs allows for the incorporation of undercuts into the part design. Because of their excellent recovery characteristics, GLS compounds are capable of being stretched and deformed, allowing them to be pulled from deep undercuts (Figure 2). If both internal and external undercuts are present on the same part, slides or core splits may be necessary. Parts with internal undercuts (e.g. bulb-shaped parts) may be air ejected from the core by use of a poppet valve in the core. Minor permanent elongation (3% - 8%) due to deformation may occur during ejection.

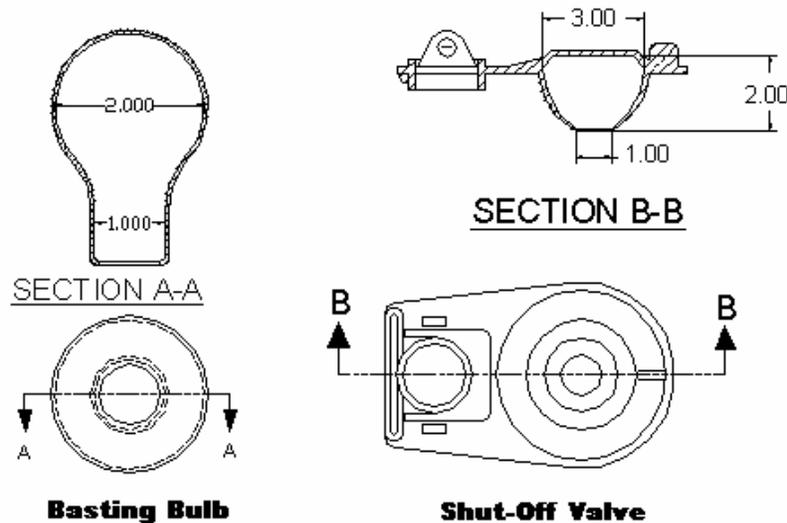


Figure 2. An example of TPE parts with large undercuts.

## Gate and Knit Line Locations

The product engineer should indicate the areas of the part that are cosmetic and those that are functional and include this information on the drawing. This will help the mold designer to determine the allowable gate and knit line locations.

## Anisotropy

Thermoplastic materials that have different properties in the flow direction versus the cross-flow direction (90° perpendicular to the flow direction) are characterized as “anisotropic” materials. Properties that may be affected are shrinkage and tensile properties. Anisotropy is caused when the polymer chains orient in the direction of flow, which leads to higher physical properties in the flow direction. Wall thickness, injection speed, melt temperature and mold temperature are a few variables that affect anisotropy. Depending on the processing conditions and mold design, most GLS styrenic TPE compounds exhibit a degree of anisotropy.

## Shrinkage

Due to their anisotropic nature, GLS styrenic TPE compounds shrink more in the flow direction than in the cross-flow direction. Generally, SEBS compounds have higher shrinkage and are more anisotropic than SBS compounds. Typical shrinkage values for SEBS-based compounds are 1.3% - 2.5%, whereas those for SBS based compounds are 0.3% - 0.5%. Softer SEBS compounds (below 30 Shore A) will shrink more than harder

materials. Some grades, such as Dynaflex G7700, G7800, and G7900 Series contain filler, which reduces their shrinkage.

The shrinkage values reported by GLS are determined using a 0.125” thick plaque. It should be noted that shrinkage is not an exact number, but a range value. This range can be affected by the part wall thickness, melt temperature, mold temperature, injection speed, hold/pack pressures and also the time between molding and measuring. As a result, prototyping is strongly recommended for parts with close tolerances to better quantify the realistic shrinkage of a specific grade of material in a specific application.

For shrinkage values for specific grades, please refer to the product Technical Data Sheet, available at [www.glscorporation.com](http://www.glscorporation.com) or by contacting your GLS representative.

## **MOLD DESIGN**

### **Types of Molds**

GLS SBC compounds can be molded in two- and three-plate molds. Both conventional and hot runner tool designs have been used with GLS compounds. Self-insulating hot runner tool designs are not recommended due to the potential for material degradation in the stagnation zones. Two-shot molds and insert molds can also be used. If a family mold is required, the cavity volumes should be similar, otherwise overpacking and flashing of the smaller cavity may occur.

### **Steel Selection**

GLS styrenic TPEs are generally non-abrasive and non-corrosive. The selection of tool steel will depend on the quantity and quality of parts to be produced. For high volume production, the initial expense of quality tooling is a sound investment.

A wide variety of tool steels are available for injection mold construction. Table 2 lists the properties of common tool steels and the typical mold components for which they are used. Soft metals, such as aluminum and beryllium copper, can be used for prototype parts or short production runs up to 10,000 parts.

**Table 2. Typical Tool Steel for Injection Mold Construction**

Steel Type	Steel Properties	Mold Component
P-20	Pre-hardened, machines well, high carbon, general-purpose steel. Disadvantage: May rust if improperly stored.	Mold bases, ejector plates, and some cavities (if nickel or chrome plated to prevent rust).
H-13	Good general purpose tool steel. Can be polished or heat-treated. Better corrosion resistance.	Cavity plates and core plates.
S-7	Good high hardness, improved toughness, general-purpose tool steel. Machines well, shock resistant, polishes well. Disadvantage: Higher cost.	Cavity plates, core plates and laminates, as well as thin wall sections.
A-2	Good high toughness tool steel. Heat-treats and polishes well.	Ejector pins, ejector sleeves, and ejector blades.
D-2	Very hard, high wear characteristics, high vanadium content, somewhat brittle. Disadvantage: Difficult to machine.	Gate blocks, gib plates to prevent galling, gate blocks to prevent wear.
420 SS	Tough corrosion resistant material. Heat-treats and polishes well. Disadvantage: High cost.	Cavity blocks, ejector pins, sleeves, etc.

Some part designs may benefit from the use of higher thermal conductivity materials such as beryllium copper. This material is less durable than steel and may hob or wear faster than steel if used at the parting-line. Beryllium copper can be used for inserts, slides or cores to increase heat transfer rates and reduce cycle times. In cases where there is a long draw core, a fountain-type bubbler may be beneficial.

### **Mold Surface Treatment, Finishing and Texturing**

Most GLS materials replicate the mold surface fairly well. To produce a glossy surface, a polished mold is required and an unfilled grade should be used. A highly polished tool and a transparent material are required to produce a part with good clarity. If a matte finish similar to that of a thermoset rubber is required, a rougher mold texture should be used (or a GLS product such as GLS Versalloy TPV alloys, which naturally produce a matte surface). In general, an EDM surface will produce a good texture and may improve release from the tool during part ejection. Matte surfaces can also help to hide any flow marks or other surface defects. Vapor honing, sand or bead blasting and chemical etching are also used to produce textured surfaces with varying degrees of gloss and appearance. To aid in release, the cavity or core may be coated with a release coating such as PTFE impregnated nickel after it has been given a sandblast or EDM finish.

## Sprue and Sprue Puller Design

The sprue should have sufficient draft, from 1° to 3° to minimize drag and sprue sticking. Longer sprues may require more taper (3° - 5°), as shown in Figure 3. Typically, the sprue diameter should be slightly larger than the nozzle diameter. An EDM finish is acceptable for most styrenic TPE materials. Permanent surface lubricant treatments have also been used successfully.

Sprue puller designs vary with the hardness of the material. The different sprue designs possible and their relative dimensions are shown in Figures 4 through 7. In addition, Table 3 shows the typical hardness range for which a particular sprue design is applicable.

**Table 3. Typical Sprue Designs for Various Hardness Values**

Typical TPE Hardness Range	Most Common Sprue Puller Types	Figure
>50 Shore A	Tapered, Pin, Z-Type	3, 4 and 6
40-70 Shore A	Undercut	5
5-40 Shore A	Pine Tree	7

Hot sprue bushings and extended nozzles may also be used with GLS compounds. In many molds, the sprue is the thickest wall section in the mold and will control the minimum cooling time. The use of a hot sprue, which may be viewed as an extension of the machine nozzle, can sometimes reduce cycle time. Extended machine nozzles may also be used to reduce sprue length and size. When hot sprues are used, the machine nozzle tip should be a free-flow nozzle rather than a reverse tip.

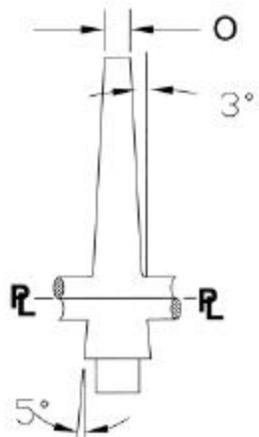


Figure 3. Tapered Sprue Puller

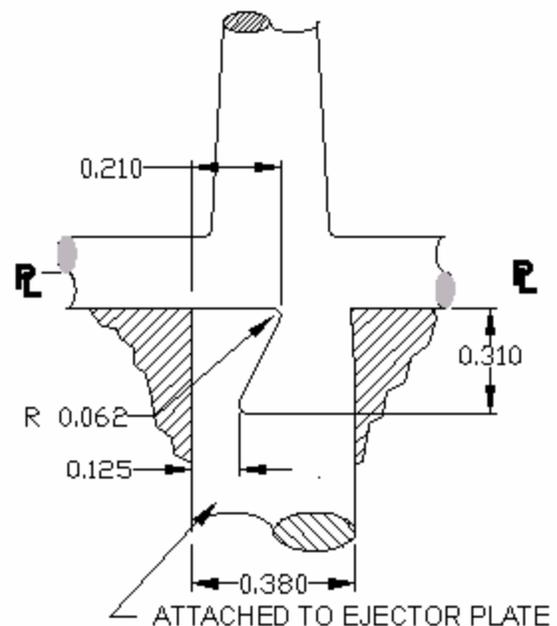


Figure 4. Z-Pin Sprue Puller

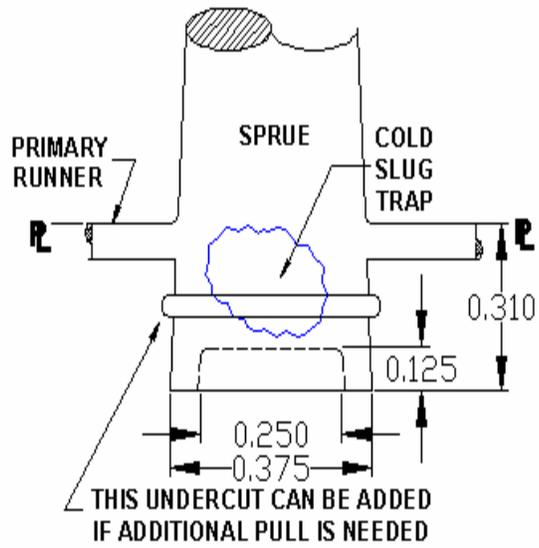


Figure 5. Undercut Sprue Puller

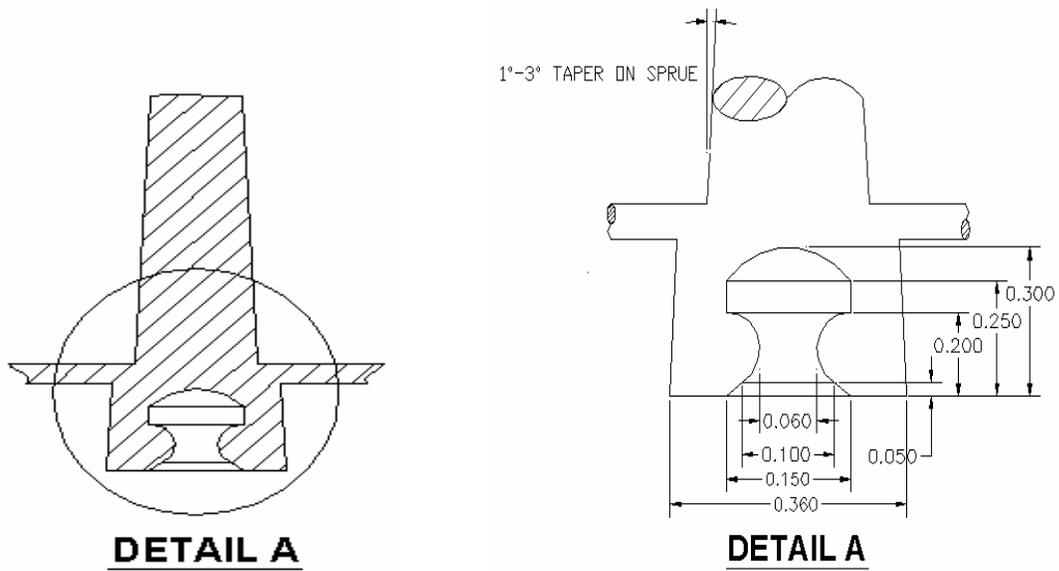


Figure 6. Sucker Pin Sprue Puller

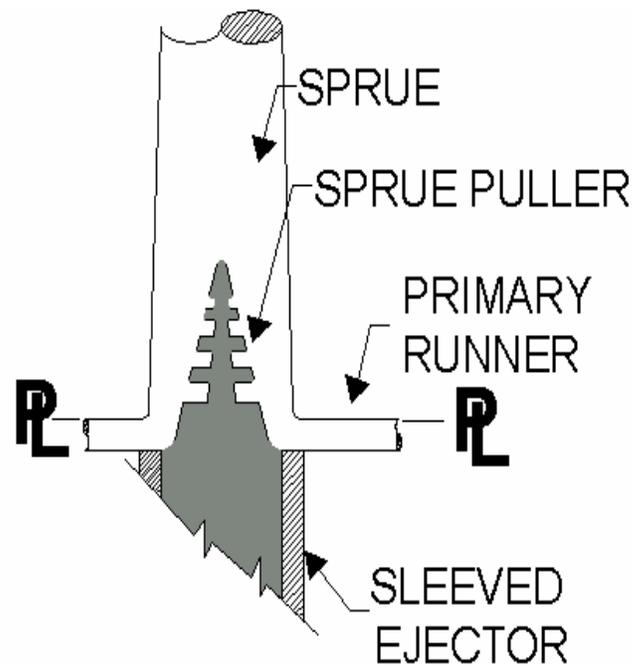
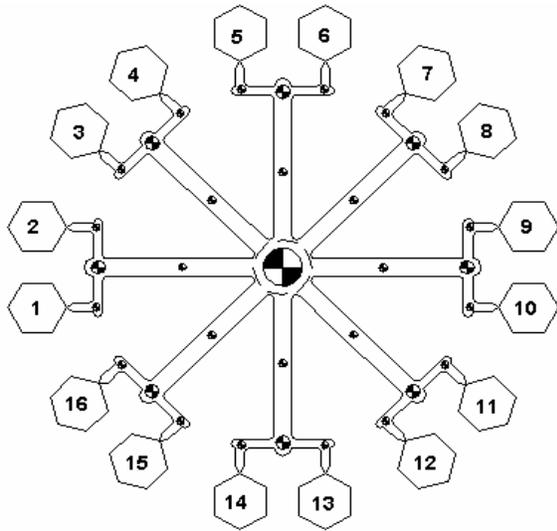


Figure 7. Pine Tree Sprue Puller

### Conventional Runner Configuration and Design

A balanced runner configuration is critical to achieve uniform part quality from cavity to cavity. In a balanced runner system, the melt flows into each cavity at equal times and pressure. The runner balance can be designed by using computer mold-flow analysis programs and verified by performing short-shot studies.

An unbalanced runner may result in inconsistent part weights and dimensional variability. The cavity closest to the sprue may be overpacked and flashing may occur. As a result of overpacking, parts may also develop high molded-in stresses, which lead to warpage. Examples of balanced runner systems are shown in Figures 8 and 9.



➤ **RUNNER "SUCKER PINS" OR EJECTOR PINS**

Figure 8. Example of Balanced Spider Runner

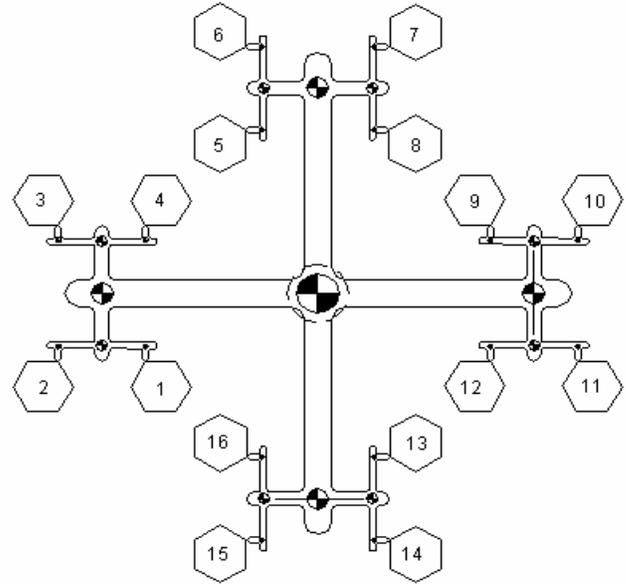


Figure 9. Example of Balanced Cross-Runner

Figure 10 shows different runner cross-sections and their associated efficiency. Full-round runners have the least resistance to flow and surface area, allowing the material to stay molten longer. The second most efficient runner cross-section is the modified trapezoid. This runner geometry most closely simulates a full round runner but only requires machining in only one plate. Figure 11 shows typical ball cutter dimensions and the corresponding modified trapezoid runner sizes. Figure 12 illustrates typical runner dimensions.

$$W = 1.25D$$

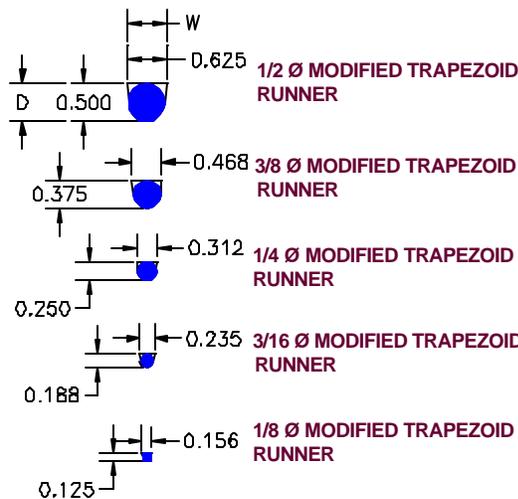


Figure 10. Typical Runner Cross-Sections

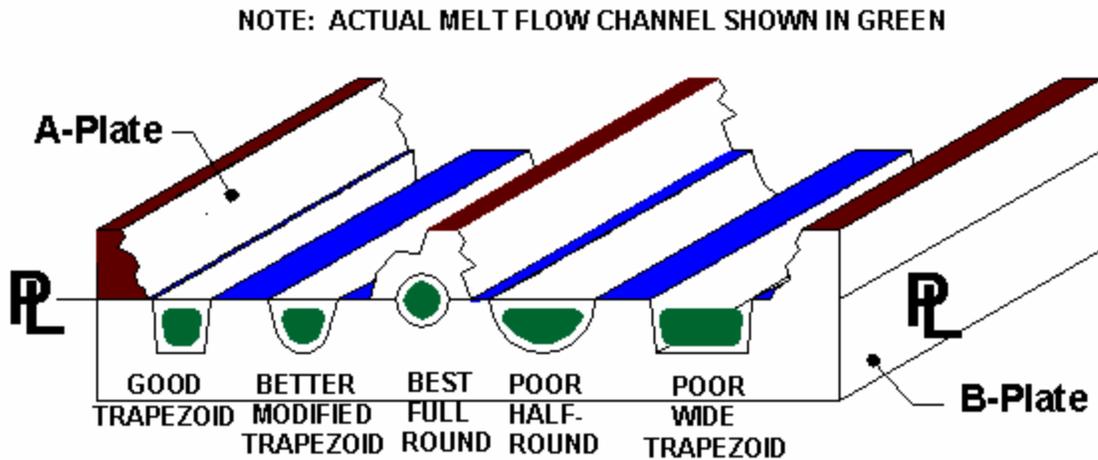
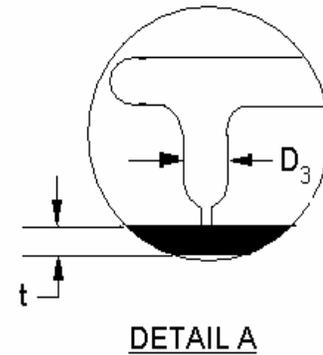
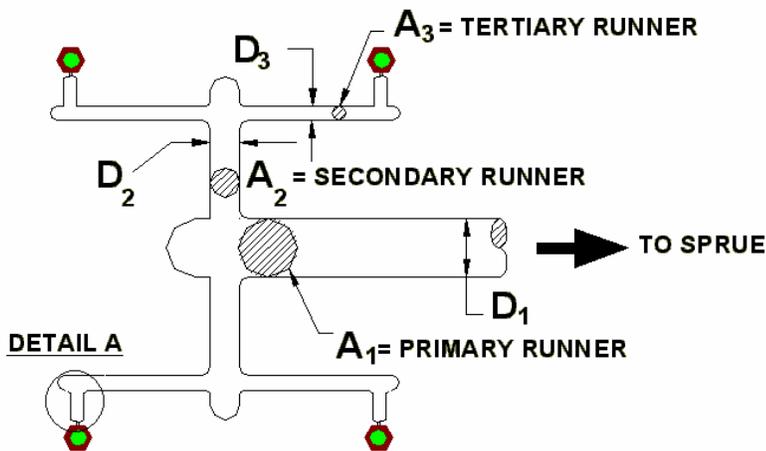


Figure 11. Modified Trapezoid Runner Sizes



Definition of Variables  
 $D_1, D_2, D_3$ : Diameter of runners  
 $A_1, A_2, A_3$ : Cross-sectional area of runners  
 $t$ : Thickness of the part

Guidelines for TPE runner sizes  
 $D_3 = 1.0 - 1.2 t$   
 $D_2 = 1.4 D_3$   
 $D_1 = 1.4 D_2$

Figure 12. Runner Design and Dimensions

Cold slug wells should be used at each runner transition (turn). Cold slug wells serve to remove the leading edge of the melt. The slug well associated with the sprue should be large enough to trap the cold material formed in the machine nozzle during the mold-open cycle. Typical slug well dimensions are approximately 1.5 to 2.0 times the diameter or width of the feed runner.

## Runner Keepers

Runner keepers or sucker pins provide undercuts to keep the runner on the desired plate but should not restrict material flow through the runner. Figures 8 and 9 show typical locations for runner keepers and sucker pins. Figure 13 illustrates an example design of a runner keeper.

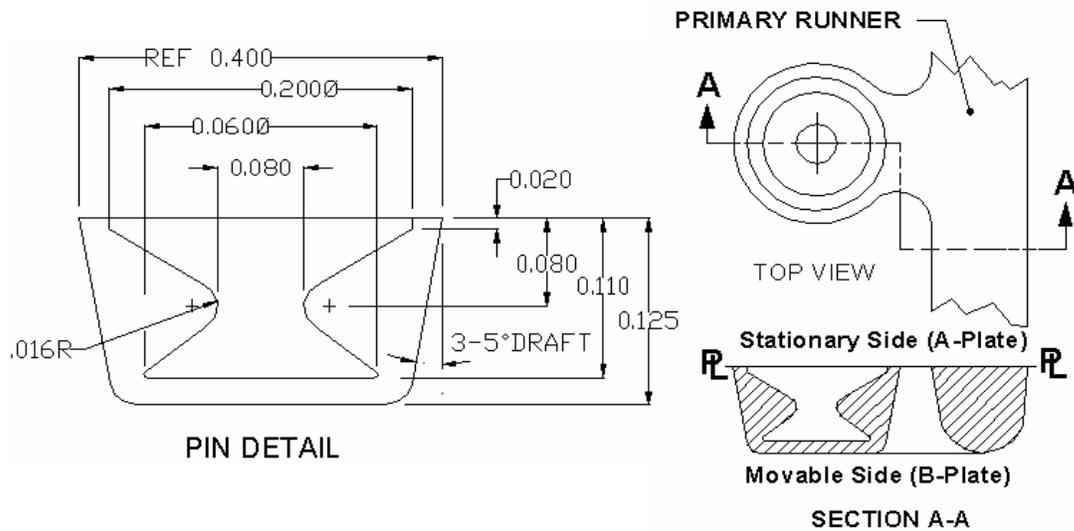


Figure 13. Runner Keeper design

## Gate Design and Location

Most conventional gating types are suitable for processing GLS styrenic TPE compounds. The type of gate and the location, relative to the part, may affect the following:

- Part packing
- Gate removal or vestige
- Part cosmetic appearance
- Part dimensions (including warpage)

The type of gate selected is dependent on both part and tool design. The gate location is equally important. To prevent the chances of jetting, locate the gate entrance in an area where the flow will impinge on a cavity wall. For automatically degating tools, the highly elastic nature of softer TPEs makes submarine gate designs or three plate tools with self-degating drops more difficult. Higher hardness and filled grades usually have lower ultimate elongation and therefore are more easily degated. To assure the gates will break at a specific location, they should have a short land length to create a high stress concentration.

## Tab/Edge Gates

Tab or edge gates (Figure 14) most commonly utilize a conventional sprue and cold runner system. They are located along the tool parting line. A small undercut can be placed where the gate meets the part to minimize gate vestige caused by degating. Advantages of edge gates are ease of fabrication, modification and maintenance. The

gate depth (D) should be 15% - 30% of the wall thickness at the gate entrance. Common practice is to start “steel safe”. A good starting point for the gate width should be 1.0 - 1.5 times the gate depth. The gate land should be equal to or slightly longer than gate depth. The gate size may also depend on the part volume. The gate area may be inserted to facilitate gate maintenance or modification.

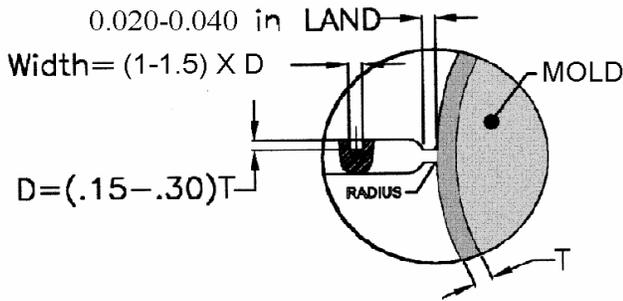


Figure 14. Tab or edge gate

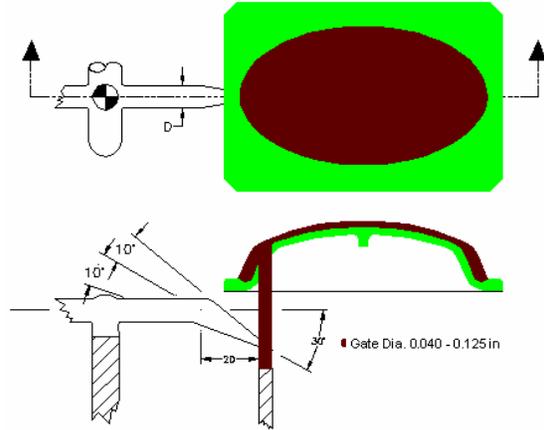


Figure 15. Submarine Gate

Submarine or tunnel gates are self-degating. During part ejection, the tool steel separates the part and the runner. Figure 15 shows a typical design of a submarine gate. Cashew type submarine gates should not be used for medium to soft hardness compounds due to their high coefficient of friction and high elongation.

### Fan Gates

A fan gate is a streamlined variation of a tab gate (Figure 16). The fan gate distributes material into the cavity more evenly; thus it is normally used in parts that require a high degree of flatness and absence of flow lines. It also minimizes the possibility of gate pucker or part warpage.

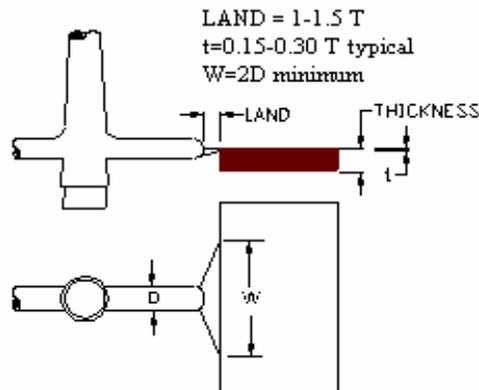


Figure 16. Fan gate

### Sprue or Direct Gate

The sprue or direct gate is often used on prototype parts because it is inexpensive. This type of gating is not recommended for GLS styrenic compounds because of their high elongation. In addition, the sprue will need to be trimmed thus appearance quality of the part is usually poor. If sprue gating is selected, care should be taken to keep both the sprue length and diameter as short and small as possible.

### Diaphragm Gate

The diaphragm gate is used to maintain the concentricity of round parts. It allows even flow into the cavity and minimizes the potential for knit lines. Due to anisotropic shrinkage, flat round parts using center or diaphragm gating may not lay flat. A ring gate may also be used on the outside of a circular part.

Table 4 compares the advantages and disadvantages of the various gate types discussed in this section.

**Table 4. Advantages and Disadvantages of Various Gate Types**

Gate Type	Advantage	Disadvantage
Edge/Tab/Fan Gate	<ul style="list-style-type: none"><li>• Appropriate for flat parts</li><li>• Easy to modify</li></ul>	<ul style="list-style-type: none"><li>• Post-mold gate/runner removal is difficult</li><li>• Poor gate vestige</li></ul>
Submarine Gate	<ul style="list-style-type: none"><li>• Automatic gate removal</li><li>• Minimal gate vestige</li></ul>	<ul style="list-style-type: none"><li>• More difficult to machine</li></ul>
Diaphragm Gate	<ul style="list-style-type: none"><li>• Concentricity</li><li>• Appropriate for round parts</li><li>• No knit lines</li></ul>	<ul style="list-style-type: none"><li>• Scrap</li><li>• Post-molding gate removal</li></ul>
Pin gate (3-plate)	<ul style="list-style-type: none"><li>• Automatic gate removal</li><li>• Minimal gate vestige</li><li>• Localized cooling</li></ul>	<ul style="list-style-type: none"><li>• Requires floater plate</li><li>• More scrap</li><li>• Higher tool cost</li></ul>
Valve gate (Hot runner systems)	<ul style="list-style-type: none"><li>• Minimal gate vestige</li><li>• Positive shut-off</li><li>• Minimizes post pack</li></ul>	<ul style="list-style-type: none"><li>• Higher tool cost</li><li>• Higher maintenance</li><li>• Only for hot runner systems</li></ul>

### Gate Location

Styrenic TPE compounds are anisotropic, thus they have different physical properties in the flow direction versus the cross-flow direction. Depending on the product's intended usage, these property differences could be critical to the performance of the final part. As a result, the anisotropic nature of the styrenic TPE needs to be taken into consideration when determining the gate location on the part.

The material flow may be estimated by eye or by using flow analysis programs. For higher shrinkage grades, the part may shrink near the gate, which causes "gate pucker" if there is a high molded-in stress at the gate. Parts shaped like a handle grip may warp toward the gate side of the part. Locating the gate at the top of the part minimizes this problem. Using two gates on opposite sides of the part can also address the issue, but it will result in two knit lines. If filling problems exist in thin walled parts, adding flow channels or minor changes in wall thickness can alter the flow. In some cases, it may be necessary to add a second gate to properly fill the parts.

The gate should be placed so that the flow path is as short as possible. Locating the gate at the heaviest cross section of the part can improve packing and minimize voids or sinks. If possible, the gate should be positioned so as to avoid obstructions (flowing around cores or pins) in the flow path.

The flow path of the material should minimize the possibility of formation of knit lines and flow marks. Upon injection, the material should impinge off the cavity wall to reduce the possibility of jetting. To minimize the effect of molded-in stress (at the gate) on part performance, the gate should be located in noncritical areas of the part. Also, the gate location should allow for easy manual or automatic degating.

## Mold Venting

Mold venting is critical to the quality and consistency of the finished part. Venting is required to allow the air in the sprue, runner and cavity to leave the tool as the melt flows into the cavity. Inadequate venting may cause short-shots, poor surface appearance, or weak weld-lines. Potential air traps in the part design can be predicted by flow simulation software. Once the tool has been built, short-shot studies can be used to find the critical venting areas.

Vents should be placed at the last place to fill and in areas where weld lines occur. The typical vent size for GLS compounds, is 0.0005" - 0.0010" (0.012 mm - 0.025 mm) with a 0.040" - 0.060" (10 mm - 15 mm) land. Past the land, the vent depth should be increased to 0.005" - 0.010" (0.12 mm - 0.25 mm) to provide a clear passage for the air to exit the tool (Figure 17). Venting in areas below the parting line can be accomplished by allowing the ejector pin to be 0,001 loose on each side (Figure 18). Venting of ribs or pockets can be achieved by venting down an ejector pin, or with the use of porous mold steels. Ejector pin vents are self-cleaning, but they should be wiped once a day to remove build-up. Porous plug vents need to be replaced, or dismantled and cleaned when they become clogged.

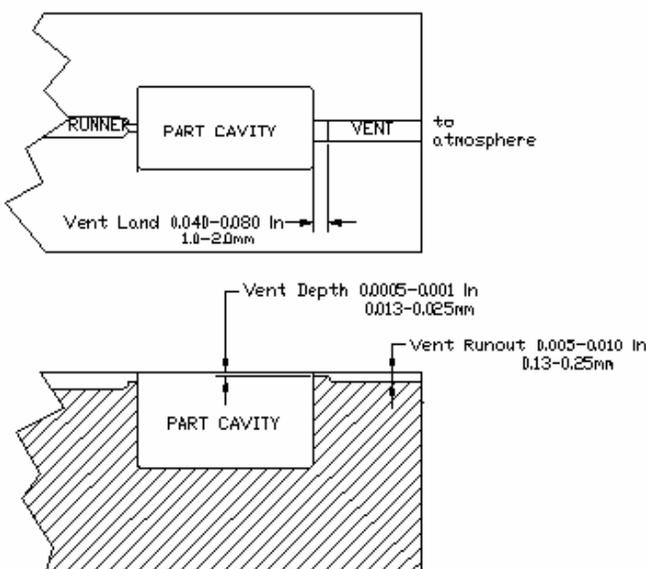


Figure 17. Mold vent design

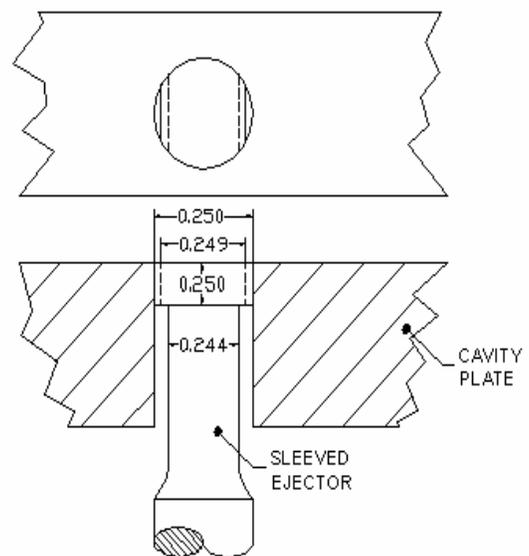


Figure 18. Venting through an ejector pin

## Part Ejection

Part ejection is more difficult in long draw areas. A 3° - 5° draft per side on all long draw areas is recommended. Ejector pins should be located at runner transitions and in areas of the part where appearance is not critical. The diameter of ejector pins should be as large as possible to minimize push-through marks. Larger pins also allow for easier ejection of warmer parts, which can reduce cycle time. Ejector blades, ejector sleeves and stripper rings can be used for part ejection. Air ejection and the use of poppet can help strip large undercuts, providing the material has room to deform when the air is applied. Mold surface texturing and special mold surface treatments can also help to pull the parts from the “A” half. Advancing cores are used usually when ejecting large internal undercuts.

## Mold Cooling

The mold should have adequate cooling to optimize cycle time. The use of mold materials with high heat transfer, such as beryllium copper, can be used to cool slides or inserts. Commercially available fountain-type bubblers may also help to cool long cores. Separate chillers for the movable and stationary sides are suggested. This allows the processor to use differential cooling to help retain the parts on the movable (“B”) plate. Connecting cooling lines from the A to the B plate should be avoided. Special cooling for cores and slides is also an option to improve cooling efficiency.

## HOT RUNNER SYSTEMS

The differences between hot runner systems; cold runners and hot sprues are summarized in Table 5. GLS SEBS compounds are quite heat stable and are used successfully in hot runner tools today.

Selecting a particular type of hot runner system is influenced by the product design and production requirements. There are many hot runner component and tool manufacturers available. If possible, utilize a system or component supplier with experience in styrenic TPEs. **SBS compounds can crosslink (forming gels) if they are held at high temperatures for too long a period of time, therefore hot runner tools are not recommended for these materials.**

## Manifold Design

**Table 5. Comparative Assessment of Hot Runner Systems**

<b>System Type</b>	<b>Advantage</b>	<b>Disadvantage</b>
Cold runner	<ul style="list-style-type: none"> <li>• Lower tool cost</li> <li>• Easily modified</li> <li>• Enables use of robotics</li> </ul>	<ul style="list-style-type: none"> <li>• Typically governs cycle time</li> <li>• Potential for cold slugs</li> <li>• Potential for sprue sticking</li> <li>• Scrap (though regrindable)</li> </ul>
Hot Sprue or Extended Nozzle	<ul style="list-style-type: none"> <li>• Faster cycle</li> <li>• Minimizes scrap</li> <li>• Easily maintained</li> <li>• Better temperature control</li> </ul>	<ul style="list-style-type: none"> <li>• Higher tool cost</li> <li>• Potential heat degradation for SBS compounds</li> </ul>
Hot Runner	<ul style="list-style-type: none"> <li>• No runner scrap</li> <li>• Faster cycle time</li> <li>• Precise temperature control</li> </ul>	<ul style="list-style-type: none"> <li>• Highest tool cost</li> <li>• Purging</li> <li>• Material degradation</li> <li>• Maintenance</li> </ul>

Externally heated systems are best. Internally heated manifolds are not suitable for TPEs. These systems typically have hot spots and stagnation zones that cause partially solidified material to cling to the cooler manifold walls. For maximum flexibility, the design should be naturally or geometrically balanced. Rheological balancing is possible, but only for a specific grade or rheometric curve. Internally heated manifolds are not suitable for TPEs – these systems typically have hot spots and stagnation zones that cause partially solidified material to cling to the cooler manifold walls. All passages should be highly polished circular cross sections with gentle bends to minimize the possibility of stagnation zones. In order to maintain high shear, minimize residence times and promote flow, the passages should have a diameter of 0.250” to 0.375”. Individualized zone controls for the hot runners are recommended and allow the operator to adjust the balance slightly to make the parts more uniform.

### Hot Runner System Gates

#### Valve Gates

Valve gates offer the best solution for high production parts where surface quality is critical, such as medical and cosmetic products. Since valve gates leave only a slight ring on the part, gate vestige is minimized. Further improvement can be obtained by positioning the valve recessed below the part surface or concealing the gate in the part detail for aesthetic products. An example of a hot runner system with a valve gate is shown in Figure 19.

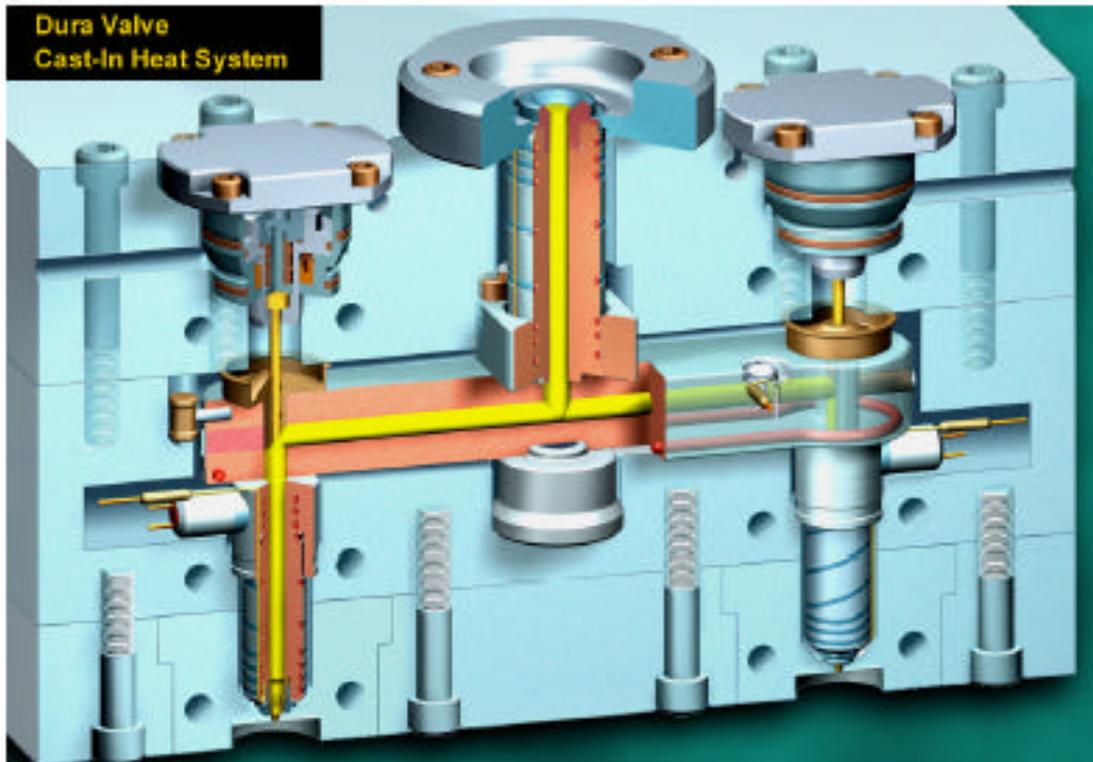


Image provided by Mold-Masters Limited, Dura is a registered trade-mark of Mold-Masters Limited.

Figure 19. Hot Runner System using valve gate

The gate diameter of a valve gate should be approximately 0.030" to 0.125", depending on the size and thickness of the part. Valve gates do not require the material in the part to freeze before the valve is closed and hold pressure is released. Therefore, the screw recovery for the next cycle can start earlier and the total cycle time may be decreased. For very thick wall parts with the potential for sinks or shrink voids, valve gates can be held open for an extended time to supply make-up material and eliminate voids and sinks.

Valve gate elements need to be insulated from the mold plates to maintain proper temperature control. Only valve gates can be used for multi-cavity foam molding or cascade molding to fill long thin flows without knit lines. Due to the low viscosity of some GLS grades, properly maintained tight valve gates are required to prevent leakage or hair flash. Valve gates may be pneumatically or hydraulically activated. Individual heater controls at each gate will allow fine control of the melt viscosity and filling.

### Hot Tip Gates

Hot tip gates are suitable for SBC compounds but will leave some gate vestige (which can be as high as 50% to 75% of the gate diameter). Vestige can be minimized by slightly recessing the gate below the part surface. The land length of the hot tip should be less than the diameter of the gate.

The elements of the hot tip should be properly insulated from the mold plates and cavity. In order to achieve this, the land length of the gate may need to be lengthened and a portion of the land should be part of the cavity. All passages within the tip should be

highly polished and streamlined to minimize stagnation and degradation zones. The efficiency of the design may be verified by recording the time it takes to make a complete color change while producing parts. This demonstrates whether there is any residual dead zone material that continues to enter the melt stream.

For hot tip gate systems, there should be a delay long enough for the part to set up completely before mastication is initiated for the next cycle. Without a delay, the parts may become overpacked. This is particularly important for low hardness, high flow materials. To reduce overpacking for thick-walled parts with large gates, use minimal back pressure during mastication.

Since TPE compounds are slightly compressible in the molten state, larger runner volumes can cause hot tip gates to drool after the mold is opened. To prevent drool, the runner system should be minimized and the melt decompressed before the mold opens.

Hot tips may be used to fill a secondary cold runner to supply material to multiple parts. Each hot tip gate should use an individual temperature controller. If the hot tip manufacturer selected does not have prior SBC compound experience, it may be necessary to experimentally determine the best gate type and geometry through prototyping.

## **OVERMOLDING**

One of the largest areas of growth for TPEs is overmolding. Many product designers are utilizing TPEs to add a “soft touch” to a rigid material. GLS compounds can be overmolded onto many different substrates to alter the surface feel, improve aesthetics, and cushion against vibration – the possibilities are limitless.

Most Dynaflex<sup>®</sup> and Kraton<sup>®</sup> compounds (and Versalloy<sup>®</sup> TPV Alloys) are suitable for two-shot or insert molding onto a PP (and in some cases, PE) substrate. The Versaflex<sup>®</sup> OM grades have been specially formulated to bond PC, ABS, nylon 6/6, PC/ABS, and PPO. The new Versollan<sup>®</sup> OM series, based on BASF high performance polyurethane (TPU), are TPU alloys specifically designed for thin-wall overmolding (both insert and two-shot molding) onto PC, ABS, and PC/ABS substrates.

With new innovative technologies, GLS continues to develop TPEs that bond to a variety of substrates. For additional information about the standard Versaflex OM series and the development of new TPEs that bond to unusual substrates, please contact your GLS Representative.

For more information about overmolding part design, mold design and processing, please refer to the GLS publication “Overmolding Guide”, available at [www.glscorporation.com](http://www.glscorporation.com) or by contacting your GLS representative.

# MACHINE SELECTION

## Machine Types

Reciprocating screw machines are recommended. However, ram or plunger equipment has been used to produce SBS parts. Newer machines with a computer interface offer improved process control and are preferred for multi-cavity tools and high production applications. Machines with the capability of programmable injection rates and pressures can produce better quality parts. Molding machines that control the shot size by position are preferable to machines that can only control by pressure and/or time. A vertical press with a rotary or shuttle table works well for insert molding. Multi-station rotary presses allow more cooling time for molding foamed parts.

## Clamp Capacity

The clamp capacity necessary for GLS styrenic compounds is lower than most TPEs. Clamp capacity can be calculated by the following equation:

$$C = (1.5 \text{ to } 3) \times A_t$$

A clamp capacity example calculation is shown in Figure 20.

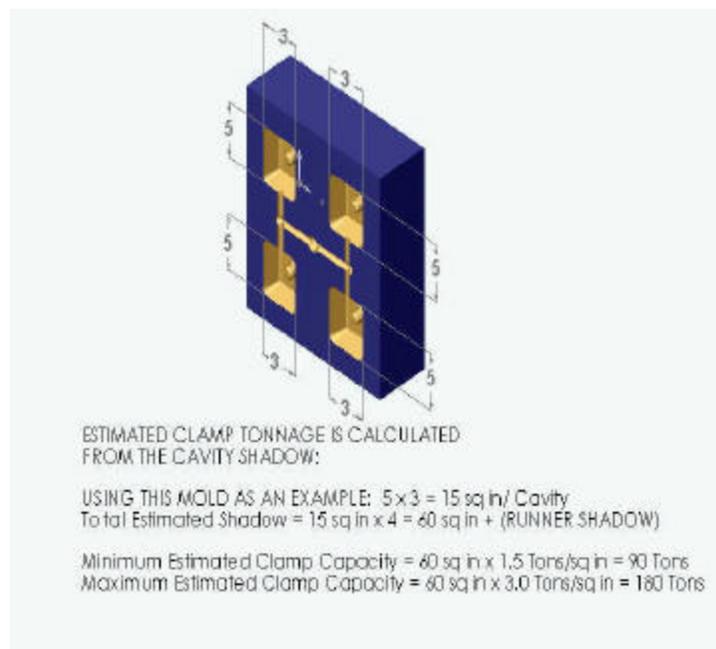


Figure 20. Estimating Machine Clamp Capacity

## **Barrel Capacity**

If possible, use a machine that utilizes 25% to 75% of the barrel shot size capacity. This allows for optimum temperature control of the material and minimizes material residence time at high temperatures. The material residence time for SEBS compounds should be no more than 10 minutes. The material residence time for SBS compounds should be no more than 8 minutes maximum. If a high level of regrind is utilized, the barrel capacity should be reduced.

## **Nozzle Selection**

Smaller nozzle diameters are recommended because they promote shear heating during injection and generate less cold slug material. Suggested starting diameters are 0.0625" - 0.1875" (1.59 mm - 4.76 mm). Static mixing nozzles have been used to improve color dispersion for concentrates with a high letdown ratio. Extended nozzles have also been used to decrease the length of the sprue (resulting in less scrap). If a foaming agent is required (to produce foamed parts), a mechanical shut-off nozzle must be used to control foaming activity and to prevent drooling.

## **Screw Selection**

General-purpose screws are suitable for styrenic TPEs. Compression ratios of 2:1 to 3:1 are commonly used for both SEBS and SBS compounds.

# **MATERIAL HANDLING AND PREPARATION**

## **Drying**

Drying is not typically required for GLS styrenic TPE compounds. Certain specialty products, such as the Versaflex and Versollan overmolding grades, are hygroscopic; thus they need to be dried prior to molding. A desiccant dryer with a -40°F dewpoint is strongly recommended for drying hygroscopic materials. Specific drying temperatures and times can be found on the Technical Datasheets for each individual product.

## **Coloring**

SBC compounds have inherently superior color than most other TPEs. Therefore, they require less color concentrate to achieve a particular color and the colors produced are cleaner (less yellow) than other TPEs. Generally, the color concentrate should be lower in viscosity (have higher melt index) than the base compound. This will promote ease of dispersion.

- Styrenic color carriers are recommended for the SBS compounds.
- Polypropylene (PP) carriers are recommended for the harder SEBS compounds.
- For soft SEBS compounds low-density polyethylene (LDPE) or ethylene vinyl acetate copolymer (EVA) have been used. PP carrier is not recommended for softer grades, as the compound hardness will be affected.

Liquid colors can be used but the carrier should be a paraffin type mineral. Poly vinyl chloride (PVC) plasticizers, such as dioctyl phthalate (DOP), should not be used as carriers. Dry colors have also been used but may require more material and time to perform color changes.

The use of a polyethylene (PE) carrier may adversely effect adhesion to the substrate for some overmolding applications. If using a specialty overmolding grade, follow the coloring recommendations given on the individual product Technical Data Sheets.

Detailed coloring recommendations are summarized in *TPE Tip # 3*.

### **Gloss and Clarity**

GLS compounds are available in opaque, translucent and water-clear grades. The Versaflex<sup>®</sup> CL series is formulated for high clarity. Clear grades can produce the best metallic or pearlescent colors. High gloss clear grades have higher COF's and more intimate mold contact and therefore are more difficult to eject. Filled opaque compounds are more difficult to color in deep intense colors, but will produce good pastel colors.

### **Regrind**

Up to 80% regrind may be used for SEBS compounds. High levels of regrind are better tolerated in black materials. Natural, light-colored or clear compounds will more easily show contamination or discoloration. Organic pigments used to produce yellow, red, blue and green colors are more likely to change color after prolonged residence time or high regrind levels. For SBS compounds, the regrind should be kept below 25%.

Dynaflex compounds have high elongation and good tear strength and therefore require the use of a high quality grinder with sharp knives. For lower durometer styrenic compounds the clearances should be set to 0.003" maximum. Only grinders with high quality support bearings and a rigid frame can maintain the tolerances necessary to achieve the necessary rotor knife to bed knife clearances. The use of a small amount of a dusting agent such as talc or calcium carbonate can minimize agglomeration during the grinding process. Feed small amounts of parts into the grinder at one time to minimize heat buildup, which can lead to agglomeration.

To allow the best incorporation of the regrind into the virgin material, the screen size should be chosen to yield particles that are roughly the same size as virgin pellets.

### **Purging**

If the press is down for more than 10 minutes, purge before restarting production. To prevent flashing, restart the machine using a reduced shot size and gradually increase it back to the original shot size. This will help to prevent flashing from occurring behind slides or inserts. For SBS compounds - if a machine is to be left at temperature longer than one hour, purge with LDPE or polystyrene before shut down. For SEBS compounds - if the machine is down over the weekend, purge with a high molecular weight (low or fractional melt flow) LDPE at low temperatures before shut down. On start up, retract the extruder and air purge it well before attempting to fill the mold.

# PROCESSING CONDITIONS

## Introduction

This section describes general processing guidelines for styrenic TPEs. The specific starting conditions for each individual product are located in the Product Technical Datasheet.

## Setting Barrel Temperatures

Figure 21 shows typical starting barrel temperatures. Barrel temperatures should be set progressively. The feed zone temperatures should be set fairly low [typically 250°F - 300°F (120°C -150°C)] to avoid feed-throat bridging and allow entrapped air to escape. Lower temperatures in the transition zone allow proper compression and shearing of the compound before it fully melts. To improve mixing when using color concentrates, set the transition zone temperatures above the melt temperature of the concentrate. The zone nearest to the nozzle should be set close to the desired melt temperature.

After the process has stabilized, the actual barrel temperatures should be compared to the set points. If the actual temperature exceeds the set temperature, then shear heating has caused the material to overheat. If good parts are being produced, the temperature settings should be reset to be the same as the actual temperatures.

The heaters should demand power 25% to 50% of the time. If the heaters are on continuously, there is not enough heat being produced from shear. To increase shear heating, increase the screw rpm and back pressure.

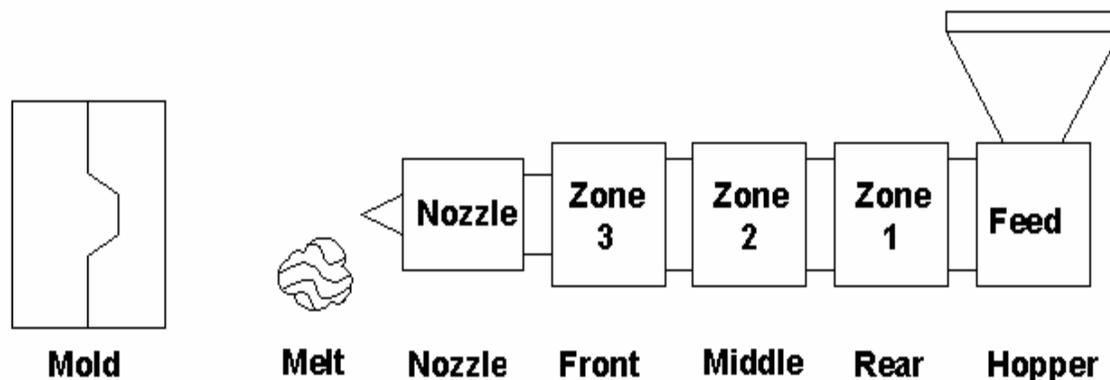


Figure 21. Suggested Initial Start-Up Conditions for Injection Molding.

## Setting Mold Temperatures

Mold temperatures should be set above the dew point temperature in the molding area. This prevents sweating of the mold and possible water contamination in the cavity. Water contamination usually appears as streaks in the parts. Mold temperatures may be raised if there are long or thin sections of the part that have proven to be difficult to fill. Higher mold temperatures usually result in higher cycle times but may improve weld line integrity and part appearance.

**Table 6. Product Family and Temperatures**

Product Family	Mold	Melt	Nozzle	Zone 3	Zone 2	Zone 1	Feed
SBS Compounds	75-90°F (25-32°C)	370-390°F (190-200°C)	370-390°F (190-200°C)	360-380°F (185-195°C)	340-360°F (170-182°C)	300-330°F (150-165°C)	100-150°F (40-65°C)
SEBS Compounds	110-130°F (43-55°C)	370-430°F (190-220°C)	390-430°F (200-220°C)	390-430°F (200-220°C)	370-390°F (190-200°C)	350-370°F (175-190°C)	100-170°F (40-75°C)
Supersoft Compounds	110-130°F (43-55°C)	340-390°F (170-200°C)	360-390°F (180-200°C)	360-390°F (180-200°C)	335-375°F (170-190°C)	300-330°F (150-165°C)	100-120°F (40-50°C)

### Setting Shot Size

When starting up a new mold, begin with short-shots, then gradually increase the shot size until all part cavities are 80-90% filled. This procedure can minimize the potential for overpacking and prevent flash in vents. The screw position should be noted and used to set the transfer point. Monitor the cushion to insure that it is maintained during the pack and hold phase. If there is no cushion, the pack pressure cannot be maintained and there is no control of part densification. After the gate freezes, any additional material volume or pressure will just pack the sprue and runner system, which can cause difficulties with sprue removal during part ejection.

### Screw rpm, Back Pressure and Screw Delay Time

The screw rpm should be set so that the screw is fully recovered for the next shot, typically 2 to 3 seconds before the mold opens. Typical screw speeds range from 50 rpm to 150 rpm. If the screw recovers too fast, and the machine is equipped with a screw delay timer, set the delay time so that there is minimal delay after the screw is fully recovered and the mold opens. This will reduce material residence time at temperature and dead time in the barrel.

Increasing the back pressure increases shear heating of the material. Normal settings for back pressure are 50-150 psi. When mixing color concentrates, higher back pressure is preferred to achieve optimum dispersion.

### Injection Speed

If possible, profile the injection speed to fill the runner system rapidly and then slow down after the material starts flowing through the gate and into the cavity. Maintain this speed until the part is 90% full and then reduce it further to completely fill the cavity without flashing the part. As stated earlier, GLS compounds are shear responsive. If a part has difficulty filling, increase the injection speeds before increasing temperature. The injection time to fill the part should be between one and two seconds. Slower fill rates may be required if surface flow defects occur.

## **Injection and Transfer pressures**

If the machine is not capable of being controlled by fill speed, set the injection pressure high enough to fill the runner system and cavity in about 1 to 5 seconds. Adjust the initial transfer pressure to approximately 50% of the injection pressure required to fill the part cavity. This helps to minimize the pressure during the pack and hold phase of injection. When setting the shot size, monitor the cushion to insure it is maintained during the pack and hold phases.

## **Transfer From Boost to Pack to Hold**

Newer molding equipment provides additional options for transferring from injection boost (first-stage Injection) to the pack and hold phase. The most accurate method to transfer from boost to pack pressure is by screw position. Using screw position allows the processor to consistently inject a specific volume of material to the cavity. It also provides accurate control of part packing and densification, which can help prevent sinks and voids in the part. Time is another method for controlling transfer but is not recommended. Transfer using cavity pressure is expensive because it involves installing pressure transducers in the part cavity. This process is used when highly accurate molding tolerances are required. Reducing the transfer pressure from boost to pack and hold will help to control drool at the bushing tip. If the injection unit is equipped with a profiled pack and hold phase, it can be used to reduce the velocity and pressure to the runner.

## **Injection Time**

The optimum time to fill the runner system is approximately 0.5 - 1.5 seconds. It should take another 1 - 5 seconds to fill the cavities. If possible, it is better to control the fill time by controlling the injection speed.

## **Hold Time**

The hold time should be set to achieve gate freeze. Usually, the gate size is the determining factor for hold time. The larger the gate the longer the hold time required to achieve gate freeze.

## **Cooling Time**

The cooling time is principally dependent on the temperature of the melt, the wall thickness of the part and cooling efficiency. In addition, the material hardness is a factor. Harder grades (>50 Shore A) will set up faster in the mold compared to very soft grades (<20 Shore A). For an average part and medium hardness SEBS compound the cooling time will be approximately 15 to 20 seconds for every 0.100" of wall thickness, provided there is cooling available from both sides. Overmolded parts will take longer to cool because they can be effectively cooled over a smaller surface area. The cooling time for overmolded parts will be approximately 35 to 40 seconds for every 0.100 inches of wall thickness.

## **Maintaining Cushion**

Cushion should be maintained or there will be no control of part densification or compensation for material shrinkage. Inadequate cushion and hold pressures will result in underfilled parts with voids or sinks and poor physical properties. Gates that freeze off too quickly (as a result of being too small or too cool mold temperatures) may also cause these above issues.

A worn or contaminated check ring can limit the machine's ability to hold pressure and maintain a cushion. GLS compounds have lower viscosity (higher flow) than traditional thermoplastics and will leak back easier than other materials. The sealing capability of the check ring should be verified by observing the machine's ability to maintain a cushion position.

### **Process Conditions for Hot Sprue Bushings or Extended Nozzles**

Hot sprue bushings should be viewed as an extension of the machine's nozzle. Externally heated sprue bushings work well with TPEs. Hot sprues and extended nozzles are normally set 5° - 10° F higher than the front zone temperature. Avoid the use of Variac or variable resistance controllers, as these controllers tend to overheat the material during short shutdowns.

### **Effects of Molding Conditions**

If a part is molded at too low a temperature, it will require excessive pressure to fill the cavity. This will result in high molded-in stresses. This in turn can cause the part to warp during ejection or at a later time when it is exposed to an elevated temperature. There also may be greater than normal post mold shrinkage and a reduction in the ultimate elongation.

The effects of overpacking the part may include:

- Gate bulge
- Increased density, thus higher part weights
- Increased hardness

The effects of underpacking a part may include:

- Gate pucker
- Voids and/or surface sinks
- Reduced physical properties
- Lower than normal hardness

Monitoring part weights has successfully been used to verify process stability and consistency. It should be noted that the gate size/location, runner dimensions and other aspects of the mold design might also affect the properties of a part.

For clear compounds, parts that have been processed at too low a temperature will have a frosty surface appearance. SBS based compounds will develop a yellow or orange color and distinctive odor when they have been processed at too high a temperature or held at temperature for too long. The color and odor are strong signs that the material has been degraded. Degradation results in poor appearance and reduction in physical properties. SEBS compounds that have been processed at too high a temperature will have a burnt odor (degradation) and in the worst case become tacky and bleed oil.

### **Molding Soft Compounds (10 - 20 Shore A)**

Soft compounds have very low viscosity (high flow); thus they require minimal injection pressure. Typical values for injection pressure are 150 psi - 450 psi. Most of the GLS soft styrenic TPE compounds are either water-clear or translucent. Clarity in the molded part can be marginally improved by increasing the mold and melt temperatures. A high polish

mold surface finish is usually justified with these products, as they duplicate the mold surface quite well.

The softer materials exhibit some tacky behavior. Cleanliness in close proximity to the molding area is important as softer materials attract and retain dust and contaminants. This tackiness also makes part ejection more difficult. In these cases, robotic sprue pickers, runner keepers, or air ejection may be required. The addition of a slight surface texture to the mold can help to mask possible surface blemishes in the molded article.

### **Molding Hard Compounds (<sup>3</sup> 50 Shore A)**

The harder compounds usually have higher viscosity and may require slightly higher injection pressure (400 psi - 800 psi) to fill the cavity. Due to their higher modulus, hard compounds require less aggressive sprue-pullers. They also tend to set up quicker, are more easily ejected and may be ejected from the mold at higher temperatures. In addition, the harder compounds may achieve a reduction in cycle time compared to softer materials.

## **TROUBLESHOOTING**

### **Approach to Troubleshooting**

Proper troubleshooting should use a systematic approach to resolve problems. There are two kinds of issues: those involving “quality control” and those encountered during startup.

“Quality control” issues occur when parts have been successfully produced in the past, but are now out of specification. These problems are the result of something in the process changing. To resolve them, you must determine what has changed and restore the process to its proper balance. Startup problems occur during the launch of a new tool or machine.

### **Quality Control Issues**

Most quality control issues are caused by process conditions, the material, or machine and tool maintenance. If the problem occurred after a change in the material lot number, try a different lot of material. It is advisable to retain a store of the previous lot of material.

If the mold setting is from a previously successful part, check the original setup conditions. If the mold is used in a different machine, minor adjustments to account for the new machine may be necessary. If the mold was modified during its downtime, process adjustments may be required.

### **Startup Issues**

To resolve startup problems, the material’s process window must be determined to ensure that there is a set of conditions that can make good parts. Start by setting the process conditions to the middle of the material’s process range and then adjust the process to fix any observed problems. If successful parts are not possible, determine what combination of variables must be changed to resolve the problems. These changes may include material selection, machine selection, and/or tool redesign.

# Injection Molding Troubleshooting

## QUALITY CONTROL ISSUES

OBSERVED PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
<i>Shorts</i>	Inadequate shot size.  Vents blocked.	<b>Material blockage at throat - lower feed zone temperature.</b>  Clean vents.
<i>Flashing</i>	<b>Too much material.</b>  Clamp pressure low.  Injection pressure too high. Injection speed too fast.	<b>Check shot size.</b>  Check for dirt on the mold parting line of low hydraulic pressure. Check injection pressure and speed.
<i>Burns</i>	<b>Dieseling in the mold.</b>	<b>Clean vents.</b>
<i>Non-Uniform Color</i>	<b>Poor concentrate mixing or dispersion.</b>	<b>Check barrel temperatures.</b> Check back pressure and screw rpm, increase if necessary.
<i>Off-Color Part or Odor</i>	<b>Contamination.</b>  Material degradation.	<b>Check for contamination.</b>  Reduce the level of regrind. Reduce the rear zone temperature. Reduce the residence time. Add delay to screw recovery.
<i>Dimensions Out of Specification</i>	<b>Loss of control of shrinkage.</b>	<b>Check hold pressures.</b> Check melt and mold temperatures. Check that cushion was maintained.
<i>Surface Defects (Streaks)</i>	<b>Moisture in part.</b>  Possible mold sweating.	<b>Dry material.</b> Check for contamination. Raise mold temperature.
<i>Voids or Sinks</i>	<b>Inadequate amount of material.</b>	<b>Make sure there is a cushion maintained.</b> Increase shot size. Increase pack and hold pressures. Increase hold time.

# Injection Molding Troubleshooting

## STARTUP ISSUES

OBSERVATION	CAUSE	SOLUTION
<b>POOR KNIT LINES</b>	Poor venting.	Place vents at last place to fill and at converging flow fronts Increase size of the vents.
	Too cool a melt.	Increase the melt and/or mold temperature. Increase injection speed.
<b>PART SHORTS</b> and has burn marks	Gas trapping/ poor venting.	Improve venting and/or relocate to burned area.
<b>PART SHORTS</b> No burn marks	Not enough material.	Increase shot size, if possible. If not, move to a larger machine.
	Blockage in flow at the feed-throat.	Reduce rpm and back pressure. Decrease the barrel temperature in the rear.
	Not enough injection pressure.	Increase injection pressure.
	Material too high in viscosity.	Increase injection rate. Increase process temperature. Use a lower viscosity compound. Increase gate and runner size.
<b>PART FLASHES</b>	Too much injection pressure.	Reduce injection pressure and time.
	Too much material.	Decrease shot size.
	Material viscosity too low.	Reduce injection speed. Reduce process temperature.
	Tool too loose.	Machine or dress the parting line.
	Not enough clamp capacity.	Use a higher viscosity compound. Increase clamp tonnage. Reduce thickness of the vents. Move to a larger machine.

## Injection Molding Troubleshooting

### STARTUP ISSUES (CONT.)

OBSERVATION	CAUSE	SOLUTION
<p><b>VOIDS OR SINKS</b>            Voids occur inside the part. Sinks pull away from the mold wall.</p>	<p>Material shrinkage &amp; insufficient supply of molten material.</p> <p>Not enough pack pressure during material solidification.</p>	<p>Decrease wall thickness.</p> <p>Increase the pack pressure and time.            Increase the gate size.            Relocate the gate to the thickest section.            Increase the runner size.</p>
<p><b>BUBBLES</b>            Part surface bulges above a bubble.</p>	<p>Gas entrapment.</p>	<p>Relocate the gate or modify the flow path.            Add a pin in the area to eliminate the gas trap.</p>
<p><b>FLOW MARKS</b>            Back fills            Shadowing            Folds</p>	<p>Filling from thin to thick sections.</p> <p>Surface irregularity.</p> <p>Uneven filling of section.</p>	<p>Reposition the gate to a thick section.</p> <p>Radius dimples.</p> <p>Relocate gate to balance the flow or reduce the runner diameter.</p>
<p><b>JETTING</b></p>	<p>High viscosity flow.</p>	<p>Increase process temperature.            Increase injection speed.            Decrease gate size.            Change type of gate.            Relocate gate to impinge.</p>
<p><b>WARPED PARTS</b></p>	<p>Anisotropic shrinkage.</p> <p>High molded-in stress.</p>	<p>Relocate the gate so flow occurs in only one direction.</p> <p>Increase the process temperature.            Reduce the pack pressure.            Increase the mold temperature.</p>
<p><b>SURFACE DEFECTS</b>            Uneven shine            Beach marks</p>	<p>High molecular weight compound in highly polished mold.</p>	<p>Change to a lower molecular weight compound.            Texture mold cavity surface (EDM, sandblast, etc.)</p>
<p><b>SURFACE DEFECTS</b>            Silver streaking or splay marks</p>	<p>Contaminated material.</p> <p>High shear in the material.</p>	<p>Check for moisture (condensation) or dry the material.            Check regrind for contaminants or moisture. Dry if required            Reduce injection speed.            Increase the process temperature.            Increase the gate size.</p>

## Injection Molding Troubleshooting

### STARTUP ISSUES (CONT.)

OBSERVATION	CAUSE	SOLUTION
<b>EJECTOR PIN MARKS</b>	Parts soft during ejection.	Increase mold close time. Reduce mold temperature. Reduce process temperature. Texture mold surface for better release. Increase size of pins. Increase draft on part. Reduce wall section. Use a compound with mold release. Use a harder compound.
<b>BURNT SMELL</b> Parts have a yellow cast	Degraded material.	Purge machine and observe whether problem reoccurs. Reduce process temperature. (Particularly in rear of machine). Reduce regrind level. Reduce residence time. Purge machine after shutdown. Move to a smaller machine. Reduce hot runner system temperatures. Minimize dead spots in hot runner manifold.
<b>PART STICKS IN "A" HALF or STATIONARY SIDE OF THE TOOL</b>	Insufficient extraction force.	Sandblast "A" side of tool. Polish "B" side. Run "A" side cooler. Put keepers in "B" half of tool. Increase draft on part in "A" half of tool.
<b>PART STICKS DURING EJECTION</b>	Insufficient ejection force.	Increase mold closed time. Reduce mold temperature. Reduce process temperature. Reduce pack and hold pressure. Sandblast "B" side. Increase size of ejector pins. Increase number of ejector pins. Increase draft on part. Provide air assist.
<b>NON-UNIFORM COLOR</b>	Poor dispersion.  Contamination.	Increase back pressure and/or screw rpm. Change the color concentrate carrier to a material with a lower melt temperature.  Check for clean regrind.

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