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4. INJECTION MOLDING ANALYSIS REPORT FOR AIR VENT BEZEL

Cool, fill, pack and warp analysis is done to study and optimize filling, packing and warpage characteristics of the part with PC+ABS, Bayblend T65 XF, Bayer material science.

Flow rate (cc/s) : 10 V/P Switchover (%) : 99 Pack time (sec) : 5 Cooling time (sec) : 20 Mold Open/Close time (sec) : 5

4.1 Process Parameters used

Following parameters are used for analysis [5] Mold temperature used (0 C) : 70 Melt temperature used (0 C) : 260

4.2 Feed System Details

The feed system for feeding the mold is oblong sub gate with sprue is used

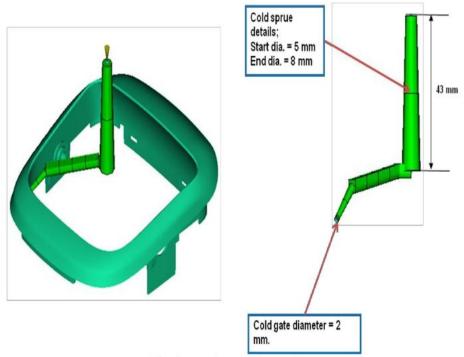


Fig -2: Location of oblong sub gate

4.3 Cool Analysis Results

The circuit for cooling the mold is important to maintain temperature inside the mold. The analysis results of cooling are as follows [2]

Table -1: Cool analysis results

Coolant inlet temp	Coolant outlet temp	Increase in temperature observed
70°C	70.2°C	0.2°C.

(Increased within recommended temp. of 3°C)

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