



Compression Molding Startup Procedure for BMC Polyester Molding Compounds

Prior to setting a mold into a press, it is necessary to first determine that the mold will fit in between the tie bars of the intended press. Once this is determined and before installation begins, the minimum clamp tonnage for the mold must be calculated. A couple reasons for the need to determine proper clamp tonnage are:

- Insufficient clamping force may lead to parts having unacceptable dimensions such as being too thick because the press may not have sufficient clamp force to force the material throughout the cavity(s).
- Potential mold damage from installing a mold that is too small for a press. Example: A mold that requires only 75T of clamp force is installed into a 400T press with non-adjustable clamp force may be damaged from too high of clamp pressure.

To determine the correct tonnage, multiply the projected area of the part at the parting line by 4,000-6,000 psi (27.6 – 41.4 MPa.).

Example: A part having a 12” diameter requires a minimum clamp pressure of 226T (2T/in²)

This can be calculated from the following formula:

$$\text{Clamp tonnage required} = r^2 * \pi * T/\text{in}^2$$
$$6''^2 * 3.1416 * 2(T/\text{in}^2) = 226 \text{ tons of clamp pressure}$$

Once a mold has been matched with a press and is installed in that press, a standard procedure should be followed to begin molding parts. Following a written procedure each time a mold is installed makes it easier for the press operators by helping to minimize the omission of any procedural steps. After the mold is set the following startup procedure can be implemented.

1. Turn on the heat and frequently check the temperature of the molding surfaces with a calibrated pyrometer and surface probe. It is desirable to have as little temperature variance (typically within 10F) across the mold surface as possible. Typical start up **mold temperatures** are:

290°F - 340°F (143°C - 171°C) for most BMC molding compounds

2. Just prior to charging the cavities with material for the first shot the mold should be **completely waxed**. Carnauba wax works well for this purpose. To wax a mold, melt the

wax on the molding surface and with the aid of a small natural bristle paintbrush, spread it over the entire molding surface, getting it into every pocket and corner. Remove any excess wax from the mold surface and begin to mold parts before the wax has a chance to burn on the tool surface.

3. The molding parameters should be adjusted to produce good parts from all cavities, each shot. Typically, the mold close time should be 3 - 6 seconds. All process parameters should be documented for future startups

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This information is suggested as a guide to those interested in processing Plenco Thermoset molding materials. The information presented is for your evaluation and may or may not be compatible for all mold designs, press configurations, and material rheology. Please feel free to call Plenco with any questions about PLENCO molding materials or processing and a Technical Service Representative will assist you.