

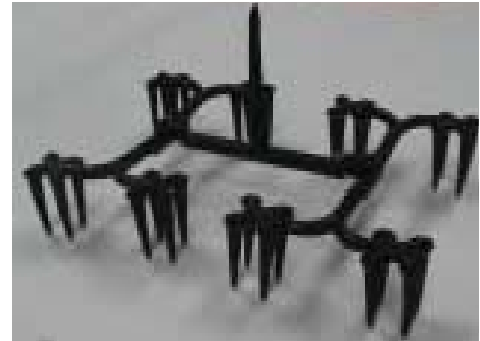
MeltFlipper® Case Study

Customer: **LORD**

Case Study: Reducing variation in a multi- cavity mold producing a thermoset rubber nitrile part.

The MeltFlipper® technology not only applies to thermoplastics, but also to thermoset materials. The following case study shows the results of an 8-cavity runner system molding a rubber nitrile dampening part. The parts were being fed with multiple gates per part (Figure 1).

The results of the imbalance study are given in Figures 2A-2C. By comparing the results of the imbalance, it can be seen that the imbalance was reduced from 17.5% without the MeltFlipper technology to less than 2.5% with the technology. This greatly reduced the variations from cavity-to-cavity along with the amount of flash being seen on the inside cavities.



Numbering Layout

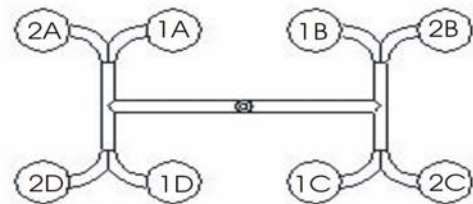


Figure 1: Top - Actual runner layout of the 8 cavity tool

Bottom - Runner layout as labeled in 5 Step

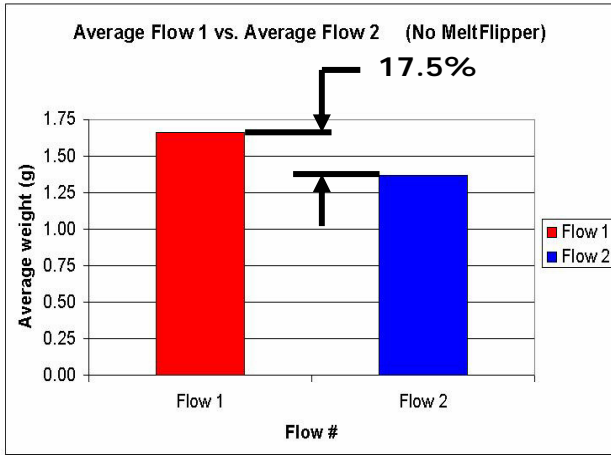


Figure 2A: Percent imbalance before MeltFlipper

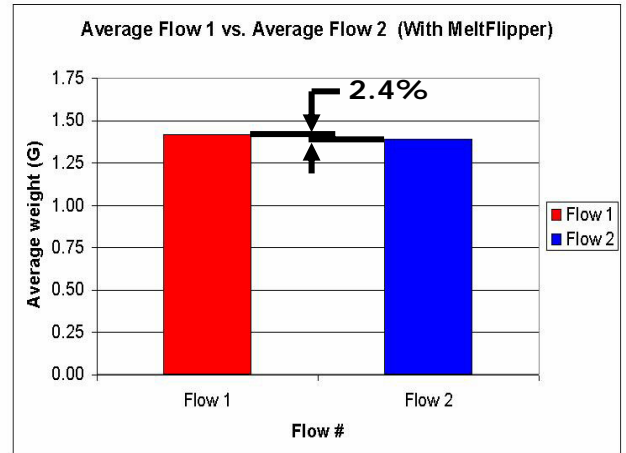


Figure 2B: Percent imbalance with MeltFlipper

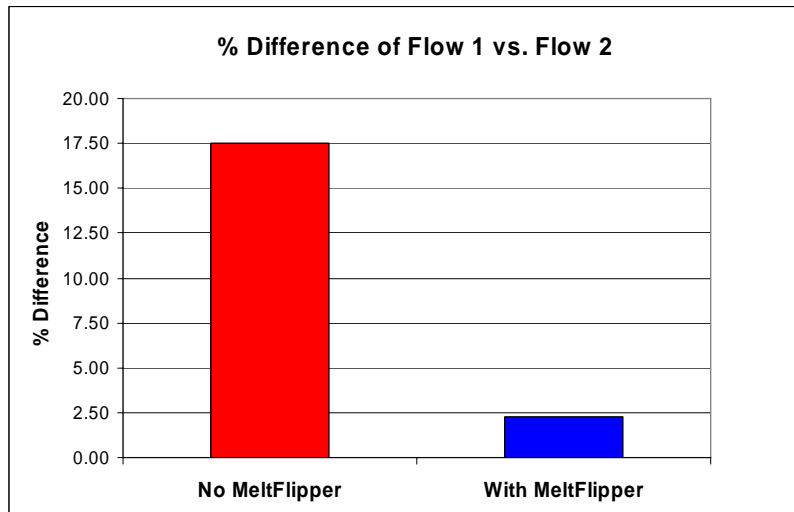


Figure 2C: Percent difference with and without MeltFlipper