TELENE SAS
4, Rue Marie Curie
59910 Bondues - France
www.telene.com
info@telene.com

Information requested to perform a mould design check

Ref : VA – WM – 2015/02

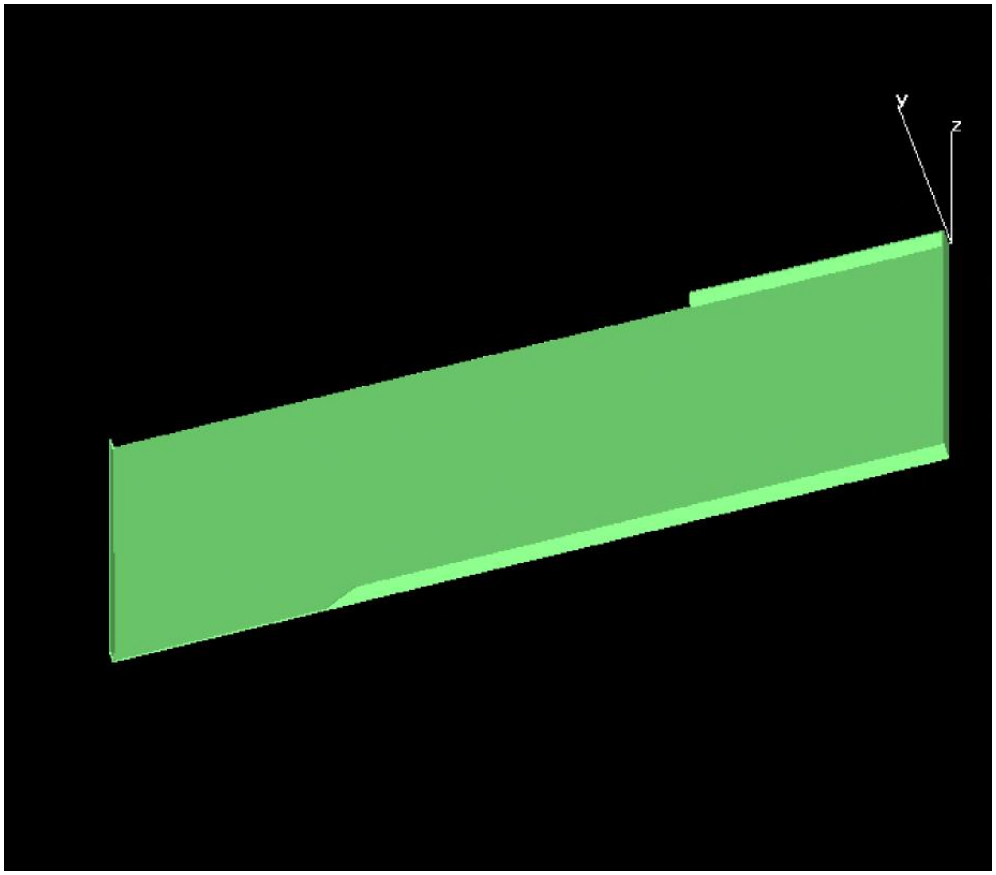
- A mould design check will give converter/designer or mould maker an opportunity to have their design reviewed by the Telene SAS Technical team against the general rules used in processing Telene® parts.
- The assessment will only cover the aspect linked to Telene® filling flow, gate design and location, flash, gaskets and reservoirs design.

Input data

All data should be sent as a 3D IGS extension file, the most classical one. All files linked to the same tool check should be sent in the same origin and reference system.

1. Part geometry

Even if the part geometry has been previously sent to Telene SAS, it is good practice to check that indeed Telene® has received the version used when starting to design the tool.



Print out of a 3D part to be molded in Telene®

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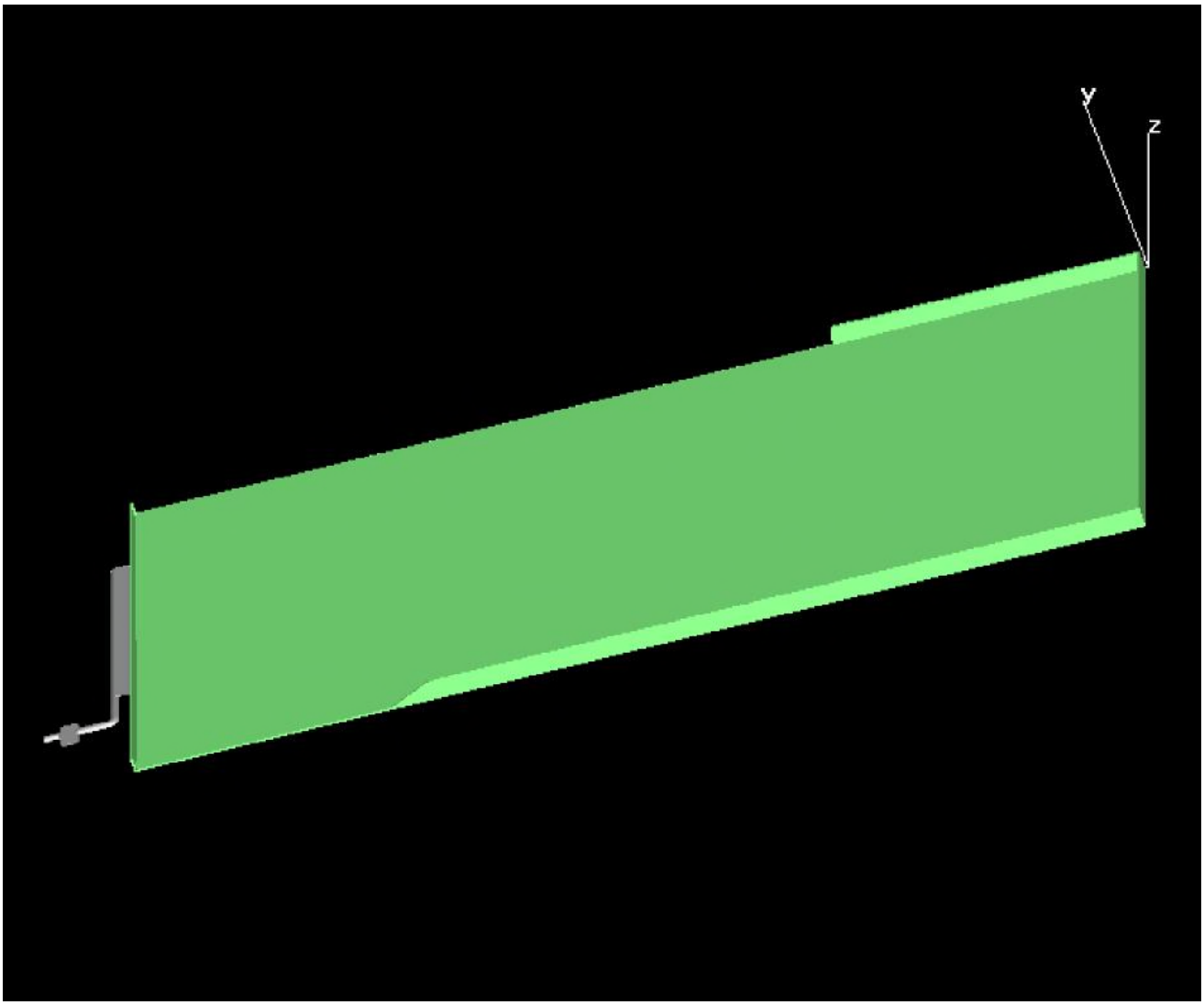
2. Gate geometry

3D gate file will allow to check its location and to anticipate filling issues. Gate location being a compromise between part shape, cosmetics and press/injection unit constrain, thanks to indicate possible limitations. Foreseen tilting angle is also of importance when considering gate location.



Part geometry and gate geometry assembled in the same reference system

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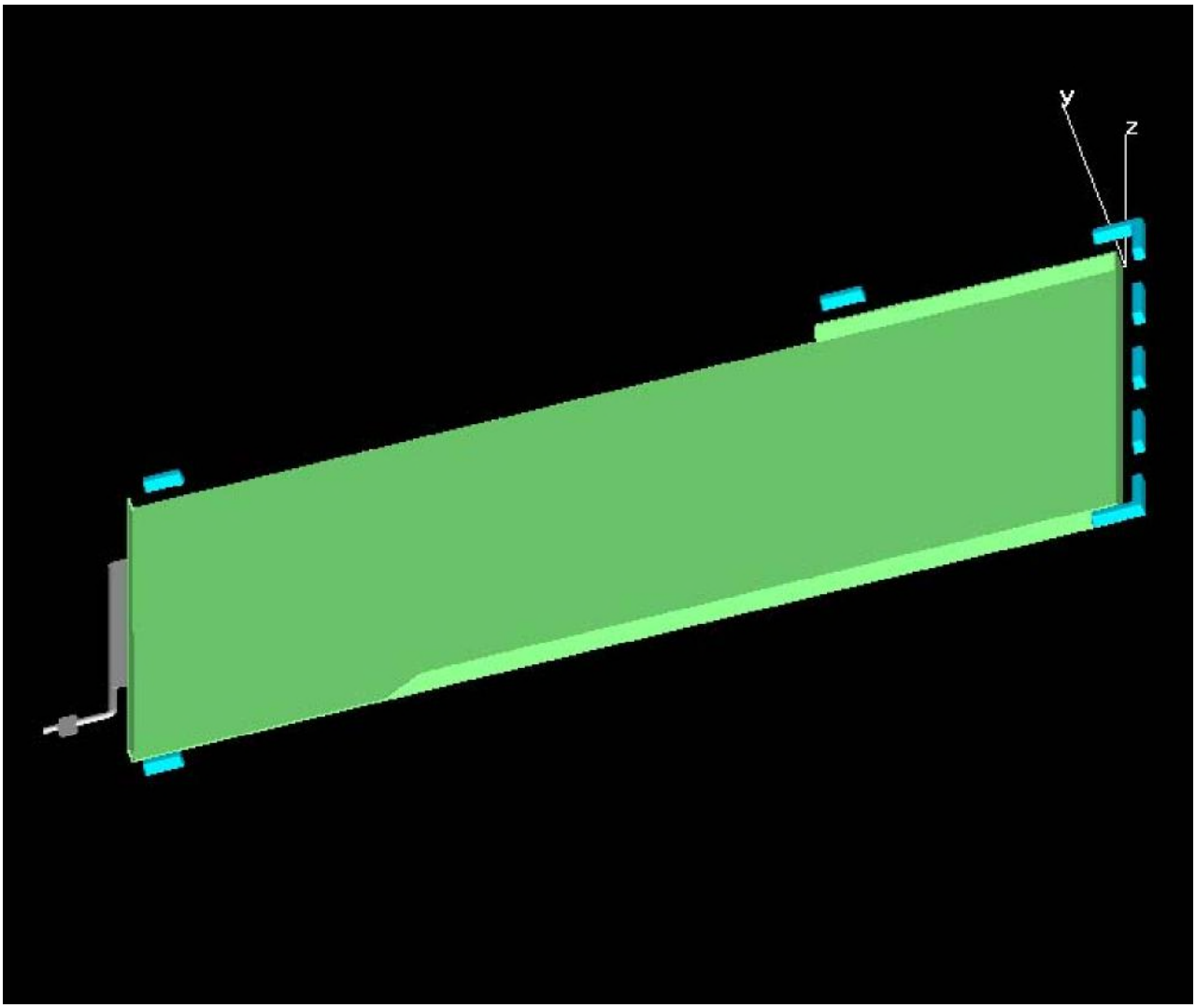
3. Reservoirs

Reservoir locations are located in places where one wants to collect extra material coming through the vents. In some cases the vents are connected to the outside by using a self-relief valve. Please mention it if it is the case.



Part, gate and reservoirs geometry assembled in the same reference system

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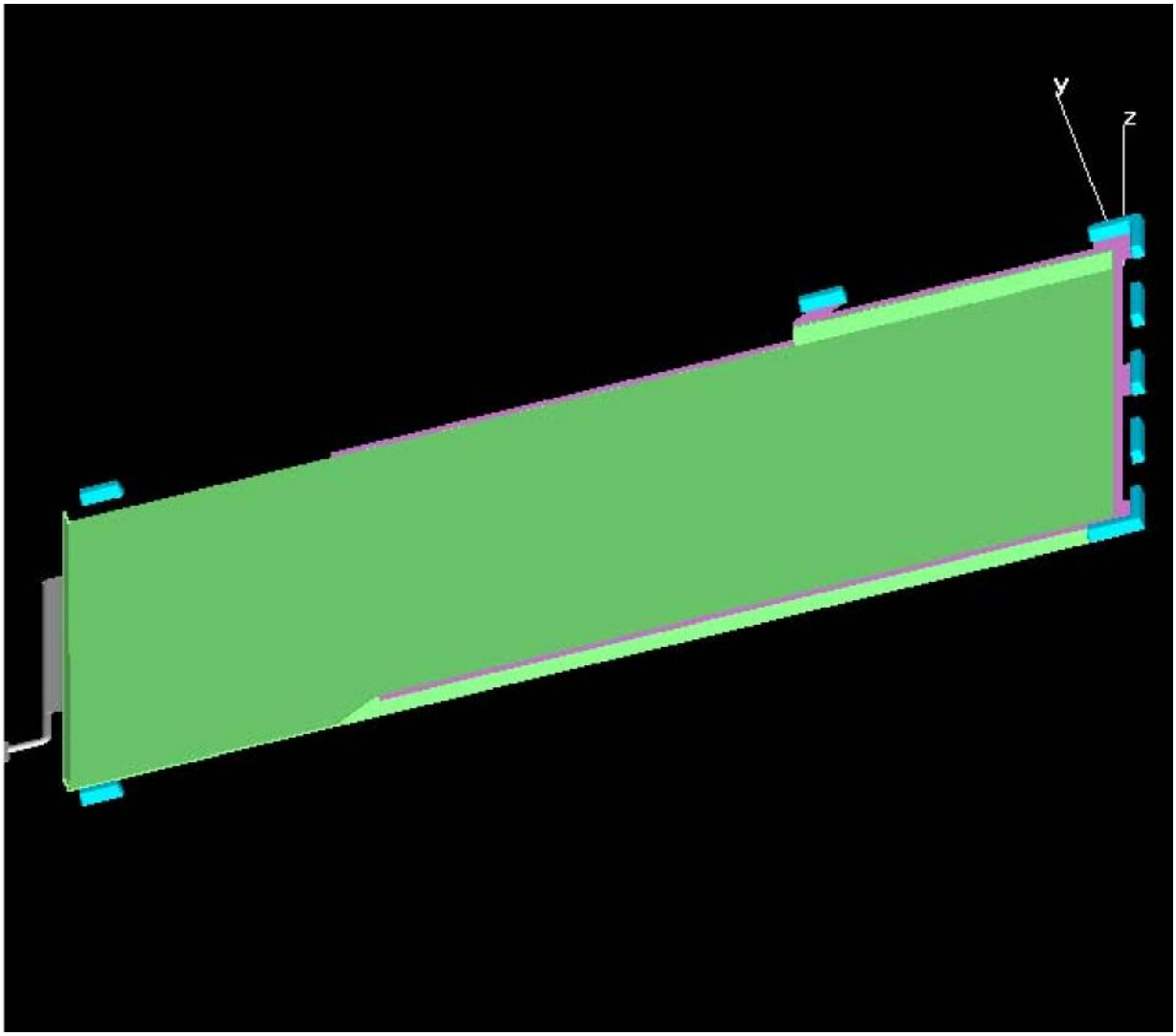
4. Flash

In Telene® molding process the flash design is an important parameter impacting the time needed to finish the part, as well as mould cleaning time between shots. Thanks to mention if you plan to use automated trimming equipment when sending your files



Part, gate, reservoirs and flash geometry assembled in the same reference system

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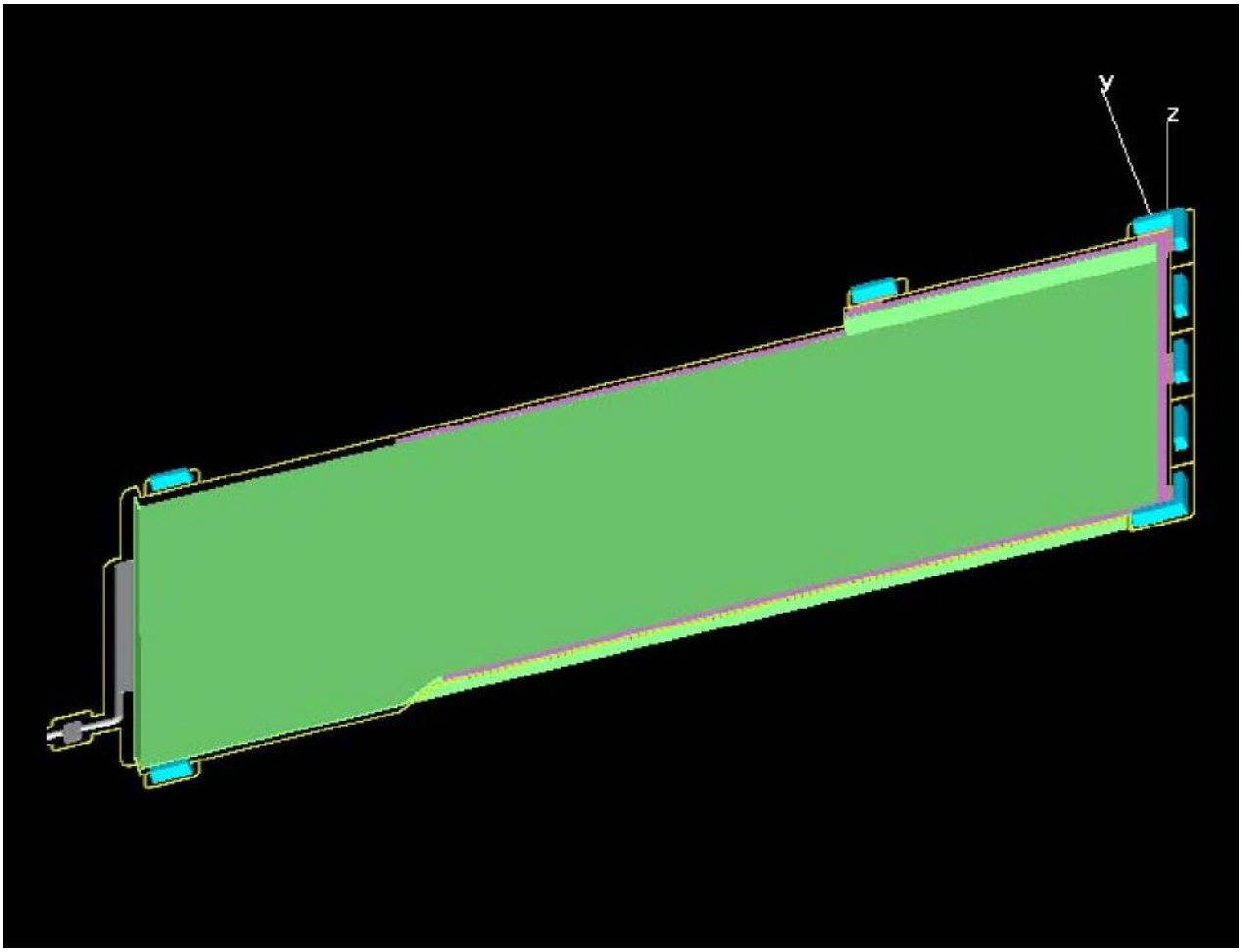
5. Gasket

Correct gasketing will prevent material leak, help to build up back pressure in the tool thus reducing the porosity level and ensure reduced DCPD emission in the press enclosure. Note that the mix head should be included in the gasket system to prevent air sucking (Not represented on the figure below)



Part, gate and reservoirs, flash and gasket geometry assembled in the same reference system