Design and manufacturing of plastic injection mould

04 – Mould bases

Standard mould elements
- Standard parts
- Finished, but it can be manufactured
- Cost effective
- Make or buy
- Different geometry (dep. on supplier)

Suppliers

- SANKIO
- FCPK
- BYTOW
- RABOURDIN
- EOC
- D-ME
- HASCO
- PROGRESSIVE COMPONENTS
- CUMSA
Build up of mould base

- 2 plates mould base
- 3 plates mould base
  - Support plate
  - Stripper plate
  - Split state half
- Hot runner mould base
- Split mould kit
- Replaceable insert mould base

Combined riser and clamp plate

- Less part
- Simple assembly
- Longer manufacturing time

Mould plates

Size: 96x96 – 996x996

Requirements:
- Hardness, Tensile stress
- Accuracy
- Surface roughness (grind)

Round mould plates

Hole for craning (lifting) 10 kg
- Asymmetric position

- Hole for guide pillar
- Hole for screw
- Shoulder for disassembly 15-25x45°, 4-10 mm depth

Mould plates

- Size: 96x96 – 996x996
- Requirements:
  - Hardness, Tensile stress
  - Accuracy
  - Surface roughness (grind)
Core and cavity

- Inserted
- One piece (solid)

Insert holder plate

Positioning

Cavity holder plate
Insert
Straight pin
Screw

Positioning

Cavity holder plate (frame)
Insert
Support plate

Support plate

Part
Support plate
Decrease the deformation

Support pillar

Anchor to the clamp plate by screw
3 plate mould base

- Runner and sprue waste
- Part

Stripper plate

- Part
- Stripper plate

Hot runner mould base

- Manifold plate
- Part

Manifold plate

1)  
2)  
3)  

Split mould kit

- Info DME-Standard

Split mould kit
Replaceable insert mould base

- Low amount of part
- Similar parts
- Same ejection point
- No ejection system
- Replaceable ejection system