

Forming Technology Reaction Injection Molding

Reaction injection molding (RIM) includes cold cure foam molding. Both processes are used to shape thermosetting foam by injecting thermosetting polyurethane resin (PUR) into a mold, where it reacts to form a foamed or solid part.

Code:	Typical applications:	Advantages:
<ul style="list-style-type: none"> • Cold cure foam molding • Hot cure foam molding 	<ul style="list-style-type: none"> • Complex • Flexible • Large part volume 	<ul style="list-style-type: none"> • Good surface finish
Code:	Other processes:	Notes:
<ul style="list-style-type: none"> • Hot cure foam molding • Hot cure foam molding 	<ul style="list-style-type: none"> • Cold curing • Hot curing • Hot curing 	<ul style="list-style-type: none"> • Good surface finish • Good surface finish

INTRODUCTION
There are two process cold cure processes. Cold cure foam molding is generally attributed to molding hot foam for upholstery and sports equipment, whereas RIM covers molding all types of RIM including foam. In both processes, the density and structure of RIM are chosen to suit the application.

As well as low modulus and high volume production, this process is commonly used to produce parts that will be injection molded (see 30) because the foaming is much less expensive than for injection molding, while repeatability and accuracy are high.

TYPICAL APPLICATIONS
Popular uses include domestic and commercial furniture such as chairs, car seats and airplane seats, armrests and cushions. These processes are also suitable for cushioning functions in footwear, such as in the soles, and for safety and flexibility in toys.

RIM is chosen a great deal in the automotive industry for products such as bumpers, under bonnet applications and car interiors. It is utilized in the medical and aerospace industries for niche products and low volume production runs, too.

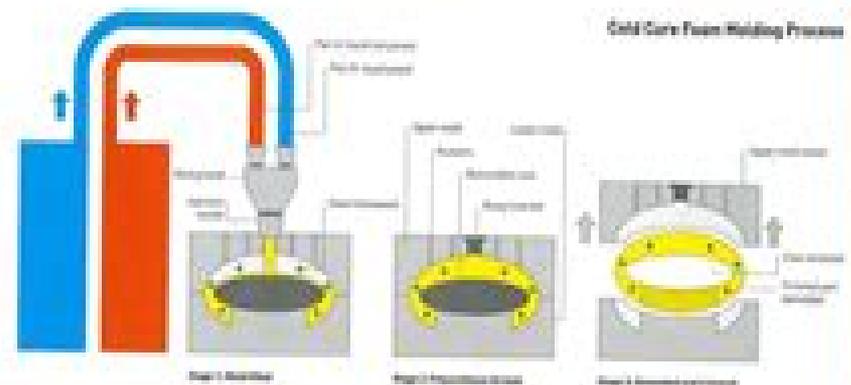
RELATED PROCESSES
Bulk foam geometries are also formed by CNC machining (page 48) or foam fabrication. The technique is often utilized to cover wooden structures in upholstery (page 34). Foam molding is becoming more widely used, for example, in the production of furniture and car seats – new formulations of PUR foam producing lower temperatures, so they are therefore less toxic.

Vacuum casting (page 45) is used to form similar geometries in PUR, but is typically applied to smaller and more complex shapes. Vacuum casting and RIM are chosen to prototype and manufacture low volume. The

properties of the part are similar to injection molding.

QUALITY
The quality of the surface finish is determined by the surface of the mold. The coating can be produced in glass reinforced plastic (GRP), steel or alloyed steel. Even though this is a low pressure process, the liquid PUR reproduces the surface texture and details very well.

DESIGN OPPORTUNITIES
This is an extremely versatile process as the mechanical properties of the cured PUR can be designed to suit the application. The flexibility of foam can range from semi rigid to very rigid, and the density can be adjusted from 0.1 g/cc to 1.0 g/cc (from 10 to 100 lb/ft³). The outer skin and inner foam can have contrasting properties to form parts with a rigid skin and lightweight foam core, for example. RIM is similar to injection molding parts can be textured and the surface



TECHNICAL DESCRIPTION
In stage 1, the resin and isocyanate and a blowing agent is applied. Isocyanate and blowing agent are then put into glass and the resin is changed into. The 2 ingredients that react to form PUR are placed in separate containers. The paper and isocyanate are fed into the mixing head, where they are combined at high pressure. The accelerated expansion of liquid chemical are dispersed into the mold at a low pressure. As they are mixed they begin to go through a chemical exothermic reaction to create PUR.
During stage 2 the polymer begins to expand to fill the mold. The only pressure in the mold is from the expanding liquid, so molds have to be designed and fitted to ensure some amount of the polymer can be held in the liquid state. As the polymer expands the pressure within is equal to its weight. If long is injected in the gate to maintain internal pressure in the mold.
In stage 3, the product is demoulded after 5-10 minutes. The part can then vary according to the size and complexity of the part. The upper and lower surfaces of the mold are separated and the spray are removed. The part is then cleaned and prepared for the next cycle.



Note: Exothermic reaction of liquid resin isocyanate is dispersed into the mold to go through the chemical process.



Note: The finished part will be used to form lightweight and flexible foam. The reaction of long isocyanate liquid resin can be controlled by temperature and time.

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JR Anderson



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