

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: 1. Cold cure foam molding 2. Cold cure foam molding	Typical operations: 1. Injection 2. Curing 3. Ejecting parts	Advantages: 1. Good surface finish
Code: 1. Hot cure foam molding 2. Hot cure foam molding	Other processes: 1. Cold molding 2. Hot molding 3. Hot molding	Notes: 1. Good surface finish 2. Good surface finish

INTRODUCTION
 These are low pressure, 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 PUR 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 tooling 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.

It is common to design a part 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.

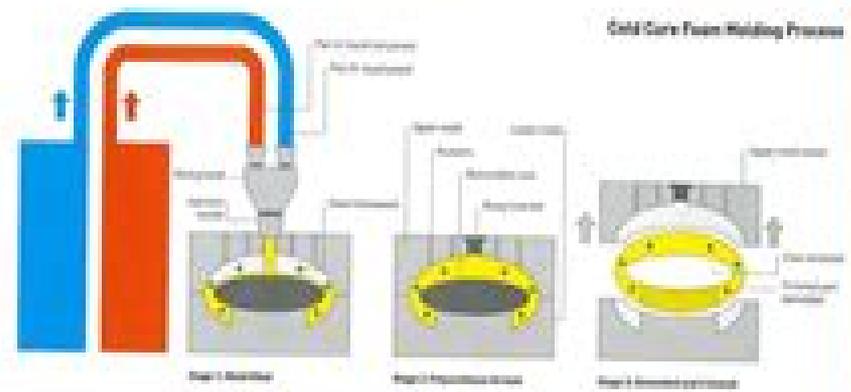
RELATED PROCESSES
 Bulk foam geometries are also formed by CNC machining (page 49) or foam fabrication. This technique is often utilized to cover wooden structures in upholstery (page 34). Foam molding is becoming more widely used, for example, in the production of furniture and car seats – new formulations of PUR foam producing lower temperatures, so they are therefore less toxic. Vacuum casting (page 47) 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 volumes. 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 tooling can be produced in high reinforced plastics (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/cm³ to 1.2 g/cm³ (1.25 to 1.45). 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 mould part is cleaned and a release agent is applied. Inlets and channels are then put into place and the mold is cleaned out. The 2 ingredients that react to form PUR are placed in separate containers. The paper and chemicals are fed into the mixing head, where they are combined at high pressure. The accelerated expansion of liquid chemicals 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 spread of the polymer when it is still in its liquid state. As the polymer expands the pressure within is raised so to ensure it does not contract in the gaps to maintain internal pressure in the mold. In stage 3, the product is demoulded after 5-10 minutes. The part cycle times vary according to the size and complexity of the part. The upper and lower surfaces of the mold are separated and the cores are removed. The mold is then cleaned and prepared for the next cycle.



Notes:
 1. Exothermic reaction of liquid reactants is dispersed into the mold by the accelerating the reaction process.



Notes:
 The PUR foam will contract to form lightweight and flexible foam. The reaction time is controlled by the reaction time. Exothermic reaction is controlled by the exothermic reaction.

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