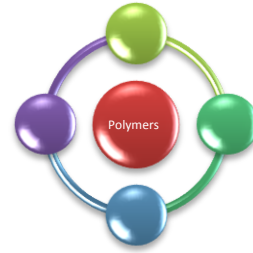




## Technical Reference Bulletin Compression Molding



Compression molding is the most basic process of the three methods used to mold silicone or other elastomer parts.

	<p><i>This photo shows a two cavity tool used to create a rectangular gasket.</i></p>	<h3>Advantages</h3> <ul style="list-style-type: none"> <li>■ Least Expensive Tooling</li> <li>■ Eliminates Transfer Pot</li> <li>■ Very Little Material Waste</li> <li>■ Good For Most Part Sizes</li> </ul> <h3>Disadvantages</h3> <ul style="list-style-type: none"> <li>■ Requires Precision “Pre-form” Placement</li> <li>■ Pre-form Weight Is Critical</li> <li>■ Flash Control Is Difficult</li> <li>■ Part consistency can be troublesome if weight and placement are not consistent.</li> </ul>
	<p><i>A “pre-form” of specific weight and shape is positioned in each cavity. The mold is closed and compressed in a heated press for a predetermined amount of time.</i></p>	
	<p><i>When the mold is opened, the part is removed. Excess rubber called “flash” is removed from the mold and trimmed from the part mechanically or in a cryogenic deflashing unit using liquid nitrogen.</i></p>	