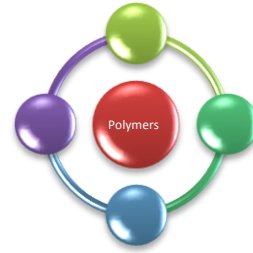
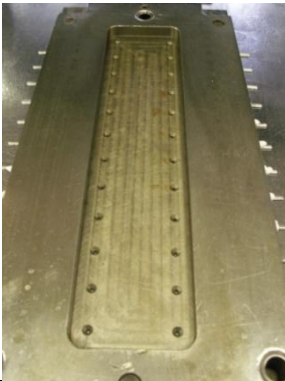





Technical Reference Bulletin Transfer Molding

Transfer molding uses a “plunger and cylinder” delivery system to control the flow of the elastomer through small holes or “sprues” located in the middle transfer plate.



| | | |
|---|---|---|
|  | <p><i>This photo shows the middle transfer section or the “pot” with the small holes or “sprues”</i></p> | <h3 style="margin: 0;">Advantages</h3> <ul style="list-style-type: none"> ■ Closer Dimensional Control is Achievable. ■ Superior Method For Rubber to Metal Bonding. ■ Unit Production Cost Are Lower Due To Shorter Cure Times. <h3 style="margin: 0;">Disadvantages</h3> <ul style="list-style-type: none"> ■ Transfer Pot Yields Higher Scrap. ■ Tooling Investment Can Be Slightly Higher Due To Required Transfer Plate. |
|  | <p><i>A “pre-form” of specific weight and shape is positioned into the transfer pot. 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 excess rubber called “flash” is removed from the transfer pot and thrown away. The resulting part is de-flashed mechanically or in a cryogenic de-flashing unit using liquid nitrogen.</i></p> | |