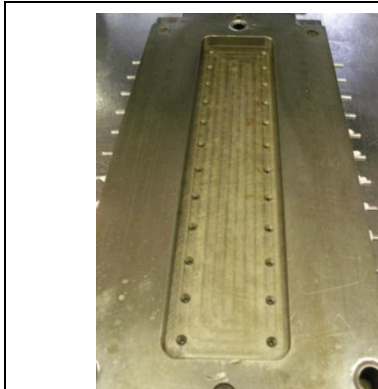
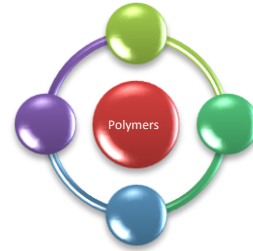


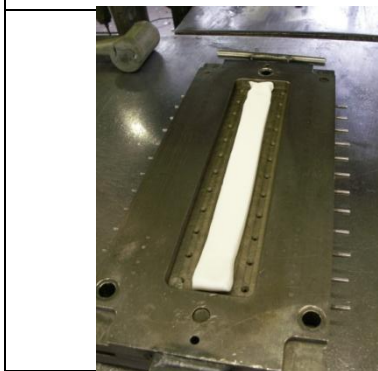


Technical Reference Bulletin Transfer Molding

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.



This photo shows the middle transfer section or the “pot” with the small holes or “sprues”



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.



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.

Advantages

- Closer Dimensional Control is Achievable.
- Superior Method For Rubber to Metal Bonding.
- Unit Production Cost Are Lower Due To Shorter Cure Times.

Disadvantages

- Transfer Pot Yields Higher Scrap.
- Tooling Investment Can Be Slightly Higher Due To Required Transfer Plate.