

**Device And Method For Producing Thick-Walled Plastic Molded Parts
Having Reduced Shrinkage Sites By Injection Molding Or Embossing**

Abstract

The invention relates to a device and method for producing thick-walled plastic molded parts by injection molding or embossing. The device comprises a mold for injection molding or embossing, having a cavity, and is characterized in that the mold comprises a wall region adjacent to the cavity, and a body removed from the cavity and adjacent to the wall region near the cavity, wherein the body of the mold is designed for a temperature T_1 and the wall region is designed for a temperature T_2 different from the temperature T_1 . According to the method, the temperature T_2 of the wall region of the mold near the cavity is brought to and held at a value greater than the Vicat temperature T_v of the plastic molding mass before and/or during the injection process, wherein the temperature T_2 is greater than the temperature T_1 of the mold body, and the temperature T_2 of the wall region near the cavity is brought to a temperature below the Vicat temperature T_v of the plastic molding mass during the solidification of the plastic molding mass. The result is thick-walled molded plastic parts, such as optical lenses and the like, having reduced shrinkage sites.

(Figure 2)