

- 1 -

REPLACED SHEETS		SG
☒	Description : paged to paged 14	
☐	Claim(s) : paged to paged	
☐	Drawing(s) : paged to paged	
☒	Abstract : paged to paged 1	
DATE OF RECEIPT		

INJECTION MOLDING METHOD

1 BACKGROUND OF THE INVENTION

Field of the Invention:

The present invention relates to an injection molding method for molding an article by means of an

5 injection molding machine.

Description of the Related Art:

Conventional injection molding method adopts such a control as to reduce the injection speed immediately before the mold cavity is filled up and to

10 switch the pressure from the injection pressure to the dwell pressure in response to a signal indicative of the filling up of the mold cavity. Such signals indicative of the filling up of the mold cavity is, for example, a signal indicative of the screw position, a signal

15 indicative of the injection load pressure, a signal indicative of the internal pressure of the runner or cavity or a signal representing the degree of opening of the mold. Alternatively, the injection pressure is adjusted in accordance with the degree of opening of the

20 mold in the dwell pressure application stage of the molding process. Thus, the control of the injection pressure has been done based upon a single factor, although the resin exhibits a complicated behavior

25 immediately before and after the filling up of the mold

1 cavity. Consequently, it has been impossible to simultaneously eliminate defects such as burrs, short shot and sink marks to a satisfactory level.

Referring to Fig. 2, the conventional injection molding method essentially required a wait time in which the filling is continued at a very small rate (low-speed filling mode) under a pressure which is low enough to avoid generation of burrs (see Fig. 4) until the gases in the gas space 11 in the mold cavity 6 are completely replaced with the resin. It is also to be understood that a too early reduction of the pressure from the primary injection pressure or a too early switching to the low-speed filling mode) tends to cause a short shot due to increase in the viscosity of the resin at the thin-walled portion 12. In other words, it is not allowed to conduct the reduction in the injection pressure or switching to the low-speed filling mode too early before the filling up of the mold cavity.

When the mold has a plurality of mold cavities as shown in Fig. 3, there may remain a cavity or cavities 6a experiencing a short shot 13 even after other cavities 6a have been filled up. A long wait time is required until the short shot in each such cavity or cavities 6a is completely filled, because such filling has to be done at a pressure low enough to avoid generation of burrs in the cavities 6a which have been completely filled.

Referring to Figs. 1, 2 and 4, when the mold cavity has been completely filled, the resin has been

1 compressed so that the resin tends to flow back towards
the screw 16, as indicated by arrows in Fig. 4. In other
words, a reaction force is applied to the screw 16. This
phenomenon is often observed when the mode has been
5 switched to the dwell pressure mode. Such reversing of
the resin, once it has occurred, makes it difficult to
completely fill thin-wall portions of the mold cavity and
tends to cause defects such as short shot 13 or sink mark
14. It is therefore necessary to take suitable measure
10 for preventing reverse flow of the resin which is allowed
by backward movement of the screw 16.

Fig. 4 shows the state of the resin which has
filled up the mold cavity but no shell or solidified
surface layer has been formed yet at the resin surface.
15 contacting the mold wall, while Fig. 5 shows the state in
which the solidified surface layer 10 has been formed.
The solidified surface layer 10 starts to be produced
from 0.1 to 0.2 second after the state shown in Fig. 4
has been attained. Therefore, possible degree packing,
20 i.e., degree of press-filling, of the resin increases in
accordance with the increase in the thickness of the
solidified surface layer 10.

SUMMARY OF THE INVENTION

Accordingly, an object of the present invention
25 is to provide a control method in which the resin
pressure is controlled based upon plural control factors.

This Sheet Has Been Replaced



1 or parameters in accordance with the demanded characteristic of the resin in the mold which varies time to time, so as to attain the greatest degree of pressing of the resin, while minimizing generation of
5 burrs on the molded article and diminishing the short shot.

To this end, according to the present invention, there is provided an injection molding method for molding an article by using an injection molding machine, in
10 which a plurality of control parameters including the injection speed, injection pressure and the mold opening degree are controlled, from a moment immediately before filling up of the mold cavity with the resin, setting the parameters in an order determined in accordance with the
15 characteristics demanded by the resin, such that, when the injection pressure is controlled as a commanding parameter, the injection speed is controlled as a subordinate parameter under a given restriction and, when the mold opening degree is controlled as the commanding
20 parameter, the injection pressure is controlled as a subordinate parameter under a given restriction.

The control is commenced after the values of one or more of the mold opening degree, screw position and injection pressure have reached predetermined values at a
25 moment immediately before the filling up of the mold cavity.

When the injection pressure is controlled as the commanding parameter, the mold opening degree is set to a



1 value which allows relief of gases but prohibits genera-
tion of a burr at the mold parting surface and, after the
mold opening degree has reached the set value, the
control is switched to a mode which controls, using the
5 set value of the mold opening degree as the control
command, the injection pressure as a subordinate
parameter under such a restriction that the injection
pressure falls within the range which does not allow
generation of local burr. Prior to a control of the
10 injection pressure as the commanding parameter, a control
is done to control the injection speed and, when a set
value of the injection pressure is reached, the control
is automatically switched to a mode in which the injec-
tion pressure is controlled while the injection speed is
15 controlled as a subordinate parameter such that the resin
does not flow backward or such that the absolute value of
the speed of backward flow of the resin is smaller than a
predetermined maximum allowable value.

According to another aspect of the present
20 invention, there is provided an injection molding method
for molding an article by using an injection molding
machine, comprising the steps of: commencing, immediately
before filling up of the mold cavity with a resin, a
control of the injection speed to follow a set value V_0 of
25 the injection speed, starting at a control start point
which is determined by a set value or values of one or
more of control parameters including mold opening degree,
screw position and the injection pressure; conducting



- 1 control of the injection pressure such that the injection pressure is set to a value represented by a set function $P = F(t)$ which provides the maximum injection pressure within a range which does not allow generation of burr
- 5 and, after the actual injection pressure has been reached the value represented by the set function $P = F(t)$, such that the injection pressure varies in conformity with the set function $P = F(t)$, while restricting the injection speed to a range which does not allow backward flow of
- 10 the resin or does not cause the absolute value of backward flow speed of resin to exceed a predetermined maximum allowable value, and setting a command mold opening degree to such a value that allows relief of gases but does not allow generation of burr at the mold
- 15 parting surface; and after the command value of the mold opening degree has been reached, switching the control to a mode in which the injection pressure is controlled so as to maintain the mold opening degree in conformity with the command value, wherein the injection pressure is
- 20 restricted to a range which does not cause generation of burrs.

These and other objects, features and advantages of the present invention will become clear from the following description which will be taken in conjunction

25 with the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a sectional view of an example of a



1 mold employed in an injection molding machine to which
the present invention is applied;

Fig. 2 is a sectional view illustrative of the
state of the resin in the mold cavity;

5 Fig. 3 is a sectional view illustrative of the
state of the resin in a mold having a plurality of mold
cavities;

Fig. 4 is a sectional view illustrative of the
state of the resin in a mold cavity showing the manner in
10 which burrs are generated;

Fig. 5 is a sectional view illustrative of the
state in which a solidified surface layer has been formed
on the resin in the mold cavity; and

Fig. 6 is a diagram showing how the injection
15 pressure, injection speed and the degree of opening of
the mold are changed in relation to time.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

Referring to Fig. 1, a molten resin is charged
through a nozzle 1 into a mold cavity 6 in a mold 1 via a
20 sprue 3, runner 4 and gates 6 so as to fill the mold
cavity 6. When the mold cavity 6 has been filled almost
fully, the mold 1 slightly urged backward in the opening
direction apart from a mating mold part tending to form a
minute gap at the parting surface 7. The amount of this
25 backward movement will be referred to as "degree of
opening" of the mold. The degree of opening of the mold
is detected by a dial gauge attached to the mold 1 by



1 means of a magnet 8, and is transmitted by a transmitter
on the dial gauge 9.

Referring now to Fig. 6, a mold opening degree
is set as at 17 as a criterion for determination as to
5 whether the cavity 6 has been filled near fully. This
set level 17 of the mold opening degree may be replaced
with the injection load pressure or the screw position.
When this set level of the mold opening degree has been
reached, a control is set so as to control the following
10 three factors or parameters:

- A) Injection speed (This parameter may be
programmed, although it is fixed in the illustrated
embodiment.)
- 15 B) Injection pressure (This parameter may be
programmed, although it is fixed in the illustrated
embodiment. In the case of an electric injection molding
machine, current value or the motor torque may be used in
place of the injection pressure.)
- 20 C) Degree of mold opening (This parameter may be
programmed, although it is fixed in the illustrated
embodiment.)

Referring to Fig. 6, when the degree of mold
opening has approached the set level 17 (5 to 10 μ in
case of an ABS resin) after the start of the injection,
25 the injection speed A_1 (10 mm/sec or so in case of ABS
resin) is feedback-controlled on the basis of the set
value of the injection speed. An increase in the load
resistance causes a rise in the injection pressure so



- 1 that the injection pressure reaches a set level P_1 (1400 atm in case of injection resin).

When this injection pressure is reached, a feedback control is conducted by using the injection
5 pressure as the commanding parameter, such that the injection pressure is controlled in accordance with a set function of $P = F(t)$, under the conditions of the following formula "S".

- 0 or set value - A_2 (3 mm/sec in case of ABS
10 resin)

$\leq$ injection speed $\leq$ set value $A_1 \dots S1$.

The maximum value P_{max} of the injection pressure is 2000 atm.

- The maximum allowable injection pressure
15 (pressure which is the highest within the range which does not cause generation of burrs) at a moment t_0 , immediately before the filling up of the mold cavity is represented by P_1 , while the maximum allowable injection pressure (pressure which is the highest within the range
20 which does not cause generation of burrs) at a moment at which the solidified surface layer is formed upon contact with the mold wall is expressed by P_2 . The present inventors have found that the pressure P_2 rises in accordance with an increase in the thickness of the
25 solidified surface layer and in accordance with an increase in the viscosity of the resin. In this embodiment, the pressure P_2 is changed linearly in accordance with a time value set in a timer 18, e.g., 0.3



1 second. Obviously, however, other function of time may be used for the control of the pressure. Anyway, the control should follow the curve of the function $P = F(t)$.

In this state, the injection speed naturally
5 falls within the range of the formula S1. Usually, the formula S1 has a value not smaller than 0. The value of this formula, however, may be lowered to a lower limit expressed by $-A_2$, particularly when the mold is so designed and constructed as to small effect in preventing
10 generation of burr. The pressure should not be reduced below this lower limit A_2 because a too large backward flowing speed increases the pumping effect on the resin. The maximum pressure P_{max} is set to 2000 atm.

An alarm is activated when the range of the
15 formula S1 is exceeded, except for the case of a surge, so that the instant shot is rejected as being defective. With this control, a waiting step is taken until the gases are expelled from the gas space 11 and until any short short 13 is completely eliminated, while avoiding
20 local generation of burrs.

When the local short shot 13 is completely eliminated, an external pressure acts so as to further open the mold 1 at the parting surface 7 (see Fig. 1). In this state, on conditions that the requirement of the
25 formula S1 and the requirement of the following formula S2 are simultaneously met, the injection pressure is controlled using the mold opening degree as the commanding parameter, such that mold opening degree



1 follows a set value C (30 μ in case of an ABS resin).

injection pressure $\leq$ set value Pmax of injection
pressure S_2 .

5 This set value C is determined to be a value
which is the greatest within a range which allows escape
of gas through the gap on the parting surface but does
not allow the resin leak therethrough. In this stage,
the thickness of the solidified surface layer 10 of the
resin contacting the surface of the mold cavity 5 is
10 still small. Consequently, the degree of possible
packing also is small because the thin solidified surface
layer of the resin may easily allow generation of burrs
when a large degree of packing is effected.

The solidified layer 10 becomes thicker as the
15 time elapses, so that the allowable mold opening degree
also is increased. In the illustrated embodiment, the
mold opening degree is directly set to C in view of time
lag incurred in the control for setting the injection
speed and the injection pressure. This value of the mold
20 opening degree C corresponds to the state at which the
solidified surface layer 10 is formed. It is thus
possible to precisely pack the resin with a degree which
is the greatest in the range which does not allow
generation of local burrs.

25 The solidification proceeds to reach the portion
near the gate 5 (see Fig. 1). In this state, the
injection pressure is no more transmitted to the resin
portion inside the cavity 6. Meanwhile, the resin is



1 continuously cooled. The resin constituting the thin-walled portion is primarily quenched and solidified, and this solidification proceeds while pulling or attracting the portion of the resin in the thick-walled portions
5 which are being cooled rather gently. Consequently, sink marks 14 are formed.

In order to suppress the generation of the sink marks, the mold clamping force acts to close the mold when the mold has been opened, thereby uniformly
10 compressing the resin in the mold cavity 6. To enable this operation, the control is conducted while setting the mold opening degree to the maximum value until the timer 19 counts up. If the gate seal occurs too early so that the time set in the timer 19 is too long (when ABS
15 resin is used, the time is set to 4 seconds, although the time varies according to the wall thickness), the mold opening degree becomes smaller than the set value C. Occurrence of such state is informed by a display or activation of an alarm. This function also contributes
20 to the setting of the timer 19. Any shot which has experienced such an abnormal condition is rejected, so that defective products are excluded. This function also contributes to proper setting of the mold clamping force. Obviously, it is possible to automatically correct the
25 mold clamping force, although such a control is omitted in the illustrated embodiment.

When the mold clamping force is too large, the required mold opening degree cannot be obtained even when

1 the injection pressure has been increased to the maximum
pressure. Such a condition is informed to the operator
through the display or the alarm, so that the operator
can readjust the mold clamping pressure. Such
5 readjustment of the mold clamping force may be done
automatically. Thus, according to the present
invention, it is possible to simultaneously obviate,
except for some special cases, the defects such as
generation of burrs, short shot and generation of sink
10 marks which are the common problem of this field of
industry.

The degree of mold opening can be measured
simply by a position detecting device such as a dial
gauge 9 which can easily be mounted on the mold by means
15 of a magnet 8 or the like fixing means, without requiring
any modification of the mold construction. Various
controls and computations described hereinbefore can be
realized without difficulty by using a general-purpose
computer program, so that details of such controls and
20 computations are not described in detail in this
specification.

For information, in case of ABS resin, the set
value of the mold opening degree is 5 to 10 μ for 20 to
35 μ and, in case of nylon, the set value of the mold
25 opening degree is 2 to 4 μ for 8 to 12 μ .

When the injection molding machine is driven
hydraulically, the control of injection speed is achieved
by varying the speed of the pump or tilt angle of the

1 swash plate, whereas, when the injection molding machine
is driven electrically, the injection speed is controlled
by varying the speed of the driving electric motor. The
control of the injection pressure is achieved by means of
5 a hydraulic pressure control valve when the injection
molding machine is driven electrically and by varying
electric current or motor torque control when the
injection molding machine is driven electrically.

As has been described, according to the present
10 invention, a plurality of parameters including at least
the injection speed, injection pressure and the mold
opening degree are controlled in conformity with the set
values starting at a moment which is immediately before
the filling up of the mold cavity with the resin, the
15 control being done in an order of the parameters
determined in accordance with the demanded character-
istics of the resin, such that the value of the
commanding parameter follows a set value while the value
of subordinate parameters meet predetermined conditions.
20 Consequently, the following advantages are brought about
by the present invention.

- 1) It is possible to simultaneously obviate defects
such as burrs, short shot and sink marks.
- 2) A gas relieving effect is achieved by a suitable
25 control of the mold re-opening degree.
- 3) It is possible to realize a rational molding
method with distinctive setting of control parameter
values.

WHAT IS CLAIMED IS:

1. An injection molding method for molding an article by using an injection molding machine, wherein a plurality of control parameters including the injection speed, injection pressure and the mold opening degree are controlled, from a moment immediately before filling up of the mold cavity with the resin, setting said parameters in an order determined in accordance with the characteristics demanded by the resin, such that, when the injection pressure is controlled as a commanding parameter, the injection speed is controlled as a subordinate parameter under a given restriction and, when the mold opening degree is controlled as the commanding parameter, the injection pressure is controlled as a subordinate parameter under a given restriction.
2. An injection molding method according to Claim 1, wherein the control is commenced after the values of one or more of the mold opening degree, screw position and injection pressure have reached predetermined values at a moment immediately before the filling up of the mold cavity.
3. An injection molding method according to Claim 1, wherein, when the injection pressure is controlled as the commanding parameter, the mold opening degree is set to a value which allows relief of gases but prohibits generation of a burr at the mold parting surface and, after the mold opening degree has reached the set value, the control is switched to a mode which controls, using



the set value of the mold opening degree as the control command, the injection pressure as a subordinate parameter under such a restriction that the injection pressure falls within the range which does not allow generation of local burr.

4. An injection molding method according to Claim 1, wherein, prior to a control of the injection pressure as the commanding parameter, a control is done to control the injection speed and, when a set value of the injection pressure is reached, the control is automatically switched to a mode in which the injection pressure is controlled while the injection speed is controlled as a subordinate parameter such that the resin does not flow backward or such that the absolute value of the speed of backward flow of the resin is smaller than a predetermined maximum allowable value.

5. An injection molding method for molding an article by using an injection molding machine, comprising the steps of:

commencing, immediately before filling up of the mold cavity with a resin, a control of the injection speed to follow a set value V_0 of the injection speed, starting at a control start point which is determined by a set value or values of one or more of control parameters including mold opening degree, screw position and the injection pressure;

conducting control of the injection pressure such that the injection pressure is set to a value



represented by a set function $P = F(t)$ which provides the maximum injection pressure within a range which does not allow generation of burr and, after the actual injection pressure has been reached the value represented by said set function $P = F(t)$, such that the injection pressure varies in conformity with said set function $P = F(t)$, while restricting the injection speed to a range which does not allow backward flow of the resin or does not cause the absolute value of backward flow speed of resin to exceed a predetermined maximum allowable value, and setting a command mold opening degree to such a value that allows relief of gases but does not allow generation of burr at the mold parting surface; and

after the command value of the mold opening degree has been reached, switching the control to a mode in which the injection pressure is controlled so as to maintain the mold opening degree in conformity with said command value, wherein the injection pressure is restricted to a range which does not cause generation of burrs.



FIG. 1

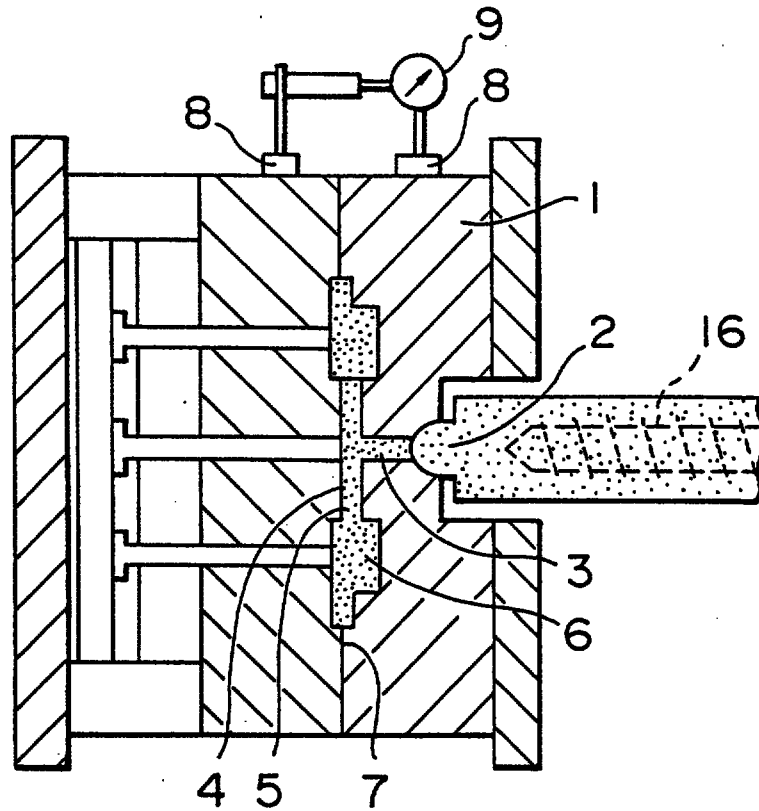


FIG. 2

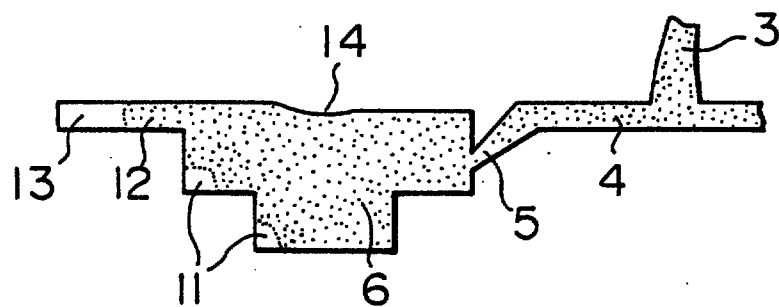


FIG. 3

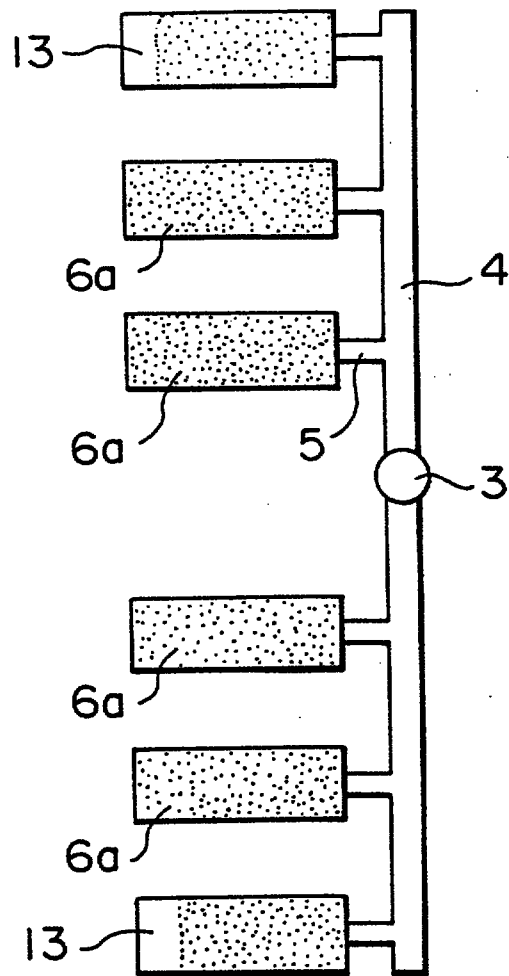


FIG. 4

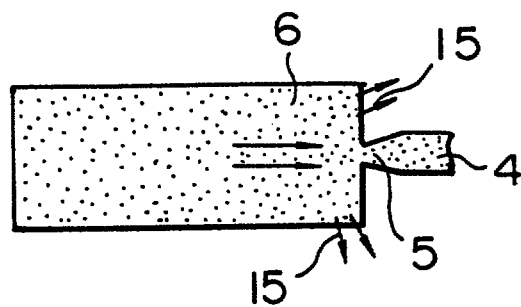


FIG. 5

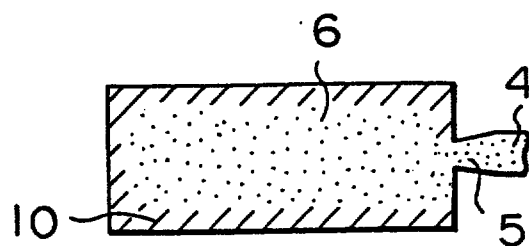
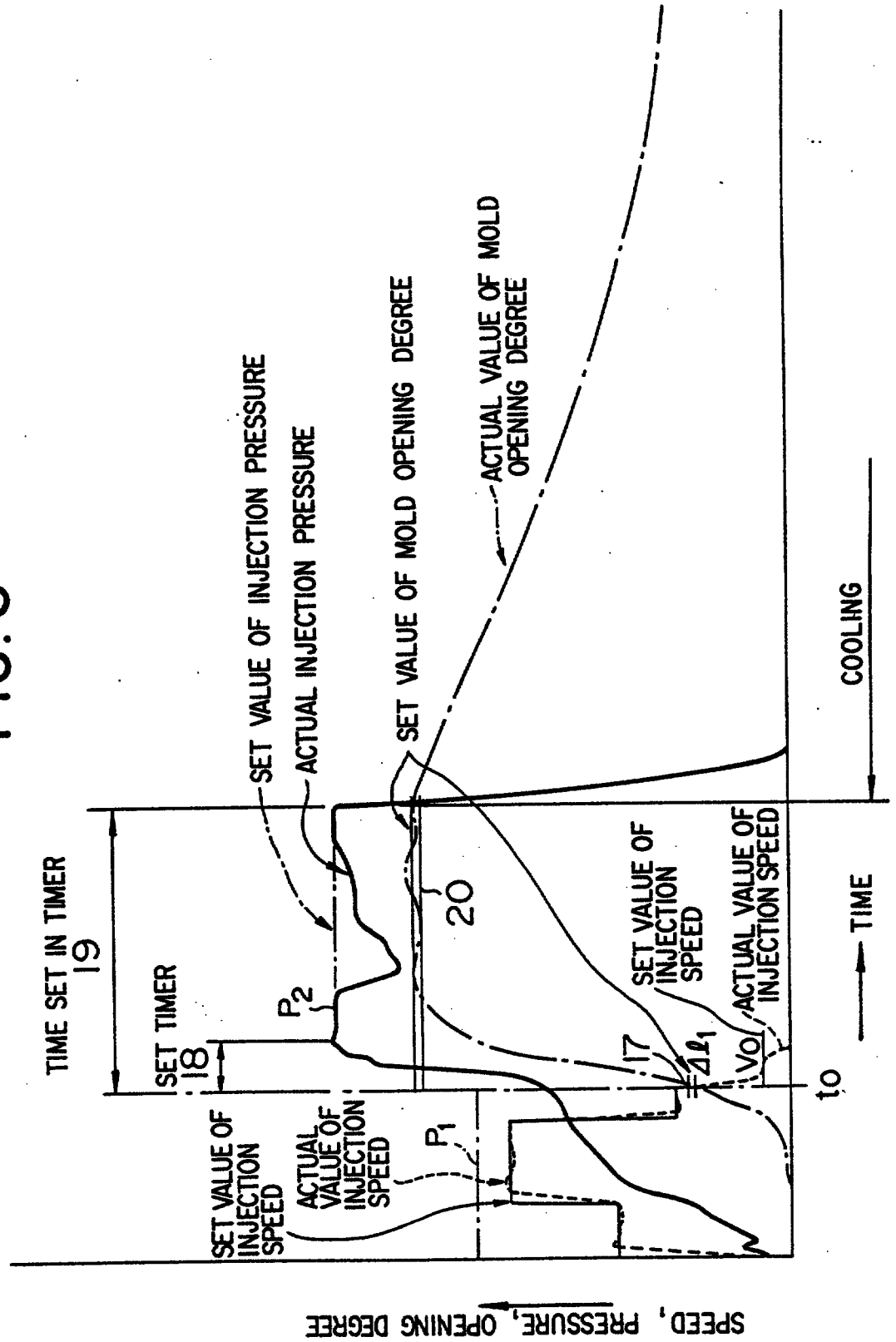


FIG. 6



ABSTRACT OF THE DISCLOSURE

(Figure 6)

INJECTION MOLDING METHOD

There is disclosed an injection molding method using an injection molding machine in which a plurality of control parameters including the injection speed, injection pressure and the mold opening degree are controlled, from a moment immediately before filling up of the mold cavity with the resin, setting the parameters in an order determined in accordance with the characteristics demanded by the resin, such that, when the injection pressure is controlled as a commanding parameter, the injection speed is controlled as a subordinate parameter under a given restriction and, when the mold opening degree is controlled as the commanding parameter, the injection pressure is controlled as a subordinate parameter under a given restriction. According to this method, it is possible to control the injection molding operation on the basis of a plurality of control parameters in accordance with characteristics demanded by the resin in the mold which varies time to time, thus making it possible to maximize the packing degree while minimizing burrs and short shot.

This Sheet Has Been Replaced



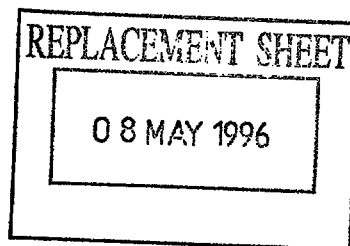
Replacement Sheet - 7 May 1996

ABSTRACT OF THE DISCLOSURE

INJECTION MOLDING METHOD

There is disclosed an injection molding method using an injection molding machine in which a plurality of control parameters including the injection speed, injection pressure and the mold opening degree are controlled, from a moment immediately before filling up of the mold cavity with the resin, setting the parameters in an order determined in accordance with the characteristics demanded by the resin, such that, when the injection pressure is controlled as a commanding parameter, the injection speed is controlled as a subordinate parameter under a given restriction and, when the mold opening degree is controlled as the commanding parameter, the injection pressure is controlled as a subordinate parameter under a given restriction.

(Figure 6)



Substitute sheet - 21 June 1999

- 3a -

1 compressed so that the resin tends to flow back towards
 the screw 16, as indicated by arrows in Fig. 4. In other
 words, a reaction force is applied to the screw 16. This
 phenomenon is often observed when the mode has been
 5 switched to the dwell pressure mode. Such reversing of
 the resin, once it has occurred, makes it difficult to
 completely fill thin-wall portions of the mold cavity and
 tends to cause defects such as short shot 13 or sink mark
 14. It is therefore necessary to take suitable measure
 10 for preventing reverse flow of the resin which is allowed
 by backward movement of the screw 16.

Fig. 4 shows the state of the resin which has
 filled up the mold cavity but no shell or solidified
 surface layer has been formed yet at the resin surface
 15 contacting the mold wall, while Fig. 5 shows the state in
 which the solidified surface layer 10 has been formed.
 The solidified surface layer 10 starts to be produced
 from 0.1 to 0.2 second after the state shown in Fig. 4
 has been attained. Therefore, possible degree packing,
 20 i.e., degree of press-filling, of the resin increases in
 accordance with the increase in the thickness of the
 solidified surface layer 10.

REPLACEMENT SHEETS		SC
☒	Description :	paged 3a, 3b, 4-11 to paged 1-11
☐	Claim(s) :	paged to paged
☐	Drawing(s) :	paged to paged
☐	Abstract :	paged to paged
DATE OF RECEIPT		23/6/99

- 3b -

5 A prior art method and apparatus for injection molding of plastic materials is described in DT 25 32 429 A1. In this known injection molding method a process control switches from an injection speed control to an injection pressure control wherein before switching from the injection speed control to the injection pressure control, the injection speed is controlled in conformity with a command value of the injection speed by regulating the discharge rate of molten resin by means of a valve. After the injection molding pressure has reached a
10 predetermined value, the injection pressure is controlled in conformity with the command value of the injection pressure. Accordingly, the process control in this known method is performed based upon a single control factor or parameter at a time.

15

SUMMARY OF THE INVENTION

Accordingly, an object of the present invention is to provided an injection molding method for molding an article by
20 using an injection molding machine in which control is performed

1 or parameters in accordance with the demanded charac-
teristic of the resin in the mold which varies time to
time, so as to attain the greatest degree of press-
filling of the resin, while minimizing generation of
5 burrs on the molded article and diminishing the short
shot.

To this end, according to the present invention,
there is provided an injection molding method for molding
an article by using an injection molding machine as defined
10 in Claim 1.

15

20

the
Accordingly, the control is commenced after the values of one
or more of the mold opening degree, screw position and
injection pressure have reached predetermined values at a
25 moment immediately before the filling up of the mold
cavity.

When the injection pressure is controlled as the
commanding parameter, the mold opening degree is set to a



1 value which allows relief of gases but prohibits genera-
tion of a burr at the mold parting surface and, after the
mold opening degree has reached the set value, the
control is switched to a mode which controls, using the
5 set value of the mold opening degree as the control
command, the injection pressure as a subordinate
parameter under such a restriction that the injection
pressure falls within the range which does not allow
generation of local burr. Prior to a control of the
10 injection pressure as the commanding parameter, a control
is done to control the injection speed and, when a set
value of the injection pressure is reached, the control
is automatically switched to a mode in which the injec-
tion pressure is controlled while the injection speed is
15 controlled as a subordinate parameter such that the resin
does not flow backward or such that the absolute value of
the speed of backward flow of the resin is smaller than a
predetermined maximum allowable value.

~~According to another aspect of the present~~
20 invention, there is provided an injection molding method
for molding an article by using an injection molding
machine, comprising the steps of: commencing, immediately
before filling up of the mold cavity with a resin, a
control of the injection speed to follow a set value V_0 of
25 the injection speed, starting at a control start point
which is determined by a set value or values of one or
more of control parameters including mold opening degree,
~~screw position and the injection pressure; conducting~~

1 ~~control of the injection pressure such that the injection~~
pressure is set to a value represented by a set function
2 $P = F(t)$ which provides the maximum injection pressure
within a range which does not allow generation of burr
5 and, after the actual injection pressure has been reached
the value represented by the set function $P = F(t)$, such
that the injection pressure varies in conformity with the
set function $P = F(t)$, while restricting the injection
speed to a range which does not allow backward flow of
10 the resin or does not cause the absolute value of
backward flow speed of resin to exceed a predetermined
maximum allowable value, and setting a command mold
opening degree to such a value that allows relief of
gases but does not allow generation of burr at the mold
15 parting surface; and after the command value of the mold
opening degree has been reached, switching the control to
a mode in which the injection pressure is controlled so
as to maintain the mold opening degree in conformity with
the command value, wherein the injection pressure is
20 restricted to a range which does not cause generation of
~~burrs.~~

These and other objects, features and advantages
of the present invention will become clear from the
following description which will be taken in conjunction
25 with the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a sectional view of an example of a

1 mold employed in an injection molding machine to which
the present invention is applied;

Fig. 2 is a sectional view illustrative of the
state of the resin in the mold cavity;

5 Fig. 3 is a sectional view illustrative of the
state of the resin in a mold having a plurality of mold
cavities;

Fig. 4 is a sectional view illustrative of the
state of the resin in a mold cavity showing the manner in
10 which burrs are generated;

Fig. 5 is a sectional view illustrative of the
state in which a solidified surface layer has been formed
on the resin in the mold cavity; and

Fig. 6 is a diagram showing how the injection
15 pressure, injection speed and the degree of opening of
the mold are changed in relation to time.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

Referring to Fig. 1, a molten resin is charged
through a nozzle 2 into a mold cavity 6 in a mold 1 via a
20 sprue 3, runner 4 and gates 6 so as to fill the mold
cavity 6. When the mold cavity 6 has been filled almost
fully, the mold 1^{is} slightly urged backward in the opening
direction apart from a mating mold part tending to form a
minute gap at the parting surface 7. The amount of this
25 backward movement will be referred to as "degree of
opening" of the mold. The degree of opening of the mold
is detected by a dial gauge attached to the mold 1 by

1 means of a magnet 8, and is transmitted by a transmitter
on the dial gauge 9.

Referring now to Fig. 6, a mold opening degree
is set as at 17 as a criterion for determination as to
5 whether the cavity 6 has been filled near fully. This
set level 17 of the mold opening degree may be replaced
with the injection load pressure or the screw position.
When this set level of the mold opening degree has been
reached, a control is set so as to control the following
10 three factors or parameters:

- A) Injection speed (This parameter may be
programmed, although it is fixed in the illustrated
embodiment.)
- 15 B) Injection pressure (This parameter may be
programmed, although it is fixed in the illustrated
embodiment. In the case of an electric injection molding
machine, current value or the motor torque may be used in
place of the injection pressure.)
- 20 C) Degree of mold opening (This parameter may be
programmed, although it is fixed in the illustrated
embodiment.)

Referring to Fig. 6, when the degree of mold
opening has approached the set level 17 (5 to 10 μ in
case of an ABS resin) after the start of the injection,
A is feedback-controlled on the basis of the set value
25 the injection speed/ A_1 (10 mm/sec or so in case of ABS
resin)

of the injection speed. An increase in the load
resistance causes a rise in the injection pressure so

- 1 that the injection pressure reaches a set level P_1 / (1418.5 bar (1400 atm) in case of injection resin).

When this injection pressure is reached, a feedback control is conducted by using the injection pressure as the commanding parameter, such that the injection pressure is controlled in accordance with a set function of $P = F(t)$, under the conditions of the following formula "S".

- 0 or set value - A_2 (3 mm/sec in case of ABS resin)

$\leq$ injection speed $\leq$ set value $A_1 \dots S1$.
2026.5 bar

The maximum value P_{max} of the injection pressure is / 2000 atm).

- The maximum allowable injection pressure (pressure which is the highest within the range which does not cause generation of burrs) at a moment t_0 , immediately before the filling up of the mold cavity is represented by P_1 , while the maximum allowable injection pressure (pressure which is the highest within the range which does not cause generation of burrs) at a moment at which the solidified surface layer is formed upon contact with the mold wall is expressed by P_2 . The present inventors have found that the pressure P_2 rises in accordance with an increase in the thickness of the solidified surface layer and in accordance with an increase in the viscosity of the resin. In this embodiment, the pressure P_2 is changed linearly in accordance with a time value set in a timer 18, e.g., 0.3

1 second. Obviously, however, other function of time may
be used for the control of the pressure. Anyway, the
control should follow the curve of the function $P = F(t)$.

In this state, the injection speed naturally
5 falls within the range of the formula S1. Usually, the
formula S1 has a value not smaller than 0. The value of
this formula, however, may be lowered to a lower limit
expressed by $-A2$, particularly when the mold is so
designed and constructed as to small effect in preventing
10 generation of burr. The pressure should not be reduced
below this lower limit $A2$ because a too large backward
flowing speed increases the pumping effect on the resin.
The maximum pressure P_{max} is set to 2026.5 bar (2000 atm).

An alarm is activated when the range of the
15 formula S1 is exceeded, except for the case of a surge,
so that the instant shot is rejected as being defective.
With this control, a waiting step is taken until the
gases are expelled from the gas space 11 and until any
short short 13 is completely eliminated, while avoiding
20 local generation of burrs.

When the local short shot 13 is completely
eliminated, an external pressure acts so as to further
open the mold 1 at the parting surface 7 (see Fig. 1).
In this state, on conditions that the requirement of the
25 formula S1 and the requirement of the following formula
S2 are simultaneously met, the injection pressure is
controlled using the mold opening degree as the
commanding parameter, such that mold opening degree

1 follows a set value C (30 μ in case of an ABS resin).

injection Pressure $\leq$ set value Pmax of injection
pressure S₂.

This set value C is determined to be a value
5 which is the greatest within a range which allows escape
of gas through the gap on the parting surface but does
not allow the resin/^{to}leak therethrough. In this stage,
the thickness of the solidified surface layer 10 of the
resin contacting the surface of the mold cavity 5 is
10 still small. Consequently, the degree of possible
packing also is small because the thin solidified surface
layer of the resin may easily allow generation of burrs
when a large degree of packing is effected.

The solidified layer 10 becomes thicker as the
15 time elapses, so that the allowable mold opening degree
also is increased. In the illustrated embodiment, the
mold opening degree is directly set to C in view of time
lag incurred in the control for setting the injection
speed and the injection pressure. This value of the mold
20 opening degree C corresponds to the state at which the
solidified surface layer 10 is formed. It is thus
possible to precisely pack the resin with a degree which
is the greatest in the range which does not allow
generation of local burrs.

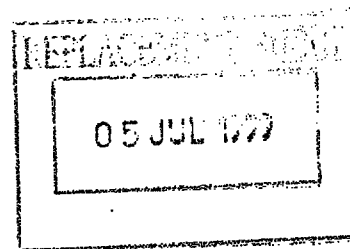
25 The solidification proceeds to reach the portion
near the gate 5 (see Fig. 1). In this state, the
injection pressure is no more transmitted to the resin
portion inside the cavity 6. Meanwhile, the resin is

Substitute sheet - 1 July 1999

- 4 -

1 in accordance with the demanded characteristic of the resin in the mold which varies time to time, so as to attain the greatest degree of press-filling of the resin, while minimizing generation of
5 burrs on the molded article and diminishing the short shot.

To this end, according to the present invention, there is provided an injection molding method for molding an article by using an injection molding machine as defined
10 in Claim 1.



15

20

the
Accordingly, the control is commenced after the values of one or more of the mold opening degree, screw position and injection pressure have reached predetermined values at a
25 moment immediately before the filling up of the mold cavity.

When the injection pressure is controlled as the commanding parameter, the mold opening degree is set to a