

Plastic Injection Tool for Producing a Closure Cap, and Method
for Producing a Closure Cap

ABSTRACT

The invention relates to a plastic injection tool (1) for producing a closure cap (5) with a cap body (14) and a cap cover (15) formed integrally with and of the same material as the cap body (14), wherein the cap cover (15) can be in the form of a cap lid that can be moved relative to the cap body (14), wherein the injection tool (1) is also divided into first and second mould halves (2, 3) that can be moved relative to one another and wherein an injection nozzle (4) is formed in the first mould half (2), wherein, in addition, sliding jaw tool parts (9) are formed in the second mould half (3), radially outside a central tool core (8), which can simultaneously be moved in an ejection direction (r) of the produced closure cap (5) and perpendicular to the ejection direction (r), and a respective partial ejection contour (16) of the cap body (14) is formed in the sliding jaw tool parts (9), wherein the partial injection contours (16), brought together in a circumferential direction of the closure cap (5), result in a complete injection contour of the part of the cap body (14) formed by the sliding jaw tool parts (9), wherein an ejector (48) is also provided, also associated with the second mould half (3), for ejecting the produced closure cap (5). In order to further improve a plastic injection tool of this type, according to the invention, partial injection contours (16) that are different from one another are formed in two or more sliding jaw tool parts (9), and a sliding jaw tool part (9) is in contact with the tool core (8) in two regions (51) lying after one another in the ejection direction (r), in the ejection direction (r) before the ejection of the closure cap (5).

Fig. 3