

Go-No/Go Injection Mold

If you answer no to any of these then the object is not injection moldable on this machine.

Is the object cross section smaller than 6"x9"?

Is the volume of the object greater than 6 in³?

Is the area cross section more than 18 square inches?

If you multiple the cross section area of your part (under 1" thick, multiple by 10% if over 1") by injection pressure needed for material selection listed below does it exceed 18 tons? (20 tons with safety factor of 10%)

Material	Ton per in ² low (injection Pressure)	Ton per in ² high (Injection Pressure)
ABS	2.70	4.41
HIPS	1.07	2.20
CAB	1.07	2.20
HDPE	1.64	2.77
LDPE	1.07	2.20
NYLON 6	4.41	5.47
NYLON 6 (30% GF)	4.98	6.04
NYLON 6/6	4.41	5.47
NYLON 11	1.64	2.20
NYLON 12	1.64	2.20
PEEK	2.20	4.41
POLYCARBONATE	3.27	5.47
POLYESTER PBT	3.27	4.98
PPS	2.13	3.20
PET	2.77	5.33
PMMA ACRYLIC	2.20	4.41
POM	3.27	5.47
POLYPROPYLENE - H	1.64	2.77
POLYSTYRENE	1.07	2.20
PVC	2.20	3.27
SAN	2.77	3.27