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(71) Applicant: **IMFLUX INC.** [US/US]; 3550 Symmes Road, Hamilton, OH 45015 (US).

(72) Inventors: **MONTAGUE, Richard, Lewis, II**; 2412 Harrigan Way, Lexington, KY 40509 (US). **POLLARD, Rick, Alan**; 1219 Rolling Meadows Dr., Moscow, OH 45153 (US). **HUANG, Chow-Chi**; 9035 Amy Marie Drive, West

Chester, OH 45069 (US). **ALTONEN, Gene, Michael**; 7649 Nordan Drive, West Chester, OH 45069 (US). **MC-CONNELL, Kimberly, Nichole**; 7071 Keltner Dr., West Chester, OH 45069 (US). **NEATE, Aaron, Timothy**; 4663 Beech Knoll Lane, Liberty Township, OH 45011 (US).

(74) Agent: **HUGHLEY, Jonathan, C.**; Marshall, Gerstein & Borun LLP, 233 S. Wacker Drive, 6300 Willis Tower, Chicago, IL 60606-6357 (US).

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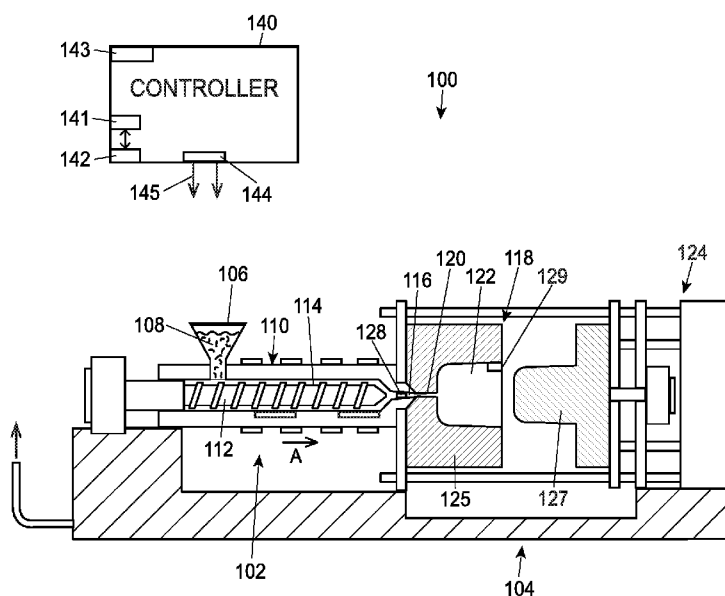


FIG. 1

(57) Abstract: Non-time dependent measured variables are used to effectively determine an optimal hold profile for an expanding crosslinking polymer part in a mold cavity. A system and/or approach may first inject molten expanding crosslinking polymer into a mold cavity, then measure at least one non-time dependent variable during an injection molding cycle. Next, the system and/or method commences a hold profile for the part, and upon completing the hold profile, the part is ejected from the mold cavity.



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## **INJECTION MOLDING OF CROSSLINKING POLYMERS**

### **CROSS-REFERENCE TO RELATED APPLICATION**

**[0001]** This application claims priority to U.S. Provisional Application No. 62/519,961, entitled “Injection Molding of Crosslinking Polymers”, filed June 15, 2017, the entirety of which is incorporated by reference herein.

### **FIELD OF THE DISCLOSURE**

**[0002]** The present disclosure generally relates to injection molding and, more particularly, to injection molding of expanding crosslinking polymers.

### **BACKGROUND**

**[0003]** Injection molding is a technology commonly used for high-volume manufacturing of parts constructed from thermoplastic materials. During repetitive injection molding processes, a thermoplastic resin, typically in the form of small pellets or beads, is introduced into an injection molding machine which melts the pellets under heat and pressure. The molten material is then forcefully injected into a mold cavity having a particular desired cavity shape. The injected plastic is held under pressure in the mold cavity and subsequently is cooled and removed as a solidified part having a shape closely resembling the cavity shape of the mold. A single mold may have any number of individual cavities which can be connected to a flow channel by a gate that directs the flow of the molten resin into the cavity.

**[0004]** Expanding crosslinking polymers (e.g., ethylene-vinyl acetate or “EVA”) are one class of polymers that are commonly injection molded. A typical injection molding process of expanding crosslinking polymers generally includes four basic operations. First, the plastic is heated in the injection molding machine to allow the plastic to flow under pressure. When injection molding expanding crosslinking polymers, at this step, the polymer is heated to a temperature that is below an activation temperature of the polymer, or the temperature at which expansion and crosslinking within the polymer begins to occur.

**[0005]** Next, the melted plastic is injected into a mold cavity or cavities defined between two mold halves that have been closed. The mold or cavity temperature is set to a value that is high enough to activate a chemical reaction or reactions that cause the polymer to begin expansion and crosslinking. At a third step, the plastic is held under pressure to allow adequate crosslinking

and expansion (or blowing) to occur in the cavity or cavities. Last, the mold halves are opened, and the molded article is removed or ejected from the mold, thereby allowing the plastic to expand to a final shape and configuration that is larger than the internal volume of the mold cavity.

**[0006]** In conventional systems, a fixed, predetermined volume of plastic is injected into the mold cavity. This volume only partially fills the cavity. The mold cavity is then heated to cause a chemical reaction, upon which the plastic is then left to expand to fill the mold cavity and crosslink for a specified hold time, which is typically determined via a “gate freeze study” where the part weight is measured over a period of time. In this gate freeze study, part weights are periodically measured during the injection molding process until the weight begins to level off. The point at which the part weight levels off is identified as generally being the optimum time to eject the part. This gate freeze study is typically performed during a process validation stage, and is oftentimes used for the entirety of subsequent injection molding cycles.

**[0007]** The time when the plastic is ejected (which is dependent on the calculated hold time) is determined or calculated to provide the injected plastic sufficient time to expand and crosslink (thus being sufficiently hardened) to the desired final shape so the plastic does not deform or become otherwise damaged. However, due to material and machine variances, using a fixed hold time as the determining variable can result in varying internal peak cavity pressures, which can impact crosslinking and expansion while in the mold cavity. Specifically, the chemical reaction that causes the part to expand is less consistent, as evidenced by both delayed and inconsistent pressure-builds in existing systems. In turn, when the part is ejected from the mold and enters a curing stage where the molded parts continue to expand and crosslink until reaching a final form, expansion and crosslinking may occur at varying rates, thus resulting in inconsistently sized parts. Further, the parts may have unsightly blemishes and other undesirable flaws.

**[0008]** For example, a melted plastic may have slightly different material characteristics in subsequent injection cycles, thus if subsequent injection cycles were to depend on prior hold times, the occurrence of part imperfections, faults, and other irregularities may arise. If a part is held in the cavity longer than needed, the overall injection molding cycle is unnecessarily long, thus the injection molding machine consumes excess energy which in turn increases operating costs and adversely impacts production capacity. Further, the molded parts may not experience

consistent heat transfer in the mold, which can result in a non-uniform skin layer. The cell structure of the molded part may also be non-uniform, meaning free radical molecules may not be aligned. When these molecules are uniformly distributed, the resulting part has more consistent and stable dimensions and physical properties.

**[0009]** Further, conventional systems typically do not provide uniform heat distribution throughout the plastic during the molding process due to varying mold thicknesses. By unevenly heating the plastic, different regions of the plastic within the mold cavity can expand at different rates, which can result in inconsistent parts having wide tolerances.

**[0010]** Further, the molded parts may be incorrectly dimensioned (meaning, parts may be either too large or too small) and may potentially be too soft or too resilient due to insufficient crosslinking. As a result, the molded part may fail any number of objective tests such as an abrasion test, a compression set test, and/or a dynamic elasticity test where energy loss is measured over a number of closely timed impacts with a controlled load.

### SUMMARY

**[0011]** Embodiments within the scope of the present invention are directed to the use of non-time dependent measured variables to effectively determine an optimal hold profile of one or more expanding crosslinking polymer parts being formed in a mold cavity. A system and/or approach may first inject molten expanding crosslinking polymer into a mold cavity, then measure at least one non-time dependent variable during an injection molding cycle. Next, the system and/or method commences a hold profile for the part, and upon completing the hold profile, the part is ejected from the mold cavity.

**[0012]** In these examples, the mold cavity is nearly completely filled at an injection stage. A suitable hold profile commences when at least one measured non-time dependent variable reaches a first threshold value, and continues until the measured at least one non-time dependent variable(s) reaches a second threshold value. During this period, additional molten expanding crosslinking polymer is restricted from being injected into the mold cavity.

**[0013]** In some examples, the first threshold value is indicative of the mold cavity being substantially full of molten expanding crosslinking polymer. The second threshold value may be indicative of the part being structurally sound, and being ready to be ejected.

**[0014]** In some examples, the measured variable is a cavity pressure value. In these examples, the first threshold value may be a nominal increase in cavity pressure. The second threshold value may be indicative of a substantially constant cavity pressure value over a specified period of time such as, for example, between approximately five seconds and ten seconds, depending on the part geometry. Other examples of threshold values with respect to cavity pressure measurements are possible.

**[0015]** In other examples, the measured variable is a temperature value. In these examples, the first threshold value may be a nominal increase above an initial cavity temperature. The second threshold value may represent a substantially constant cavity temperature value over a specified period of time such as, for example, between approximately 0.1 seconds and ten seconds, depending on the part geometry. Other examples of threshold values with respect to cavity temperature measurements are possible.

**[0016]** In some approaches, an expanding crosslinking polymer injection molding system includes an injection molding machine comprising an injection unit and a mold forming at least one mold cavity, a controller adapted to control operation of the injection molding machine, and one or more sensors coupled to the injection molding machine and the controller. The injection unit is adapted to receive and inject a molten expanding crosslinking plastic material into the at least one mold cavity to form a molded part. At least one of the one or more sensors is adapted to measure at least one non-time dependent variable during the injection mold cycle. The controller is adapted to commence a hold profile for the expanding crosslinking polymer part, and is further adapted to cause the molded part to be ejected from the mold cavity upon completing the hold profile.

**[0017]** By optimizing the hold profile, consistent parts having minimal defects and variances in size are produced. Measurements obtained from the non-time dependent variable or variables can be used as a highly accurate measure of when to make process parameter decisions.

#### **BRIEF DESCRIPTION OF THE DRAWINGS**

**[0018]** The above needs are at least partially met through provision of one, more than one, or any combination of the approaches for injection molding expanding crosslinking polymers described in the following detailed description, particularly when studied in conjunction with the drawings, wherein:

[0019] Fig. 1 illustrates an elevation view of an exemplary injection molding machine having a controller coupled thereto in accordance with various embodiments of the present disclosure;

[0020] Fig. 2 illustrates an example relationship between a blowing agent and a crosslinking agent over time during injection molding of an expanding crosslinking polymer in accordance with various embodiments of the present disclosure; and

[0021] Fig. 3 illustrates an example relationship between screw position, cavity pressure, and melt pressure during an expanding crosslinking polymer injection molding cycle in accordance with various embodiments of the present disclosure.

[0022] Skilled artisans will appreciate that elements in the figures are illustrated for simplicity and clarity and have not necessarily been drawn to scale. For example, the dimensions and/or relative positioning of some of the elements in the figures may be exaggerated relative to other elements to help to improve understanding of various embodiments of the present invention. Also, common but well-understood elements that are useful or necessary in a commercially feasible embodiment are often not depicted in order to facilitate a less obstructed view of these various embodiments. It will further be appreciated that certain actions and/or steps may be described or depicted in a particular order of occurrence while those skilled in the art will understand that such specificity with respect to sequence is not actually required. It will also be understood that the terms and expressions used herein have the ordinary technical meaning as is accorded to such terms and expressions by persons skilled in the technical field as set forth above except where different specific meanings have otherwise been set forth herein.

### **DETAILED DESCRIPTION**

[0023] An injection molding process for expanding crosslinking polymers is herein described. Examples of expanding crosslinking polymers include EVA, which, when polymerized, include any number of blowing agents and any number of crosslinking agents which are activated by a specified temperature. For example, the blowing agents and crosslinking agents may be activated at temperatures between approximately 160° C and approximately 190° C, or preferably, at temperatures between approximately 165° C and approximately 185° C, and more preferably, at temperatures between approximately 170° C and approximately 180° C, which may provide an optimal range for blowing and crosslinking to occur. Other examples of suitable temperature ranges are possible.

**[0024]** As illustrated in Fig. 1, an injection molding machine 100 that molds expanding crosslinking polymers includes an injection unit 102 and a clamping system 104. The approaches described herein may be suitable for vertical press injection molding machines and any other known types of injection molding machines. The injection unit 102 includes a hopper 106 adapted to accept the expanding crosslinking polymer material in the form of pellets 108 or any other suitable form. In many of these examples, the pellets 108 include any number of foaming agents, crosslinking agents, and the like. Other examples are possible.

**[0025]** The hopper 106 feeds the pellets 108 into a heated barrel 110 of the injection unit 102. Upon being fed into the heated barrel 110, the pellets 108 may be driven to the end of the heated barrel 110 by a reciprocating screw 112. The heating of the heated barrel 110 and the compression of the pellets 108 by the reciprocating screw 112 causes the pellets 108 to melt, thereby forming a molten plastic material 114. The molten plastic material 114 is typically processed at a temperature selected within a range between about 110° C and about 150° C. This melt temperature is below an activation temperature of the molten plastic material 114.

**[0026]** The reciprocating screw 112 advances forward and forces the molten plastic material 114 toward a nozzle 116 to form a shot of plastic material 114 which will ultimately be injected into a mold cavity 122 of a mold 118 via one or more gates 120 which direct the flow of the molten plastic material 114 to the mold cavity 122. In other embodiments, the nozzle 116 may be separated from one or more gates 120 by a feed system (not illustrated). The mold cavity 122 is formed between the first and second mold sides 125, 127 of the mold 118 and the first and second mold sides 125, 127 are held together under pressure via a press or clamping unit 124. The mold 118 may include any number of mold cavities 122 to increase overall production rates. The shapes and/or designs of the cavities may be identical, similar, and/or different from each other.

**[0027]** The press or clamping unit 124 applies a predetermined clamping force during the molding process which is greater than the force exerted by the injection pressure acting to separate the two mold halves 125, 127, thereby holding together the first and second mold sides 125, 127 while the molten plastic material 114 is injected into the mold cavity 122. To support these clamping forces, the clamping system 104 may include a mold frame and a mold base, in addition to any other number of components.

**[0028]** The reciprocating screw 112 continues forward movement, causing the shot of molten plastic material 114 to be injected into the mold cavity 122. The mold cavity 122 is heated to a temperature that is higher than the activation temperature of the molten plastic material 114. For example, the mold cavity 122 may be heated to a temperature between approximately 160° C and approximately 185° C, and preferably, to a temperature between approximately 170° C and 180° C. As such, a chemical reaction begins to occur within the molten plastic material 114 as it contacts sidewalls of the mold cavity 122. It is understood that walls of the mold cavity 122 may be preheated prior to injection the molten plastic material 114, or alternatively, may be rapidly heated to a suitable temperature as the molten plastic material 114 enters the mold cavity 122. Examples of heating techniques that may be used to heat surfaces of the mold that define the mold cavity are: resistive heating (or joule heating), conduction, convection, use of heated fluids (e.g., superheated steam or oil in a manifold or jacket, also heat exchangers), radiative heating (such as through the use of infrared radiation from filaments or other emitters), RF heating (or dielectric heating), electromagnetic inductive heating (also referred to herein as induction heating), use of thermoelectric effect (also called the Peltier-Seebeck effect), vibratory heating, acoustic heating, and the use of heat pumps, heat pipes, cartridge heaters, or electrical resistance wires, whether or not their use is considered within the scope of any of the above-listed types of heating.

**[0029]** The injection molding machine 100 also includes a controller 140 which is communicatively coupled with the machine 100 via connection 145, and is generally used to control operation of the injection molding machine 100. The connection 145 may be any type of wired and/or wireless communications protocol adapted to transmit and/or receive electronic signals. In these examples, the controller 140 is in signal communication with at least one sensor, such as, for example, sensor 128 located in the nozzle 116 and/or a sensor 129 located proximate to an end of the mold cavity 122. The sensor 129 may be located at any position within or near the mold cavity 122. It is understood that any number of additional sensors capable of sensing any number of characteristics of the mold 118 and/or the machine 100 may be placed at desired locations of the machine 100.

**[0030]** The controller 140 can be disposed in a number of positions with respect to the injection molding machine 100. As examples, the controller 140 can be integral with the machine 100, contained in an enclosure that is mounted on the machine, contained in a separate enclosure

that is positioned adjacent or proximate to the machine, or can be positioned remote from the machine. In some embodiments, the controller 140 can partially or fully control functions of the machine via wired and/or wireless signal communications as known and/or commonly used in the art.

**[0031]** The sensor 128 may be any type of sensor adapted to measure (either directly or indirectly) one or more characteristics of the molten plastic material 114. The sensor 128 may measure any characteristics of the molten plastic material 114 that is known in the art, such as, for example, pressure, or temperature, and the like, or any one or more of any number of additional characteristics which are indicative of these. The sensor 128 may or may not be in direct contact with the molten plastic material 114. In some examples, the sensor 128 may be adapted to measure any number of characteristics of the injection molding machine 100 and not just those characteristics pertaining to the molten plastic material 114.

**[0032]** The sensor 128 generates a signal which is transmitted to an input of the controller 140. If the sensor 128 is not located within the nozzle 116, the controller 140 can be set, configured, and/or programmed with logic, commands, and/or executable program instructions to provide appropriate correction factors to estimate or calculate values for the measured characteristic in the nozzle 116.

**[0033]** Similarly, the sensor 129 may be any type of sensor adapted to measure (either directly or indirectly) one or more characteristics of the molten plastic material 114 to detect its presence and/or condition in the mold cavity 122. In various embodiments, the sensor 129 may be located at or near an end-of-fill position in the mold cavity 122. The sensor 129 may measure any number of characteristics of the molten plastic material 114 and/or the mold cavity 122 that is known in the art, such as, for example, pressure, temperature, and the like, or any one or more of any number of additional characteristics which are indicative of these. The sensor 129 may or may not be in direct contact with the molten plastic material 114.

**[0034]** The sensor 129 generates a signal which is transmitted to an input of the controller 140. If the sensor 129 is not located at the end-of-fill position in the mold cavity 122, the controller 140 can be set, configured, and/or programmed with logic, commands, and/or executable program instructions to provide appropriate correction factors to estimate or calculate values for the measured characteristic at the end-of-fill position. It is understood that any number of

additional sensors may be used to sense and/or measure operating parameters. For example, U.S. Patent Application No. 15/198,556, filed on June 30, 2016 and published as U.S. Publication No. 2017/0001356, describes a sensor positioned prior to the end-of-fill to predict the end-of-fill and is hereby incorporated herein by reference in its entirety.

**[0035]** The controller 140 is also in signal communication with the screw control 126. In some embodiments, the controller 140 generates a signal which is transmitted from an output of the controller 140 to the screw control 126. The controller 140 can control any number of characteristics of the machine, such as, for example, injection pressures (by controlling the screw control 126 to advance the screw 112 at a rate which maintains a desired melt pressure of the molten plastic material 114 in the nozzle 116), barrel temperatures, clamp closing and/or opening speeds, cooling time, inject forward time, hold profiles, overall cycle time, pressure set points, ejection time, screw recovery speed, and screw velocity. Other examples are possible.

**[0036]** The signal or signals from the controller 140 may generally be used to control operation of the molding process such that variations in material viscosity, mold cavity 122 temperatures, melt temperatures, and other variations influencing filling rate are taken into account by the controller 140. Adjustments may be made by the controller 140 in real time or in near-real time (that is, with a minimal delay between sensors 128, 129 sensing values and changes being made to the process), or corrections can be made in subsequent cycles. Furthermore, several signals derived from any number of individual cycles may be used as a basis for making adjustments to the molding process. The controller 140 may be connected to the sensors 128, 129, the screw control 126, and or any other components in the machine 100 via any type of signal communication known in the art or hereafter developed.

**[0037]** The controller 140 includes software 141 adapted to control its operation, any number of hardware elements 142 (such as, for example, a memory module and/or processors), any number of inputs 143, any number of outputs 144, and any number of connections 145. The software 141 may be loaded directly onto a memory module of the controller 140 in the form of a non-transitory computer readable medium, or may alternatively be located remotely from the controller 140 and be in communication with the controller 140 via any number of controlling approaches. The software 141 includes logic, commands, and/or executable program instructions which may contain logic and/or commands for controlling the injection molding machine 100

according to a mold cycle. The software 141 may or may not include an operating system, an operating environment, an application environment, and/or a user interface.

**[0038]** The hardware 142 uses the inputs 143 to receive signals, data, and information from the injection molding machine being controlled by the controller 140. The hardware 142 uses the outputs 144 to send signals, data, and/or other information to the injection molding machine. The connection 145 represents a pathway through which signals, data, and information can be transmitted between the controller 140 and its injection molding machine 100. In various embodiments this pathway may be a physical connection or a non-physical communication link that works analogous to a physical connection, direct or indirect, configured in any way described herein or known in the art. In various embodiments, the controller 140 can be configured in any additional or alternate way known in the art.

**[0039]** The connection 145 represents a pathway through which signals, data, and information can be transmitted between the controller 140 and the injection molding machine 100. In various embodiments, these pathways may be physical connections or non-physical communication links that work analogously to either direct or indirect physical connections configured in any way described herein or known in the art. In various embodiments, the controller 140 can be configured in any additional or alternate way known in the art.

**[0040]** As previously stated, during an injection molding cycle, the sensors 128, 129 are adapted to measure at least one variable related to operation of the machine 100. During operation, the controller 140 commences a hold profile which may be stored in the software 141. In some examples, the hold profile may be commenced upon the measured variable reaching a threshold value. Upon completing the hold profile, the controller 140 will send a signal to the machine that causes the mold cavity 122 to open and to eject the part from the mold 118 so that it can complete necessary continued expansion and crosslinking to form a structurally sound molded part. For example, a structurally sound molded part may be free of divots, dwells, flash, partial fills, burns, tears, minimal imperfections such as sink marks and/or swirls on the surface layer, weakness at thickness changes, and may also have uniformity of mechanical properties.

**[0041]** In these examples, the variable or characteristic may be one other than time (e.g., a cycle, step, or any other time), thus time is not directly measured and used to determine the length of the hold profile, and accordingly, time is not directly measured and used to determine

when to eject the part. Rather, the variable or characteristic relies on another value or indicator as a determining factor for part readiness. The use of one or more non-time dependent variables is advantageous because during successive runs, even with the same supply of pellets 108, variations in pellet quality, catalyst stability, ambient conditions, or other factors may influence the cross-linking of the polymer material from shot-to-shot. While a time-dependent process may provide satisfactory parts most of the time, a system that determines ejection readiness based on one or more non-time dependent variables is preferable, as this provides a more accurate assessment for each individual shot or run of the molding system.

**[0042]** Turning to Fig. 2, which illustrates an example relationship between the blowing agent and the crosslinking agent of the expanding crosslinking polymer over time, during the injection molding process, the blowing agent first activates at a given temperature and begins to react over time. Generally speaking, the blowing agent, depicted by the solid line in Fig. 2, will cause the part to expand, and thus will at least partially dictate the part size. At approximately the same point that the blowing agent is activated, the crosslinking agent, depicted by the dashed line in Fig. 2, activates and begins to form structural bonds within the polymer. Both the blowing agent and crosslinking agent generate exothermic reactions, thus they generate heat as the reaction advances, which in turn causes the blowing and crosslinking agents to continue their respective chemical reactions. When the blowing process concludes, the reaction will stop emitting heat. At this point, crosslinking continues until the part is sufficiently formed, meaning the molten plastic material 114 is no longer in a flowable state.

**[0043]** Referring again to Fig. 1, upon the molten plastic material 114 substantially filling the mold cavity 122, a hold profile is commenced. During the hold profile, which may commence upon the measured variable (which can be measured by any of sensors 128 and/or 129) reaching a first threshold value, additional molten plastic material 114 is restricted from being injected into the mold cavity 122. This may occur by shutting off the supply of molten plastic material 114, or alternatively or in combination, by controlling movement of the screw 112. Additionally, the mold cavity 122 is held closed during the hold profile. Upon the measured variable (which can be measured by any of sensors 128 and/or 129) reaching a second threshold value, controller 140 causes the hold profile to terminate, whereby the mold cavity 122 is opened and the part is ejected from the mold 118.

**[0044]** Turning now to Fig. 3, which represents an example expanding crosslinking polymer injection molding cycle 300, the measured variable may reach first and second threshold values. Line 302 depicts the position of the screw 112 under a certain injection pressure (i.e., 5,000 psi) once the cavity pressure is built to a desired and/or designated trigger point. As an example, the pressure can decrease from approximately 5,000 psi to approximately 2,000 psi at this point. In this example, during injection of the expanding crosslinking polymer, melt pressure, which is depicted by line 304, is first increased and then held to a substantially constant value.

Accordingly, the sensor 128 may be a pressure sensor disposed within, on, and/or near the screw 112. As a non-limiting example, the melt pressure may be between approximately 0 psi and approximately 11,000 psi. Other examples of suitable melt pressures are possible. Further, it is understood that in some examples, the melt pressure may not be held to a substantially constant value.

**[0045]** In Fig. 3, line 306 depicts the measured variable as a cavity pressure value. Accordingly, in this example, the sensor 129 may be a pressure sensor disposed within, on, or near the mold cavity 122. In the illustrated example, in region I, the sensor 129 measures a cavity pressure that exceeds the first threshold value. As previously noted, in some examples, during the injection molding process, the mold cavity 122 can be essentially completely filled with molten plastic material 114.

**[0046]** In this example, the measured cavity pressure value is defined as a cavity pressure greater than a nominal value, which may be at least partially caused by the molten plastic material 114 completely filling the mold cavity 122 and exerting a pressure on the cavity walls. The increase in cavity pressure may additionally or alternatively be caused by the expansion of the molten plastic material 114 within the mold cavity 122. It is understood that in some examples, the first threshold value may be any desired quantity. For example, the first threshold value may be a distinct cavity pressure value, such as, approximately 100 psi. Other examples are possible.

**[0047]** Upon the sensor 129 measuring a cavity pressure value exceeding the first threshold value, the controller 140 commences the hold profile. As illustrated by line 304 in Fig. 3, the melt pressure is then adjusted (for example, reduced). In the illustrated example, the melt pressure is again held to a substantially constant value, such as, for example, between

approximately 500 psi and approximately 3,500 psi. Other examples are possible. This pressure is maintained by controlling movement of the screw 112 to a hold pressure measured at the nozzle by the sensor 128.

**[0048]** At region II, as the melt pressure is maintained, the measured cavity pressure increases as the molten plastic material 114 begins to blow and/or expand. Upon the sensor 129 measuring a cavity pressure value that exceeds the second threshold value, the hold profile is completed, and the controller 140 causes the part to be ejected from the mold cavity 122. As an example, the second threshold value may be a distinct cavity pressure value, such as, between approximately 100 psi and approximately 2,000 psi. Other examples are possible. This second threshold value is indicative of the expanding crosslinking polymeric part being sufficiently structurally sound to complete the remainder of its expansion and crosslinking outside of the mold cavity. At this point, the mold cavity 122 is opened, thus the melt pressure drops to approximately 0.

**[0049]** In some examples, the sensor 129 is a temperature sensor that measures a temperature value. Accordingly, in these examples, the first threshold value may be a cavity temperature value that is representative of the mold cavity 122 being substantially completely filled. For example, the first threshold temperature value may be between approximately 168° C and approximately 176° C. Other examples are possible. Similarly, in these examples, the second threshold value may be a cavity temperature value that is representative of the molten plastic material 114 being sufficiently structurally sound for ejection. In these examples, the cavity temperature may plateau or decrease at a point when the part is ready to be ejected from the mold cavity 122. As a non-limiting example, the second threshold temperature value may be between approximately 160° C and approximately 180° C. Other examples are possible.

**[0050]** Because the mold cavity 122 is substantially completely filled (e.g., between approximately 95% and approximately 99% fill) prior to commencement of the hold profile, and because pressure is applied to the molten plastic material 114 thereby holding it against the heated walls of the mold cavity 122, heat is uniformly distributed or transferred to the molten plastic material 114 due to the increased surface contact. Advantageously, the blowing and crosslinking agents will activate more uniformly, thus forming more cohesive bonds.

**[0051]** So configured, the hold profile can be described as the combination of regions I and II in Fig. 3. The injection molding machine 100 does not contemplate the actual duration of time

required to commence the hold profile, and rather, the machine 100 operates in a closed loop mold holding pattern. So configured, molded parts have more consistent part sizes and appearances, as well as a uniform skin layer due to consistent heat transfer. Further, not only will particular parts have consistent dimensions, the hold profile helps to ensure reliability and consistency across a range of sizes of parts, which has been particularly challenging with respect to expanding crosslinking polymer articles. Further still, the hold profile provides better control over the injection process, allowing the part to dictate when the cavity is full and ready to be ejected. In some examples, using the hold profile can decrease the overall cycle time due to a reduced cure time. Additionally, the use of the hold profile can generate parts having more uniformity in cell structure due to free radical molecules becoming aligned. These parts will have minimal imperfections such as sink marks and/or swirls on the surface layer. As such, the hold profile makes a more consistent and stable dimensioned part, with consistent physical properties.

**[0052]** Those skilled in the art will recognize that a wide variety of modifications, alterations, and combinations can be made with respect to the above described embodiments without departing from the scope of the invention, and that such modifications, alterations, and combinations are to be viewed as being within the ambit of the inventive concept.

**[0053]** The patent claims at the end of this patent application are not intended to be construed under 35 U.S.C. § 112(f) unless traditional means-plus-function language is expressly recited, such as “means for” or “step for” language being explicitly recited in the claim(s). The systems and methods described herein are directed to an improvement to computer functionality, and improve the functioning of conventional computers.

What is Claimed is:

1. A method for determining whether an expanding crosslinking polymer part is ready to be ejected from a mold cavity during an injection molding cycle, the method comprising:

injecting molten expanding crosslinking polymer into a mold cavity;  
measuring at least one non-time dependent variable during the injection mold cycle;  
commencing a hold profile for the expanding crosslinking polymer part; and  
upon completing the hold profile, ejecting the part from the mold cavity.

2. The method of claim 1, wherein commencing the hold profile comprises:  
upon the measured at least one non-time dependent variables reaching a first threshold value, commencing the hold profile;

restricting additional molten expanding crosslinking polymer from being injected into the mold cavity; and

upon the measured at least one non-time dependent variables reaching a second threshold value, terminating the hold profile.

3. The method of claim 2, wherein the first threshold value is indicative of the mold cavity being substantially full of molten expanding cross linking polymer.

4. The method of any one of claims 2 or 3, wherein the second threshold value is indicative of the part being structurally sound.

5. The method of any one of claims 2-4, wherein the measured at least one non-time dependent variable comprises a cavity pressure value.

6. The method of claim 5, wherein the first threshold value comprises a nominal increase in cavity pressure.

7. The method of any one of claims 5 or 6, wherein the second threshold value comprises a substantially constant cavity pressure value over a period of time.

8. The method of any one of claims 2-7, wherein the measured at least one non-time dependent variable comprises a temperature value.

9. The method of claim 8, wherein the first threshold value comprises a nominal increase in cavity temperature.

10. The method of any one of claims 8 or 9, wherein the second threshold value comprises a substantially constant cavity temperature value over a period of time.

11. The method of any one of claims 1-10, wherein the hold profile is commenced at a substantially constant pressure.

12. An expanding crosslinking polymer injection molding system comprising:  
an injection molding machine comprising an injection unit and a mold forming a mold cavity, the injection unit adapted to receive and inject a molten expanding crosslinking plastic material into the mold cavity to form a molded part;  
a controller adapted to control operation of the injection molding machine; and  
one or more sensors coupled to the injection molding machine and the controller;  
wherein at least one of the one or more sensors is adapted to measure at least one non-time dependent variable during the injection mold cycle, wherein the controller is adapted to commence a hold profile for the expanding crosslinking polymer part and is further adapted to cause the molded part to be ejected from the mold cavity upon completing the hold profile.

13. The system of claim 12, wherein the controller commences the hold profile by commencing the hold profile when the measured at least one non-time dependent variable reaches a first threshold value, restricting additional molten expanding crosslinking polymer from being injected into the mold cavity, and terminating the hold profile when the measured at least one non-time dependent variables reaches a second threshold value.

14. The system of claim 13, wherein the first threshold value is indicative of the mold cavity being substantially full of molten expanding cross linking polymer.

15. The system of any one of claims 13 or 14, wherein the second threshold value is indicative of the part being structurally sound.

16. The system of any one of claims 13-15, wherein the measured at least one non-time dependent variable comprises a cavity pressure value.

17. The system of claim 16, wherein the first threshold value comprises a nominal increase in cavity pressure.

18. The system of any one of claims 16 or 17, wherein the second threshold value comprises a substantially constant cavity pressure value over a period of time.

19. The system of any one of claims 13-18, wherein the measured at least one non-time dependent variable comprises a temperature value.

20. The system of claim 19, wherein the first threshold value comprises a nominal increase in cavity temperature.

21. The system of any one of claims 19 or 20, wherein the second threshold value comprises a substantially constant cavity temperature value over a period of time.

22. The system of any one of claims 12-21, wherein the hold profile is commenced at a substantially constant pressure.

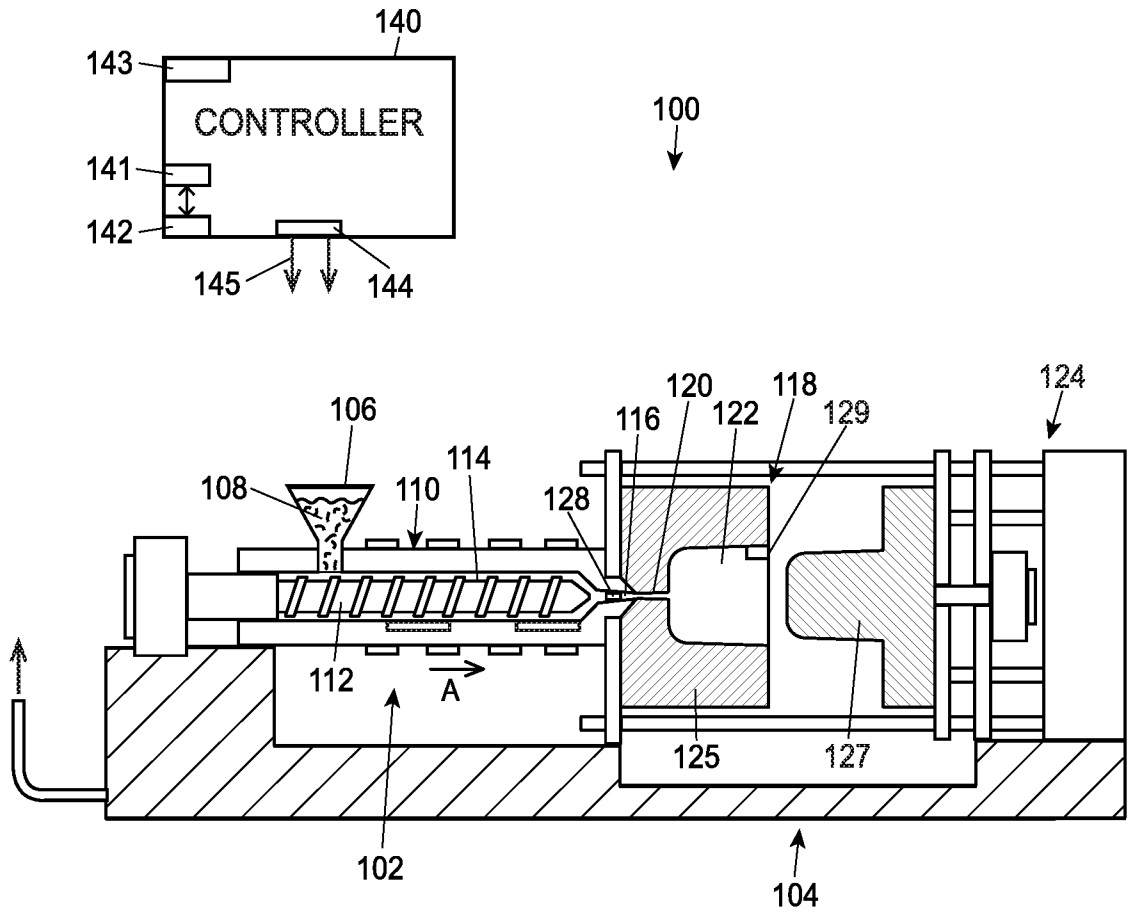


FIG. 1

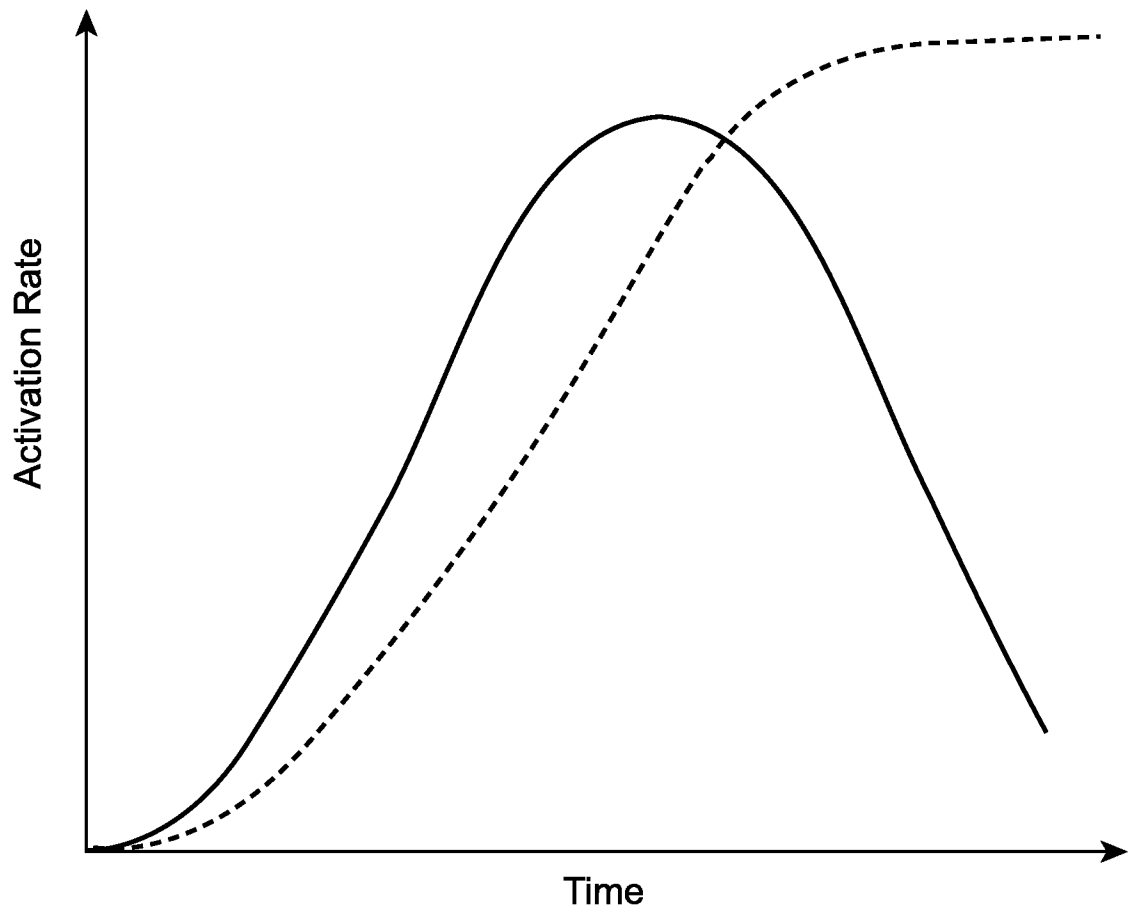


FIG. 2

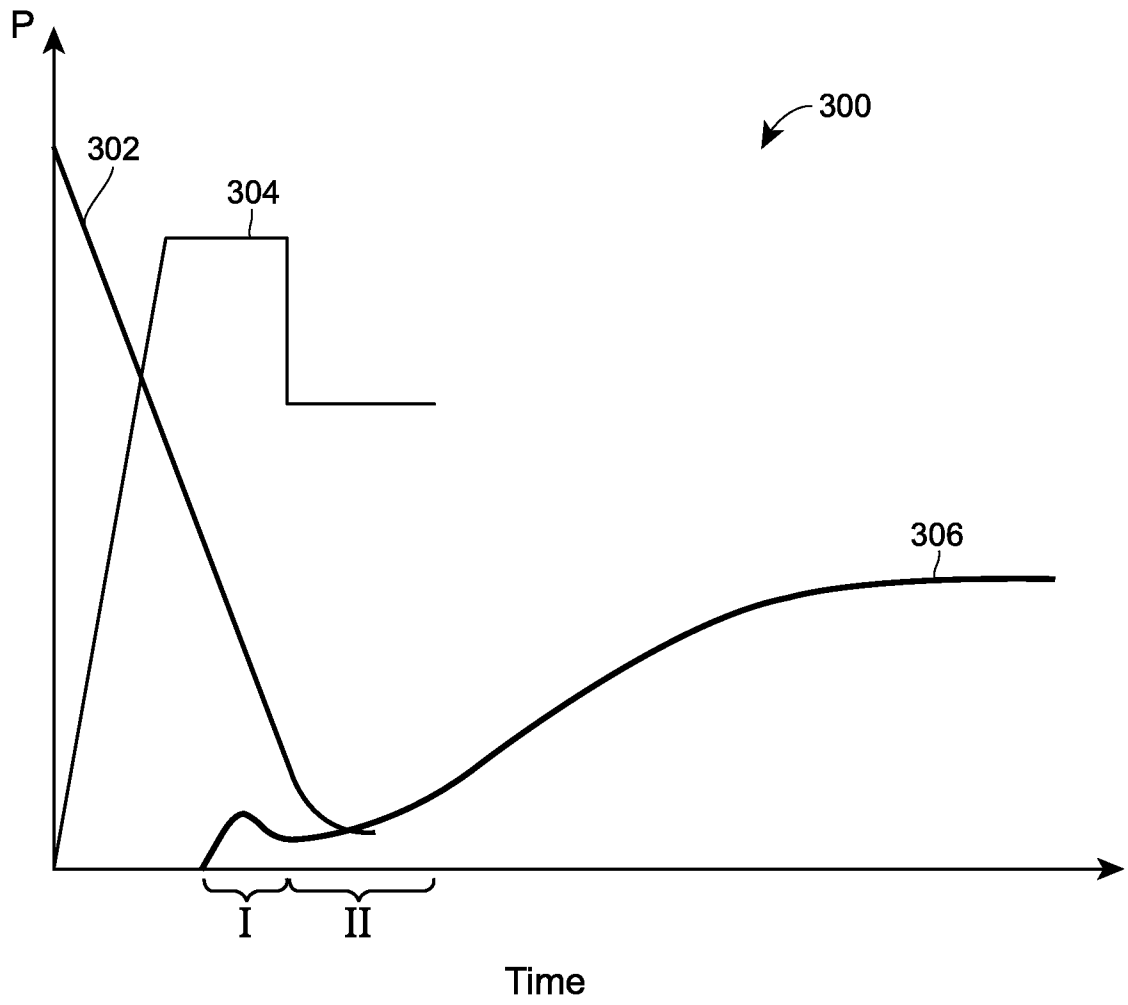


FIG. 3

**INTERNATIONAL SEARCH REPORT**

International application No  
PCT/US2018/036827

**A. CLASSIFICATION OF SUBJECT MATTER**  
 INV. B29C44/60 B29C45/77 B29C45/76 B29C45/78 B29K21/00  
 B29K23/00  
 ADD.  
 According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**  
 Minimum documentation searched (classification system followed by classification symbols)  
 B29C B29K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)  
 EPO-Internal, WPI Data

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 4 411 609 A (YOSHII MASAKI [JP] ET AL) 25 October 1983 (1983-10-25) column 3, line 65 - column 7, line 30; figures 2a-5	1-22
X	----- US 8 641 943 B1 (KIPE GEORGE [US] ET AL) 4 February 2014 (2014-02-04) column 7, line 4 - column 10, line 55; figures 1-17	1-22
X	----- US 4 767 579 A (BUJA FREDERICK J [US] ET AL) 30 August 1988 (1988-08-30) column 4, line 49 - column 7, line 18; figures 1-4	1-22
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Further documents are listed in the continuation of Box C.

See patent family annex.

\* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"E" earlier application or patent but published on or after the international filing date	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"O" document referring to an oral disclosure, use, exhibition or other means	"&" document member of the same patent family
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search <b>3 August 2018</b>	Date of mailing of the international search report <b>10/08/2018</b>
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Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016	Authorized officer <b>Horubala, Tomasz</b>
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## INTERNATIONAL SEARCH REPORT

International application No  
PCT/US2018/036827

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
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X	US 2016/311140 A1 (STIGSSON JERRY [SE] ET AL) 27 October 2016 (2016-10-27) paragraphs [0060] - [0092]; figures 1-11 -----	1-22
X	US 9 604 398 B2 (IMFLUX INC [US]) 28 March 2017 (2017-03-28) column 4, line 10 - column 9, line 10; figures 1-9 -----	1-22

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