



primasil
silicones



Benefits

- A relatively simple moulding technique
- Ideal for small quantities
- Excellent value for parts not requiring the precision of injection moulding

Limitations

- Non suitable for very large volumes
- Relatively labour intensive

Costs

- Influenced by the complexity of the part, required quality, material choice, and volumes
- Cost effective for small runs and prototyping
- Normally a trade off between cost of tool and part price

Contact details

For further assistance, please contact:

Primasil Silicones Ltd
Kington Road, Weobley,
Herefordshire UK
HR4 8QU

T: +44 (0)1544 312600

F: +44 (0)1544 312601

info@primasil.com

<http://www.primasil.com>

Compression Moulding

A piece of uncured rubber of specific size is placed between two halves of a pre-heated mould. The mould is then closed in a press under an overall pressure of around one ton per square inch. The rubber is heated by conduction from the mould surface, and cures to the shape of the cavity.

Applications

Primasil supplies compression moulded parts to every industry.

Quality

Manufactured in accordance with ISO9001:2000 quality standards. Excellent quality parts are achievable, but compression moulding typically results in some 'flashing'. Well designed mould tools can minimise this, and allow for 'tear trims', but parts frequently have to be hand finished. Dimensional tolerances for compression mouldings comply with BS 3734: Part 1:1997 (*see overleaf*). Higher tolerances may be possible.

Tooling

Bespoke steel tooling is recommended. The number of cavities is dependent on the size of the part, the volumes required, and the quality and tolerances demanded.

Prototypes & Samples

We would normally recommend that a prototype tool is commissioned to confirm product design and function. Depending on the product, an aluminium or resin prototype tool can produce thousands of parts. Normally single cavity moulds, the samples produced are more expensive than production parts, and quality is rarely as good as parts produced with production tooling.

Lead-times

Lead times are determined by the complexity and size of the mould, but can be reduced by having fully dimensioned electronic drawing files with the required tolerances at the earliest possible opportunity. If this is not possible, our engineers can work from your sketches and drawings or we can design your product based on what you tell us.