Abstract

Trial and error is usually used to find process parameter because it has not been standarrized so most of the hygiene cap silver bullet product which are processed with injection molding have defects in PT XYZ.

To handle that problem then used a approaching methode by comparing process parameters in the factory with process parameters theoretically. To get those process parameters by taking the data in the factory and then re-calculate it. After got those parameters then simulate the it with Moldflow Plastic Insight 5.0 and compares the defects appeared from those simulation.

From this experiment it got the sink mark defect with minimum injection process are injection temperature(Tmelt) = 245° C, holding pressure (Phold) = 5MPa, and cooling time(tcold) = 7 second, so sink index is 0.3746% . Smaller than sink index in the factory 0.7289% which is used as reference parameters process and to minimalize the defects appear

Key words: injection molding, product defects, sink marks, injection temperature, holding pressure, cooling time