PMMDA

GUIDE TO

MOULD

TEMPERATURE

CONTROL
Introduction
This document has been compiled by the PMMDA to provide plastics processors with a guide to mould temperature control and a code of practice against which mould temperature controller specification can be measured.

The Need for Mould Temperature Control
Mould temperature controllers are used to bring a connected mould (consumer) to an operating temperature, and maintain the set temperature by either heating or cooling.

The benefits are:
a. Preheating the mould to production temperature
b. Optimisation of the cycle time
c. Improves product finish
d. Reduced reject rate particularly during machine start up.

Glossary Terms
"Leak Stopper" Facility
Feature to either reverse the pump flow or use a venturi system, to allow the run to be finished before the lead in the mould is rectified.
A dedicated vacuum unit can also be used for a more permanent leak stop capability.
Introduction of air into the system via a solenoid valve.
Compressed air is also an option.

Mould Draining
Tank open to atmosphere - operates below 90°C for water and 130°C for oil.
Forced flow to facilitate operating temperatures up to 350°C for oil.

Open System
To facilitate operating temperatures above 90°C for water.

Closed System
Mixes cooling water directly in to the heat transfer fluid.
Heat exchanger between heat transfer fluid and cooling water.

Closed System (pressurised)
Pump immersed in process fluid tank on "open systems".

Direct Cooled
Pump used in closed system for oil and water. Output flow can be dependent on pressure.

Indirect Cooled
Lobe or gear pump usually used with oil. Must have a pressure relief valve.

Submersible Pump
Temperature measuring point of the system, installed in the unit.

Centrifugal Pump
Temperature measuring point of the system installed outside the unit - usually in the mould.

Positive Displacement pump
Operating temperature required at the process.

Temp. Sensor - Internal
Deviation from the set point temperature.

Temp. Sensor - External
A type of electrical connection to allow transfer of information/control to process machinery or other host computer.

Set Point
Alternative to serial interface, but with limitations. It allows control of the piece of equipment to be "handed over" host processing machine.

Set Point Tolerance
Mould, extruder barrel rolls etc.

Serial Interface

"Hard Wired Interface"

Consumer

Heat Transfer Fluids
WATER
Positive → Operating with water is more economical, cleaner and presents fewer problems. In the case of leaks in the temperature control circuit (e.g. hose couplings) water loss may be simply run into the drainage system without any further precautions (unless additives are included).

Negative → Water has a low boiling point. Depending on the water quality, there is the risk of corrosion and calcification of the system (temperature control unit and mould) which will eventually lead to a decrease in flow in the mould and to deterioration of heat exchange between the mould and the circulating water.

OIL
Positive → Thermal oils do not exhibit the disadvantages of water as mentioned above. As they have a far higher boiling point, they can be used for temperatures up to and above 350°C.

Negative → No corrosion and calcification of the temperature control circuit. Heat transfer efficiency is approximately one third that of water. Production of odours starting at 150°C in open systems. Tendency to "cracking" (property degradation). Flammable under certain conditions. Not particularly suitable for moulds with very small heating/cooling channels eg. 6mm dia. High fluid cost.
**Standard Units of Measurement**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Heat Capacity</td>
<td>kW</td>
</tr>
<tr>
<td>Temperatures</td>
<td>°C</td>
</tr>
<tr>
<td>Cooling capacity at “X” °C operating</td>
<td>kcal/hr</td>
</tr>
<tr>
<td>And “Y” °C Cooling Water</td>
<td>l/min</td>
</tr>
<tr>
<td>Pump capacity / Flow Rate</td>
<td>bar or m.head</td>
</tr>
<tr>
<td>Delivery Pressure</td>
<td></td>
</tr>
<tr>
<td>Total power consumption (inc. pump)</td>
<td>kW</td>
</tr>
<tr>
<td>Dimensions</td>
<td>mm</td>
</tr>
<tr>
<td>Weight</td>
<td>kg</td>
</tr>
<tr>
<td>Tank Capacity</td>
<td>litres</td>
</tr>
</tbody>
</table>

**Determination of the unit**

**Main Characteristics**

- Outlet Temperature max: °C
- Heat Transfer Fluid: Water/oil
- Heating Capacity: kW
- Cooling Capacity: kW
- - at outlet temperature: °C
  - - cooling water inlet temperature: °C
- Pump Capacity
  - - flow rate: l/min
  - - delivery head or pressure: m/bar
- Operating Voltage: V/Hz/Phases

NB: Flow rate should be specified at the corresponding pressure.

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**The selection of the temperature control unit depends on:**

- Material to be processed (determines mould temperature and type of heat transfer fluid)
- Weight of the mould (kg), required warming up time - for calculating head capacity.
- Material throughput (kg/h) - for calculating cooling capacity

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**Standard Calculations**

*How to calculate required heating capacity in kW*

\[ A \times (B-C) = \text{kcal/h} \]

\[ \text{Kcal/h} \div 860 = \text{kW} \]

\[ A = \text{net weight of mould (kg)} \times \text{specific heat capacity of mould material - see table A} \]

\[ B = \text{operating temperature of the mould (°C) - see table B} \]

\[ C = \text{initial temperature of the mould (°C)} \]

*How to calculate required cooling capacity in kcal/h*

\[ D \times E \times (F-G) = \text{kcal/hr} \]

\[ D = \text{throughput of raw material (kg/h)} \]

\[ E = \text{specific heat of raw material - see table A} \]

\[ F = \text{melt temperature of raw material (°C) - see table B} \]

\[ G = \text{operating temperature of the mould (°C) - see table B} \]

In practice, a safety factor of at least 1.2 is added to the above calculations to compensate for heat losses to the surroundings. It is necessary to state the "outlet temperature" to which the cooling capacity relates. "Cooling capacity as a function of fluid temperature" graph should be referred to in the manufacturers leaflet.

For determination of the "pump capacity", maximum values are not sufficient and the "characteristics curve of the pump" should be referred to in the manufacturers leaflet.

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**TABLE "A" Specific Heat Values**

<table>
<thead>
<tr>
<th>Material</th>
<th>Specific Heat (kcal/kg °C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>0.11</td>
</tr>
<tr>
<td>Aluminium</td>
<td>0.21</td>
</tr>
<tr>
<td>Brass</td>
<td>0.09</td>
</tr>
<tr>
<td>Water</td>
<td>1.00</td>
</tr>
<tr>
<td>Oil</td>
<td>0.45 (at 100°C)</td>
</tr>
<tr>
<td>LDPE</td>
<td>0.60</td>
</tr>
<tr>
<td>HDPE,PA,PP</td>
<td>0.48</td>
</tr>
<tr>
<td>ASA,PMMA,POM Copolymer</td>
<td>0.36</td>
</tr>
<tr>
<td>PP reinforced, PS,SAN,SB</td>
<td>0.36</td>
</tr>
<tr>
<td>ABS,PC,PVC Rigid</td>
<td>0.29</td>
</tr>
<tr>
<td>PET</td>
<td>0.30 - 0.55</td>
</tr>
</tbody>
</table>
### TABLE "B" Typical Processing Temperatures for Plastics

<table>
<thead>
<tr>
<th>Material</th>
<th>Abbreviation</th>
<th>Melt Temp °C</th>
<th>Mould Temp °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Acrylonitrile Butadiene Styrene</td>
<td>ABS</td>
<td>240-280</td>
<td>50-80</td>
</tr>
<tr>
<td>Styrene Acrylonitrile</td>
<td>SAN</td>
<td>200-270</td>
<td>40-80</td>
</tr>
<tr>
<td>Acrylate Styrene Acrylonitrile</td>
<td>ASA</td>
<td>240-280</td>
<td>40-80</td>
</tr>
<tr>
<td>ASA/PC Blend</td>
<td>ASA+PC</td>
<td>260-300</td>
<td>60-90</td>
</tr>
<tr>
<td>Poly Methylene Methacrylate</td>
<td>PMMA</td>
<td>200-260</td>
<td>50-80</td>
</tr>
<tr>
<td>Low Density Polyethylene</td>
<td>LDPE</td>
<td>170-240</td>
<td>10-40</td>
</tr>
<tr>
<td>Polypropylene</td>
<td>PP</td>
<td>200-270</td>
<td>10-40</td>
</tr>
<tr>
<td>High Density Polyethylene</td>
<td>HDPE</td>
<td>180-270</td>
<td>10-40</td>
</tr>
<tr>
<td>Polystyrene</td>
<td>PS</td>
<td>180-260</td>
<td>10-40</td>
</tr>
<tr>
<td>Nylon 6.6</td>
<td>PA 66</td>
<td>280-300</td>
<td>40-80</td>
</tr>
<tr>
<td>PA 66 + GF</td>
<td>285-310</td>
<td>80-120</td>
<td></td>
</tr>
<tr>
<td>Nylon 6</td>
<td>PA 6</td>
<td>230-290</td>
<td>40-80</td>
</tr>
<tr>
<td>PA 6 + GF</td>
<td>260-290</td>
<td>80-120</td>
<td></td>
</tr>
<tr>
<td>Polyacetal</td>
<td>POM copolymer</td>
<td>180-230</td>
<td>60-120</td>
</tr>
<tr>
<td>Polybutylene Terephthalate</td>
<td>PBTP</td>
<td>245-270</td>
<td>60-80</td>
</tr>
<tr>
<td>Polyether Sulphone</td>
<td>PES</td>
<td>320-360</td>
<td>140-160</td>
</tr>
<tr>
<td>Polysulphone</td>
<td>PSU</td>
<td>310-360</td>
<td>120-160</td>
</tr>
<tr>
<td>Polycarbonate</td>
<td>PC</td>
<td>280-310</td>
<td>80-120</td>
</tr>
<tr>
<td>Polyvinyl Chloride (rigid)</td>
<td>PVC</td>
<td>170-210</td>
<td>20-50</td>
</tr>
</tbody>
</table>

GF= Glassed Fibre  PMMDA Guide only. Consult material supplier for details

### Connections to the Mould

The following hose recommendations are made on the basis of safety in operation and should be confirmed as suitable by the hose supplier.

1. Water up to 90 °C  
   Oil up to 120 °C  
   High Temperature, fabric reinforced rubber hose
2. Water up to 200 °C  
   Oil up to 250 °C  
   PTFE, stainless steel braided hose
3. Oil up to 350 °C  
   All stainless steel flexible hose

Note: to ensure optimum flow rates, the use of reducing adapters on hoses is not recommended.

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**OPEN TANK SYSTEM (water or oil)**

**CLOSED TANK SYSTEM (presumed water)**

The **"GUIDE TO .. " series are produced by**

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