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**Tools for moulding — Thermal insulating  
sheets for injection moulds**

*Outillage de moulage — Feuilles d'isolation thermique dans les moules  
d'injection*

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ISO 15600:2000

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this International Standard may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 15600 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

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# Tools for moulding — Thermal insulating sheets for injection moulds

## 1 Scope

This International Standard lays down the basic dimensions and tolerances, in millimetres, of type A and B thermal insulating sheets for plastic and rubber moulds. Thermal insulating sheets are used in applications where heat transmission between injection mould and machine platen has to be reduced. This International Standard also gives material guidelines and design requirements, and specifies the designation of the insulating sheets.

The dimensions of the sheets have been chosen to match those of mould plates specified in ISO 6753-2. For type B sheets measuring 156 mm × 156 mm and larger, the diameter of the hole has been chosen to match the fitting diameter ( $\varnothing$  90 mm) of locating rings.

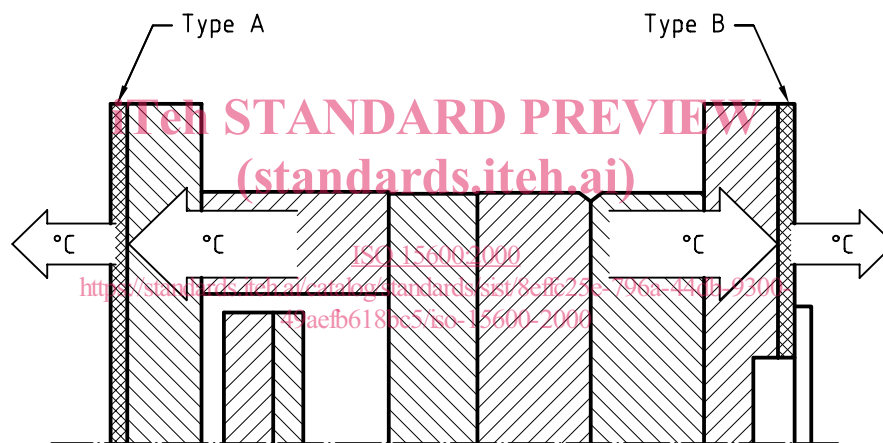


Figure 1 — Example of mounting of thermal insulation sheets

## 2 Dimensions

See Figures 2 and 3 and Table 1.

For type B thermal insulating sheets, where  $w \times l$  is smaller than 156 mm × 156 mm, the diameter of the hole is left to the manufacturer's discretion.

Dimensions in millimetres

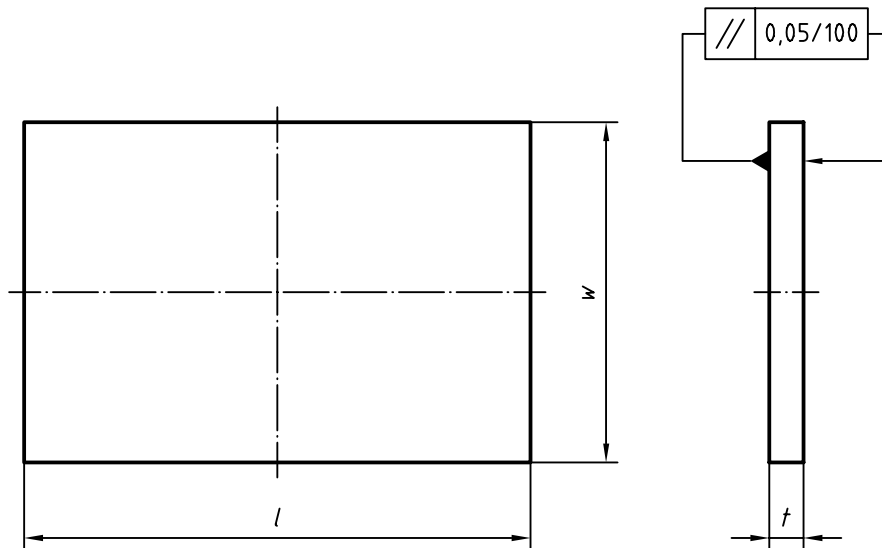


Figure 2 — Type A thermal insulating sheet

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Dimensions in millimetres

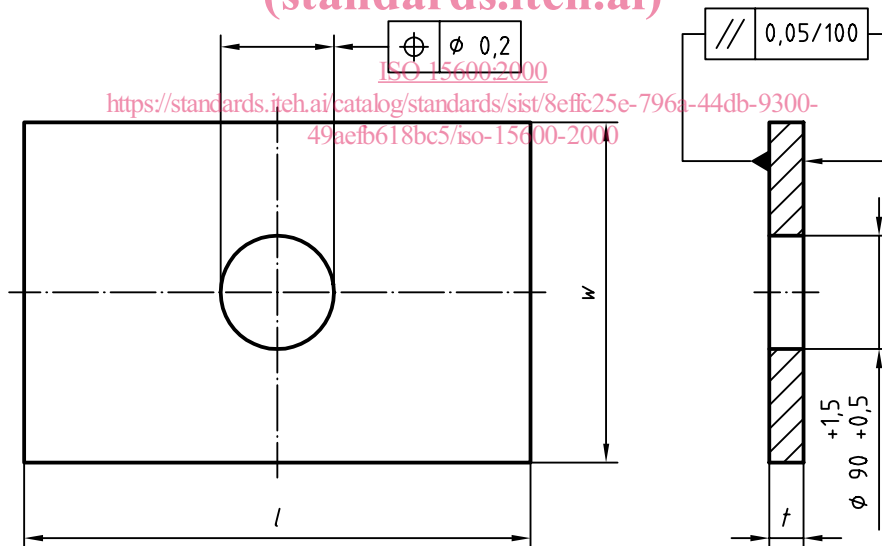


Figure 3 — Type B thermal insulating sheet

Table 1 — Dimensions of type A and B thermal insulating sheets

Dimensions in millimetres

Dimensions			Dimensions			Dimensions		
<i>w</i>	<i>l</i>	<i>t</i>	<i>w</i>	<i>l</i>	<i>t</i>	<i>w</i>	<i>l</i>	<i>t</i>
-2,0 -2,5	-2,0 -2,5	-0,2 -0,4	-2,0 -2,5	-2,0 -2,5	-0,2 -0,4	-2,0 -2,5	-2,0 -2,5	-0,2 -0,4
96	× 96 × 120	6	310	× 310 × 350 × 396 × 446 × 496 × 556 × 626	6 and 10	556	× 556 × 626 × 706 × 796 × 896 × 996 × 1 116	10
120	× 120 × 156	6	350	× 350 × 396 × 446 × 496 × 556 × 626 × 706	6 and 10	626	× 626 × 706 × 796 × 896 × 996 × 1 116	10
156	× 156 × 196 × 220 × 246 × 276 × 310	6	396	× 396 × 446 × 496 × 556 × 626 × 706	6 and 10	706	× 706 × 796 × 896 × 996 × 1 116	10
196	× 196 × 220 × 246 × 276 × 310 × 350 × 396	6	446	× 446 × 496 × 556 × 626 × 706 × 796 × 896	6 and 10	796	× 796 × 896 × 996 × 1 116	10
220	× 220 × 246 × 276 × 310 × 350	6	496	× 496 × 556 × 626 × 706 × 796 × 896	6 and 10	896	× 896 × 996 × 1 116	10
246	× 246 × 276 × 310 × 350 × 396 × 446 × 496	6	556	× 556 × 626 × 706 × 796 × 896	6 and 10			
276	× 276 × 310 × 350 × 396 × 446 × 496 × 556	6						

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### 3 Material

The type of material is left to the manufacturer's discretion.

### 4 Design requirements

The compressive strength shall be a minimum of 170 N/mm<sup>2</sup> at 140 °C, and a minimum of 100 N/mm<sup>2</sup> at 200 °C.

The coefficient of thermal conductivity,  $\lambda$ , shall be at maximum 0,3 W/mK.

### 5 Designation

Thermal insulating sheets according to this International Standard shall be designated by:

- a) "Thermal insulating sheet";
- b) a reference to this International Standard, i.e. ISO 15600;
- c) the type (A or B);
- d) the length,  $l$ , in millimetres;
- e) the width,  $w$ , in millimetres;
- f) the thickness,  $t$ , in millimetres.

EXAMPLE A thermal insulating sheet of type A, of length,  $l = 96$  mm, width,  $w = 96$  mm and with thickness,  $t = 6$  mm is designated as follows:

**Thermal insulating sheet ISO 15600 A - 96 × 96 × 6**

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## Bibliography

- [1] ISO 6753-2:1998, *Tools for pressing and moulding — Machined plates — Part 2: Machined plates for moulds.*

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