



Designation: D1896/D1896M – 10

Standard Practice for Transfer Molding Test Specimens of Thermosetting Compounds¹

This standard is issued under the fixed designation D1896/D1896M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This practice covers a general procedure for the transfer molding of mechanical and electrical test specimens of thermosetting molding materials.

NOTE 1—The utility of this practice has been demonstrated for the molding of thermosetting molding compounds exhibiting intermediate viscosity non-Newtonian flow.

1.2 The values stated in either SI or inch-pound units are to be regarded separately as standard. The values stated in each system are not always exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems can result in nonconformance with this practice.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 2—There is no known ISO equivalent to this standard.

2. Referenced Documents

2.1 *ASTM Standards:*²

[D883 Terminology Relating to Plastics](#)

[D957 Practice for Determining Surface Temperature of Molds for Plastics](#)

[D3123 Test Method for Spiral Flow of Low-Pressure Thermosetting Molding Compounds](#)

[D3795 Test Method for Thermal Flow, Cure, and Behavior Properties of Pourable Thermosetting Materials by Torque Rheometer](#)

3. Terminology

3.1 Definitions:

¹ This practice is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.09 on Specimen Preparation.

Current edition approved Aug. 1, 2010. Published September 2010. Originally approved in 1961. Last previous edition approved in 2009 as D1896 - 09. DOI: 10.1520/D1896_D1896M-10.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

3.1.1 *General*—Definitions of terms applying to this practice appear in Terminology [D883](#).

3.1.2 *transfer molding, n*—a method of forming articles by fusing a plastic material in a chamber and then forcing essentially the whole mass into a hot mold where it solidifies.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *breathing, v*—the operation of opening a mold or press for a very short period of time at an early stage in the process of cure.

3.2.1.1 *Discussion*—Breathing allows the escape of gas or vapor from the molding material and reduces the tendency of thick moldings to blister.

3.2.2 *cavity (of a mold), n*—the space within a mold to be filled to form the molded product.

3.2.3 *clamp pressure, n*—the pressure applied to the mold to keep it closed, in opposition to the fluid pressure of the compressed molding material.

3.2.4 *fill time, n*—the time required to fill each cavity used in the mold. Fill times can be critical to well molded parts (see [Note 3](#) under 4.4).

3.2.5 *minimum plunger pressure, n*—the minimum pressure, on the ram, required to just fill each cavity used in the mold at a specified temperature and reasonable fill time.

3.2.6 *vent, n*—a hole, slot, or groove provided in a mold or machine to allow air and gas to escape during molding, extrusion, or forming.

4. Significance and Use

4.1 Transfer molding is particularly suited to thermosetting materials of intermediate plasticity. Fixed molding parameters cannot be specified for each type of material. Molding compounds of the same type come in many different plasticities measured in accordance with Test Methods [D3123](#) and [D3795](#). Consequently, for a given material type, the molding parameters required to produce satisfactory test specimens will often vary dependent on the plasticity of the specific material grade.

4.2 The mold shown in this practice provides for a set of five specimens. However, if only certain specimens are desired, the other cavities can be blocked by inserting gate blanks.

*A Summary of Changes section appears at the end of this standard

4.3 Typically, breathing of the mold is not required to release trapped volatile matter as the gas is free to flow from the vent end of the mold. This is a particular advantage for heat-resistant compounds and reduces the tendency for molded specimens to blister at high exposure temperatures.

4.4 Flow and knit lines in a molded piece are often sites of mechanical or electrical weakness and can be found in some degree of severity throughout the molded piece. The semisolid molding compound passing through the gate is subject to non-Newtonian flow and, consequently, wrinkles and folds as it travels down the mold cavity. Fibers and other reinforcements in the molding compound align with the flow pattern and, consequently, can orient perpendicular to the axis of the bar at the center and parallel at the surface of the bar. Mold temperature, thermal conductivity and plasticity of the molding compound, degree of preheat, and plunger pressure are parameters that influence the time to fill the mold cavities and the formation of knit lines.

NOTE 3—If the temperature of the mold is held constant and the plunger pressure varied for a designated thermosetting molding compound, two extreme characteristic conditions can be obtained. If the pressure is low, then the vent end of the cavity will not fully fill, and weld lines will form by incomplete knitting of the material. If the pressure is too high, the mold cavity will fill fast, the outside of the specimen will case harden while the pressure is still forcing material out the vent, and a ball-and-socket grain structure will be obtained. A ball-and-socket structure is an indication of the molding condition, and lower test data will result.

4.5 Thermosetting compounds containing long-fiber fillers such as glass roving, chopped cloth, or shavings can be used but are not recommended for transfer molding. These filler materials tend to break, tear, or ball in passing through the gates of the mold, thereby not optimizing their potential strength.

4.6 The Izod impact strength of transfer molded specimens of molding compounds containing short fibers will generally be lower than the values obtained using compression-molding methods. Quite often the impact strength will vary along the axis of the bar due to molding parameters, flow pattern, and fiber orientation.

4.7 The flexural and tensile strength of transfer molded specimens of molding compounds containing short fibers will generally be higher than the values obtained using compression-molding methods. Flexural tests are particularly sensitive to transfer molding due to the thin resin skin formed at the surface of the bar during the final filling of the cavity and pressure buildup.

5. Apparatus

5.1 *Press*—A hydraulic press designed to develop and maintain accurately any desired pressure between 7 and 85 MPa [1000 and 12 000 psi] on the plunger to ± 1 MPa [± 150 psi] and have a minimum plunger loading capacity of 230 cm³ [14 in.³] (see **Note 4**). The clamp pressure shall be at least 20 % higher than the plunger pressure.

NOTE 4—Plunger molding pressure under actual molding conditions is a variable that is difficult to control. Pressure standardization should be carried out on an empty cavity with the plunger against the mold-stop plate. The speed of the moveable platen is not important as the mold is

closed before the plunger operates. A ram speed of 3.6 m/min [140 in./min] and a plunger speed of 2.2 m/min [85 in./min] have been found satisfactory when the mold is not loaded. The plunger speed is subject to the flow properties of the molding material when the plunger cavity is loaded with molding compound.

5.2 *Mold*—A five-cavity mold similar to that shown in **Fig. 1** has been found satisfactory, although molds with fewer cavities or different configurations of the tension specimen can be used. Specimens can be eliminated by blocking the runners to particular cavities and reducing injection pressure and shot size accordingly. The gates for each of the cavities in this mold are 6.4 mm wide by 1.52 mm deep [$\frac{1}{4}$ by 0.060 in.]. Suitable venting must be provided from each cavity. A cavity surface finish of SPI-A3 is recommended³, as is chrome plating of the mold surface.

NOTE 5—Although the mold shown is generally useful, it is preferred to use a multiple-identical-cavity mold with a symmetrical layout of runners and cavities. In either case, it is important to describe the mold in the report on the specimen preparation.

5.3 *Heating System*—Any convenient method of heating the press platens and plunger cavity can be used, provided the heat source is constant enough to maintain the mold and plunger temperature within $\pm 3^\circ\text{C}$ [$\pm 5^\circ\text{F}$].

5.4 *Temperature Indicator*—Typically, a surface pyrometer is used to measure the temperature of the mold surface as specified in Practice **D957**.

5.5 *Preforming*—Any preforming equipment or press can be used that will provide a satisfactory preform of material for the plunger and ease of handling in the electronic preheater.

6. Conditioning

6.1 Molding compounds are generally preformed, electronically preheated, and molded from the compound in the as-received condition.

6.2 Condition molding compounds known to contain a high percentage of moisture for 30 min at $90 \pm 3^\circ\text{C}$ [$194 \pm 5^\circ\text{F}$] in a forced-draft oven and preform immediately afterward. A maximum depth of 15 mm [0.6 in.] is recommended for the molding compound in the oven tray. Store the preformed material in a desiccator over anhydrous calcium chloride at room temperature until ready to preheat and mold.

6.3 In the case of a referee test, prepare the preform material as indicated in **6.2**.

7. Procedure

7.1 Choose and set the temperatures of the mold and plunger cavity based on the manufacturer's recommendation, the relevant material specification, or previous experience with the particular type of material being used and its plasticity. Typically, the temperature will be in the range from 150 to 175°C [302 to 347°F].

³ The sole source of supply of the mold comparison kits known to the committee at this time is The Moldmakers Division of the Society of the Plastics Industry, Inc., 1667 K St., NW, Suite 1000 - Washington, DC 20006. If you are aware of alternative suppliers, please provide this information to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee¹, which you may attend.