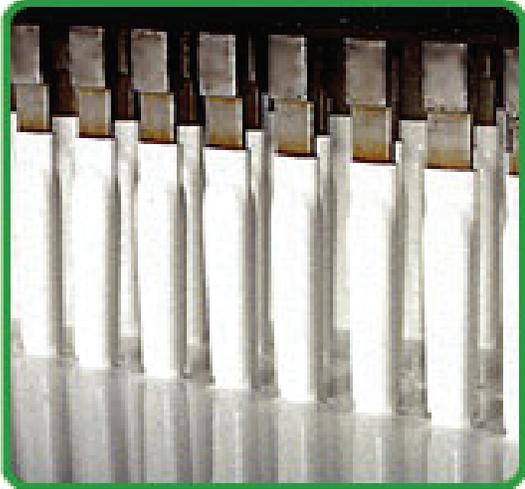


How To Use Plastisol For Dip Molding Applications

Dip molding has grown into a high-tech manufacturing process that competes head-to-head with other plastic and rubber molding processes. In its basic form, dip molding involves the following:



- the heating of a metal mold
- immersing or dipping the heated mold into the liquid plastisol
- extracting the mold from the liquid and curing it using heat
- cooling the dipped parts and stripping them from the molds

More Specifically

1. Heating of a metal mold:
 - Begin with an oven temperature of 380 to 400 degrees F
 - Preheat the metal until it reaches a temperature of 340 to 350 degrees F
2. Dipping the heated metal mold:
 - Dip the heated metal into the plastisol for 20 to 30 seconds
 - The heat causes the plastisol to build or gel onto the mold
3. Return the plastisol coated metal mold to the oven for four to five minutes for curing
4. Allow mold and parts to cool before stripping

Note: All times and temperatures can be varied to get the desired results, e.g., for thicker walls, raise the temperature when heating the metal and/or leave the mold in the liquid plastisol longer.



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