

CB Mold Start-Up Program

PROGRAM DESCRIPTION

Dura-Cast Products is a full service rotomolding facility with on-site rotomold manufacturing for many plastic resin materials, CNC router, poly-foaming capabilities, simple and complex secondary finishing operations, packaging, shipping, product concept design, rotomolding consulting services, mold design, and our own full service stainless steel fabrication facility. We do not build cast aluminum molds on site, but contract them to tooling shops with which we have long-standing relationships.

We understand that some customers want to be able to pick and chose the services that they require, mold fabrication being one of them. To better facilitate customer-based mold fabrication, Dura-Cast has a set of guidelines, which will help ensure that a mold can be successfully rotomolded and produce a product of acceptable quality.

MOLD FABRICATION PREREQUISITES

The quality of the product is directly related to the quality of the mold. All customer-based mold fabrication must include the basic requirements for rotomolding:

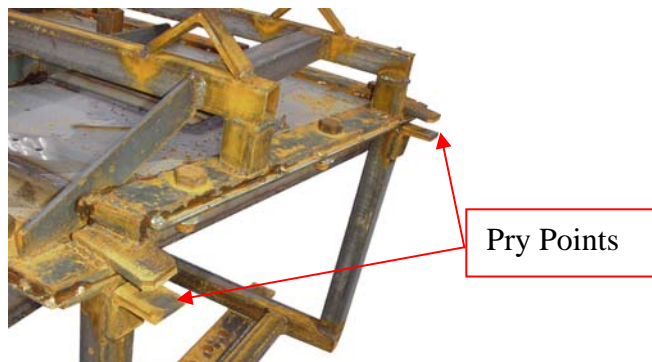
- Mold accurately represents the desired product
- Mold includes appropriate plastic and mold shrinkage factors
- Provisions are made for undercuts
- Internal mold finishing provides acceptable product finish
- Unusual requirements have been discussed with a rotomolding professional and acceptable solutions are available e.g. different wall thicknesses in the same product, de-molding issues, required cooling fixtures, close tolerances, molded in inserts and logos, draft angles, etc.
- Tight parting line with less than 0.010 inch gap
- Vent hole appropriately sized and located
- Pry points are located at strategic points to separate mold
- Lift rings are located for balanced mold handling and mold separation
- Appropriate frame positioning for mold rotation requirements, heat absorption and center of gravity balance
- Forklift slots for handling and transport
- Mold frame feet for stable mold storage

DURA-CAST REQUIREMENTS

Mold Material: 12 ga. stainless steel

Mounting frame: See mounting rails drawing

Parting line flanges: 3/8" x 2" carbon steel with 3/4" bolt holes, or hold-down clamps, 8" on center



Framed Mold -
Ready to be Mounted



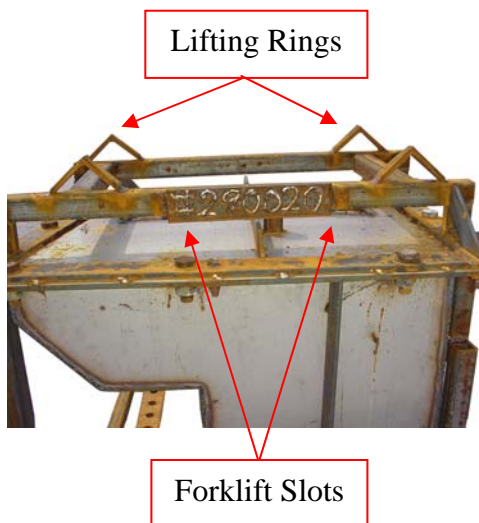
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MOLD INSPECTION

When the mold arrives at Dura-Cast, one of our engineers will inspect it to verify that all of the prerequisites and Dura-Cast requirements have been met. If there are any questions or problems, we will notify the customer and await instructions before proceeding.

1ST ARTICLE PRODUCTION

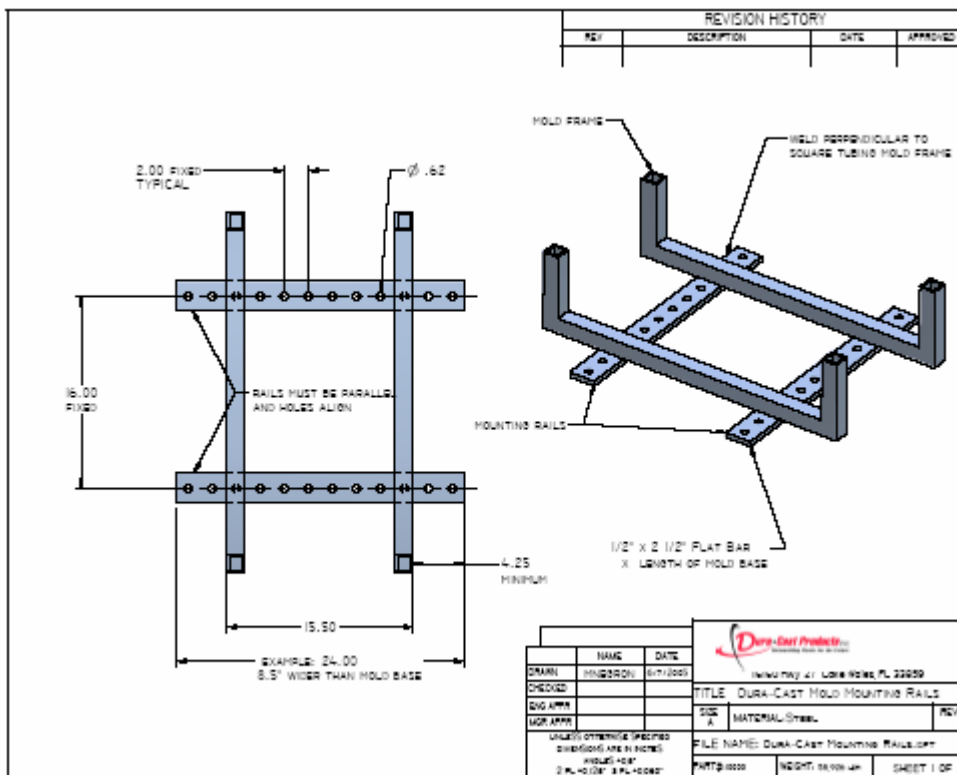
Each mold and its product present a unique set of parameters and variables - cool or hot areas of the mold, biaxial rotation adjustments, type of resin, cook, air cool and water cool times, release agents, and de-molding are just a few. The first articles to come out of the mold are usually not acceptable and provide valuable information about what adjustments must be made to correct the procedures. Sometimes, the mold requires additional refinement – insulating specific areas or adding heating ribs are two. Dura-Cast will keep the customer informed about the progress of the 1st Article. We will notify a customer if additional expenses are required to rectify issues that are only revealed during the actual rotomolding process.



Generally, after a few samples have been run, an acceptable 1st Article is produced. This 1st Article should meet all of the product specifications, and the mold is now ready for full production manufacturing.

Please contact Dura-Cast Products if you want to build a mold for your rotomolded plastic product. We can either build it for you, or provide guidelines that will help ensure that your customer-based mold fabrication project is successful. Call to request a price quote for the CD Mold Start-Up Program.

MOLD MOUNTING RAILS



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