

Texture Number	Min. Draft Required	Texture Depth (In.)
11000	1.5	0.00040
11010	2.0	0.00100
11020	3.0	0.00150
11030	3.5	0.00200
11040	5.0	0.00300
11050	7.0	0.00450
11060	5.0	0.00300
11070	5.0	0.00300
11080	3.5	0.00200
11090	6.0	0.00350
11100	9.5	0.00600
11110	4.5	0.00250
11120	3.5	0.00200
11130	4.5	0.00250
11140	4.5	0.00250
11150	4.5	0.00275
11160	6.5	0.00400
11200	5.0	0.00300
11205	4.5	0.00250
11210	6.0	0.00350
11215	7.0	0.00450
11220	8.0	0.00500
11225	7.0	0.00450
11230	4.5	0.00250
11235	6.5	0.00400
11435	15.5	0.01000

TEXTURE DEPTH AND SIDEWALL DRAFT CONSIDERATIONS:

Henry Plastic Molding has prepared the table to the left based on Mold-Tech guidelines. Refer to Mold-Tech at www.mold-tech.com or call the Mold-Tech support number at 630-235-8948 for more information. Engineers at HPMI are also available if needed.

To assure clean ejection of your part with no scuffing, use a simple rule for determining draft:

- 1.5 – 2 degrees of draft per .001” in texture depth

This rule is for sidewalls of the tool that the part will shrink away from. Areas in the tool that the part will shrink toward will require more draft. Lifters, slides, cams, and other tooling components should have their texturing draft requirements evaluated based on their action as they move away from the part. Shut-off conditions on textured sidewalls may also be affected by the texture depth / tool draft relationship. Texture depth can be reduced in specific areas and/or the texture pattern can be ‘softened’ on surfaces where there are ejection concerns. Part design, part size, molding materials, texture construction, and other molding factors have a significant impact on ejection issues.

Standard tool materials such as P-20, H-13, S-7, 01, A1, A2, A6, 420 stainless, beryllium copper, kirksite, forged, wrought and cast aluminums have all been textured successfully.

Equivalent textures are available and often provide excellent comparison to the actual Mold-Tech textures, while saving significant cost and mold build time. Use of an equivalent texture should be determined and decided by the customer, not the mold maker.

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General guideline only: No information supplied provides a warranty, expressed or implied, regarding the suitability of the suggested design methods. Customer retains all responsibility for correct designs and part performance

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