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(57) Sammendrag:
The present invention relates to a mould device adapted for use in a reaction injection moulding machine, in particular for the moulding of flashless parts, and to a method of moulding flashless parts. In particular a mould device adapted for use in a reaction injection mould for production of window sashes or frames by injection of reaction injection mould-processable material is provided, comprising a first mould part, and a second mould part adapted for defining a mould cavity and a parting line with said first mould part, wherein at least one of said mould parts has at least one recess adapted for receiving at least one pressure absorbing insert arranged externally to the mould cavity and adjacent to the parting line of said mould cavity.

Fortsættes...

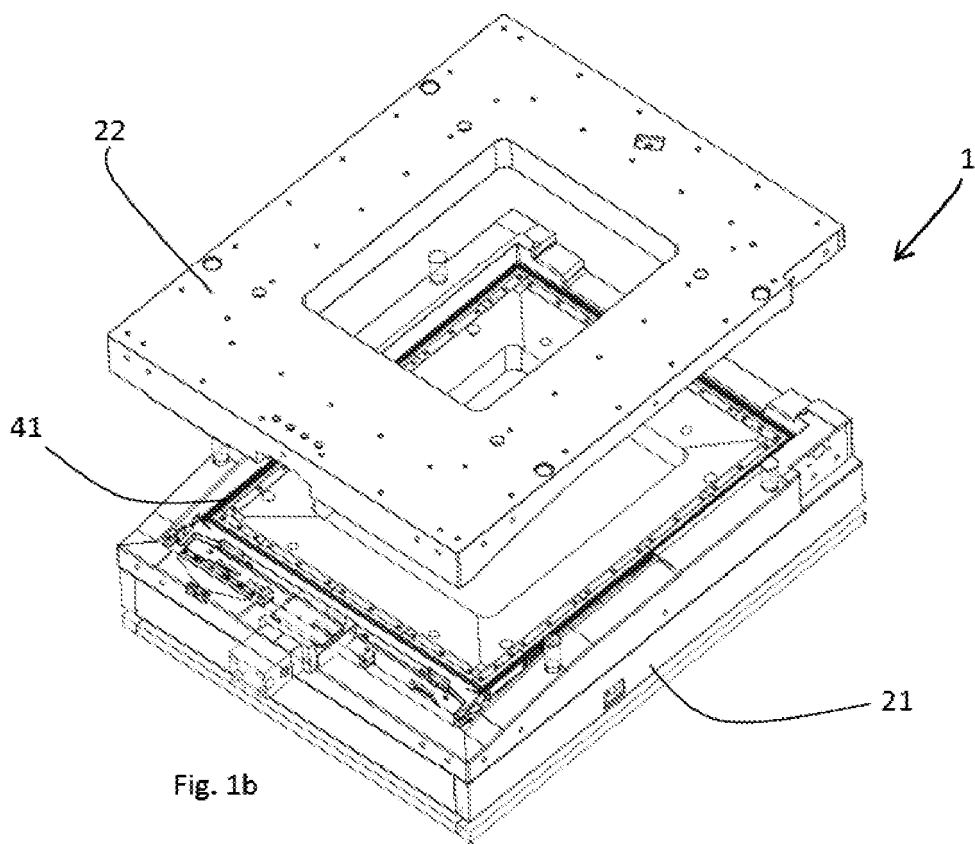


Fig. 1b

Title of Invention

Injection moulding device and method

Technical Field

The present invention relates to a mould device adapted for use in a reaction
5 injection moulding machine, in particular for the moulding of flashless parts,
and to a method of moulding flashless parts.

Background Art

Flash is a thin fin of material formed on a moulded article where, in the partic-
ular case of reaction injection moulding, some of the moulding material has
10 been forced through gaps present due to imperfections created on the faces
of the moulding parts during manufacture, or through gaps between moulding
parts caused by the presence of a substrate placed within the mould and on
which the moulding is to be carried out. This moulding material may cure
along with the curing of the moulded article, resulting in an undesirable solid
15 protrusion along the side of the moulded element. Such flash is cumbersome
in most cases, for example in the case of a moulded element intended for
mechanical applications as the flash may result in the part not fitting into its
intended location or preventing it from fulfilling its intended function due to
imperfect contact between elements. Flash formation may also often result in
20 complications of aesthetic nature, as the moulded article will require addition-
al processing to achieve the intended surface finishing. Trimming of flash may
be carried out using several methods including stripping with a mechanical
operator during the moulding process, using rotating knives or disk sanders,
or by freezing and subsequent shearing. In any case, the removal of flash
25 from moulded elements is a costly process, as it lengthens the article produc-
tion time and increases the labour required to obtain a satisfactory final prod-

uct. Further, the formation of flash may result in considerable waste of material, leading to an additional unnecessary expense causing production costs to increase, especially in the case of large moulded elements.

Efforts to avoid entirely the occurrence of flash in reaction injection moulding
5 have been made. The concept of a "flashless" mould that includes a mould plate with weakened sections, which flex or provide a diaphragm action when the mould is subjected to pressure so as to pinch off the mould cavities where the mould faces come together is well known. US2962761 and US3121918 for instance, both disclose moulds comprising base pieces that will flex under
10 the clamping pressure applied.

In more detail, US3121918 discloses a press plate in conjunction with a deformable mould-supporting diaphragm against which multi-plate, multi-cavity type moulds may be clamped for the moulding of rubber parts. When pressure is applied, the plates can easily flex and conform to the pressure applied
15 by the diaphragm. Plate flexibility permits the diaphragm to close up on gaps so as to compensate for manufacturing tolerances of the moulds and to thereby ensure the application of a uniform damping force to all the mould parts and avoid flash on the moulded element.

US4372740 relates to a moulding apparatus comprising an upper mould and
20 a lower mould, wherein fluid substance is filled below the lower mould thereby making the lower mould floatable on the fluid substance and movable along the lower holding means, thus realising a perfect joint between the upper mould and the lower mould, while compensating for mould production imperfections due to a back pressure of the fluid substance.

25 US2883704 describes an injection moulding apparatus comprising separable first and second units that are disposed one against the other defining a plurality of cavities, a hollow member in which mouldable material can be confined, and a piston for forcing the mouldable material in the hollow member

into the cavities through a sprue plate. Around the bottom edge of said first unit a member presents a flange, which extends inwardly from the wall of the hollow member. The flange has a certain amount of flexibility which permits it to flex under the mould pressures to form a tight seal with the upper surface
5 of the sprue plate. This tight seal, together with the fact that a part of the mouldable material flows over the face of the flange prevents any of the mouldable material from being ejected between the flange and the sprue plate as flash.

These solutions, however, all beget disadvantages. US3121918, US2883704
10 and US4372740 are designed for moulding multiple moulded articles simultaneously and the solution disclosed therein is therefore not appropriate for the moulding of single, large flashless product. Both US2962761 and US3121918 include mould plates that provide a diaphragm action when the mould is subjected to pressure, and thus are based on the principle of equalizing pressure
15 across the face of the mould and require pressure distributing means, such as a pressure distributing pad or a capsule / mould-supporting unit and pressure distributing and equalising means, which are additional parts that accumulate wear and shorten the overall lifespan of the injection moulding device.

US 4688752 A discloses a reaction injection mould for production of a gasket
20 around a glazing unit.

Summary of Invention

It is therefore an object of the present invention to provide an alternative mould device with a simple, durable design adapted for use in a reaction injection mould for production of flashless window sashes or frames, by pro-
25 cessing reaction injection mould-processable material.

This and other objects are achieved by an injection mould device according to a first aspect of the invention, and a method of producing flashless window sashes and frames according to a second aspect of the invention.

According to the first aspect of the present invention, there is provided a
5 mould device adapted for use in a reaction injection mould for production of window sashes or frames by injection of reaction injection mould-processable material, comprising at least one pressure absorbing insert , a first mould part, and a second mould part, the second mould part is adapted for defining a mould cavity and a parting line with said first mould part, wherein at least
10 one of said mould parts has at least one recess in which the at least one pressure absorbing insert is received, said at least one pressure absorbing insert (6) being arranged externally to the mould cavity and adjacent to the parting line of said mould cavity.

By a pressure absorbing insert, it is understood that the pressure transferred
15 by the mould-processable material when being injected into the cavity will be at least partially absorbed by elastic deformation of said insert. By the elastic deformation, the pressure absorbing insert counters the pressure transferred by said injected material. The pressure described will eventually cease, at which point the insert will regain its initial shape ready for a new moulding
20 procedure. In the context of the invention, elastic deformation may typically be of less than 0.5mm, such as 0.1mm or less, such as 0.01mm or less.

Such pressure may occur frequently at the parting lines of the two generally contacting mould parts, at sites where contact is imperfect and gaps may appear between them. Such gaps may be the result of mould part manufactur-
25 ing imperfections, wear on the mould part faces, or caused by the presence of an object placed within the mould and on which the moulding is to be carried out. While being capable of elastic deformation, the pressure absorbing inserts of the present invention are resistant enough to withstand the pressure applied by the injected material. Thereby, gaps appearing between the two

mould part faces are sealed, and the ejection of excess mould-processable material between the faces is avoided.

For the pressure absorbing insert to perform its intended function of absorbing the pressure transferred by the mould-processable material by elastic deformation, it is placed adjacent to the mould parts parting line in the moulding condition, while being external with regards to the mould cavity. By adjacent, it is understood that the pressure absorbing insert is in close proximity of the mould-parts parting line in the moulding condition, the insert thereby sealing the mould cavity along its parting line so as to prevent the formation of flash.

Moreover, due to the placement of the insert in the open recess, replacement of the insert may be made easy. Compared to the solutions proposed in the prior art, where the flash-avoiding system is based on the provision of a fluid suitable for floating support of the mould parts, or where a diaphragm effect is ensured by a difficultly replaceable layer and weakened sections, the operator of the present invention will find it easy to exchange or replace the pressure absorbing inserts if need be. The inventors have realised that by using pressure absorbing inserts of different hardness, consistent flashless results may be obtained when using different mould-processable materials at different mould-processable material injection pressures. Therefore, such a need may arise from the wish to switch the pressure absorbing insert for one with a different hardness so as to achieve a more satisfactory result.

All of the above-mentioned points being considered, the formation of flash on the end product at sites corresponding to the moulding parts parting lines may be advantageously reduced.

According to a preferred embodiment, the pressure absorbing insert is heat-expandable within the recess. By the pressure absorbing insert being heat-expandable, the moulding temperature e.g. the temperature within the moulding device in the moulding condition, which is typically higher than resting

temperature, will cause the pressure absorbing insert to expand within the mould part recess. The mould part is typically made of a non-deformable, non-compressible solid material, typically steel or other metal alloy. The volumetric, heat-induced expansion of the pressure absorbing insert will be

5 greatest in the direction encountering least resistance. The insert will, therefore, expand through the open face of the recess, projecting the edge of the pressure absorbing insert to come in close proximity of the mould parting line, the insert thereby sealing the mould cavity along its parting line so as to prevent the formation of flash. Thus, by the pressure absorbing insert being heat-

10 expandable, the invention allows for the active sealing of the parting lines of the closed mould parts under increased heat condition, which may ensure a tighter seal than that obtained in the cited prior art documents.

According to one embodiment, the pressure absorbing insert expands into the mould cavity up to 0,5mm when moulding, such as 0,1mm or less, such as

15 0,01mm.

According to one embodiment, the pressure absorbing insert extends between 0,01 and 0,1mm at 20° Celcius e.g. in mould resting condition, beyond the recess e.g. beyond the recess' open face edge. It should be understood that the mould device of the invention may be positioned in at least two conditions e.g. an open, resting condition, in which the faces of the two mould parts are not in general contact with each other, and a closed, moulding condition, wherein the mould part faces are in general contact with each other and the mould parts are defining a mould cavity and a parting line. By the extension of

20 the pressure absorbing insert beyond the recess in mould resting condition, a pre-moulding tension is established. In moulding condition, the two mould parts are in close contact with each other. Therefore, the open face of the recess exposes the pressure absorbing insert in one mould part to at least partially contact either the face of the second mould part or a second pressure absorbing insert present in the recess of the second mould part, in

25

moulding condition. Thus, in moulding condition, the at least one pressure absorbing insert will be under pressure from all its sides. The established pre-tension will ensure that any gaps between the mould faces along the parting line will be tightly sealed by the expansion of the heat-expandable pressure
5 absorbing insert as described herein above.

According to an embodiment, the pressure absorbing insert has a Shore D hardness between 58-65. Experimental results have determined that hardness within this range may contribute to a pressure absorbing insert offering good resistance to the pressure applied by the injected material. Furthermore,
10 hardness within the mentioned range may ensure greater durability. Notwithstanding the pressure absorbing insert being made of a material of sufficient hardness, it should also be elastically deformable to a sufficient degree so as to fulfil its intended function in recovering its initial shape once the moulded part is removed from the moulding device, and after countering the pressure
15 transferred by the moulding material upon injection. Thus, the pressure absorbing insert is typically made of a heat-deformable plastic polymer, such as thermoplastic, or polysiloxanes, such as silicone.

According to an embodiment, the pressure absorbing insert is a heat-deformable synthetic fluoropolymer, such as polytetrafluoroethylene (PTFE).
20 By using a synthetic fluoropolymer, the pressure absorbing insert exhibits high strength, toughness and self-lubrication, but also good flexibility.

According to an embodiment, the pressure absorbing insert is an integral part of the mould part. As an intergral part, it is understood that the pressure absorbing insert is permanently fixed to the sides and/or the base of the recess.
25 Permanent fixation results in an arrangement that is more precise, as movement of the pressure absorbing insert within the recess is reduced. The benefits that come with a more adjustable arrangement may, however, be desired.

According to an embodiment, the pressure absorbing insert is detachably attached to said at least one moulding part. Detachability of the pressure absorbing insert in the open face recess ensures that replacement of the insert may be made easy. Need to replace the pressure absorbing insert may arise
5 according to what is described herein above.

The pressure absorbing insert may be adjustable within the recess. In such a case, the recess and the pressure absorbing insert will have shapes and sizes adapted to allow for adjustability of the pressure absorbing insert within the recess. A pressure absorbing insert has a length dimension, a width dimension and a thickness dimension. Said length dimension is essentially parallel
10 to the parting line in the moulding condition, said width dimension is perpendicular to said length dimension and extends in the same plane as the length dimension, and said thickness dimension is perpendicular to both said length and said width dimensions.

15 According to an embodiment, the pressure absorbing insert may be placed in a variety of positions along a first axis x essentially parallel to the length dimension of the insert.

According to another embodiment, the pressure absorbing insert may be placed in a variety of positions along a second axis y essentially parallel to
20 the width dimension of the insert.

According to another embodiment, the pressure absorbing insert may be placed in a variety of positions along a third axis z essentially parallel to the thickness dimension of the insert.

Such adjustability permits, for example, an optimal placement of the pressure
25 absorbing insert with respect to the parting line defined by the two mould parts in the moulding condition.

The pressure absorbing insert further has at least a proximal edge, which is closest to the moulding device parting line when mounted in the recess, and a distal edge, which is farthest away from the moulding device parting line in the moulding condition. According to one embodiment, the pressure absorbing insert thickness dimension is smaller at the distal edge than it is at the proximal edge. By the reduced thickness dimension, the use of screws or other attachment devices on the pressure absorbing insert is facilitated, when these are arranged more distally from the parting line. In this way, attachment devices will not obstruct the transfer of pressure from the moulding part to the pressure absorbing insert when moulding.

According to an embodiment, mould parts may be tapered away from said first and second contact faces and the parting line in the moulding condition. In this way, said mould parts form angles with the plane defined by the pressure absorbing insert length and the width dimensions in the closed, moulding condition. This allows the mould parts to better apply pressure to the pressure absorbing insert and to better allow for the use of screws or other attachment devices as described herein above.

According to an embodiment, moulding parts are adapted for use with an injection pressure applied to the reaction injection moulding processable material during injection below 14bar.

All of the above-mentioned points being considered, the formation of flash on the end product at sites corresponding to the moulding parts parting lines may be advantageously reduced according to the present invention.

In another aspect of the invention, a method of producing a flashless window sash or frame is provided.

In a preferred embodiment of this second aspect, the injection pressure applied to the reaction injection moulding processable material during injection is below 14bar. By limiting the injection pressure applied to the moulding pro-

cessable material, the pressure transferred to the mould parts parting line is less compared to traditional injection moulding, thus leading to a reduction in frequency and amount of flash forming on the moulded article.

An injection pressure below 14bar will also reduce the pressure absorbing
5 insert hardness requirement at sites prone to flash formation in the context of the invention. The thermal expansion coefficient of common solid materials is inversely proportional to their melting point. Thus, a pressure absorbing insert with a low melting point has a greater thermal expansion coefficient than that
10 of an insert made of a material with a high melting point, and greater thermal expansion will result in tighter sealing of the mould parts along the parting line as described above. Injection pressure below 14bar may thus result in reduced flash formation on the moulded article compared to injection at higher pressures.

15 Further presently preferred embodiments and further advantages will be apparent from the following detailed description and the appended dependent claims.

Brief Description of Drawings

20 The above, as well as additional objects, features and advantages of the present inventive concept, will be better understood through the following illustrative and non-limiting detailed description, with reference to the appended drawings. In the drawings like reference numerals will be used for like elements unless stated otherwise.

25 Fig. 1a shows a perspective view of the moulding device in an embodiment of the invention in a closed condition.

Fig. 1b shows a perspective view of both moulding parts in the moulding device in an open condition in an embodiment of the invention.

Fig. 2a shows a perspective view of a first moulding part in an embodiment of the moulding device according to the invention.

5 Fig.2b shows a perspective view of a first moulding part containing a moulded element in an embodiment of the invention.

Fig. 3a shows a perspective partial view of a first moulding part in an embodiment of the invention.

10 Fig. 3b shows another perspective partial view of a first moulding part in an embodiment of the invention.

Fig. 4a shows a perspective view of a heat-deformable pressure absorbing insert according to an embodiment of the invention.

Fig. 4b shows a perspective view of another heat-deformable pressure absorbing insert according to an embodiment of the invention.

15 Fig. 4c shows a section of a mould device in a closed condition in an embodiment according to the invention.

Description of Embodiments

Referring first to Figs. 1a-2b showing the overall appearance and principles underlying a mould device 1 according to the invention, the mould device
20 comprises two mould parts 21, 22. As seen in Figs. 1b and 4c, each mould part has a contact face 41, 42 arranged to contact the other mould part in the moulding condition. The mould parts are typically made of a non-deformable, non-compressible solid material, typically steel or other metal alloy and are further adapted for defining a mould cavity 3 with each other in the closed,
25 moulding condition. Around the edges of the contact faces and the mould

cavity, a parting line 4 (Fig. 1a and 4c) is defined by the mould parts when in the moulding condition.

The moulding device of the present invention is intended primarily for moulding window frames and sashes, which are most commonly shaped by two
5 pairs of opposing frame members, such that the sash or frame is made up of four elongated elements and is substantially rectangular, not shown in detail. Elongated frame elements may be moulded individually for posterior assembly to form a completed frame or sash. Window sashes or frames are otherwise moulded as one essentially rectangular part, thereby simplifying manu-
10 facture and thus reducing production time and costs. Thus, the moulding parts 21, 22 and the mould cavity 3 are adapted to mould an essentially rectangular moulded part e.g. a window sash or frame 9, fig. 2b.

The moulding device according to the present invention is adapted for manufacturing of a window sash or frame by a reaction injection moulding process
15 using a polymer, for example, and not in a way intended to be limiting, polyurethane (PU), such as thermoplastic polyurethane or non-isocyanate based polyurethane (NIPU), but may also be made of or contain polyurea, polyisocyanurate, polyester, polyphenol, polyepoxide, or nylon 6. It is generally known to the skilled person that two parts of the polymer are mixed together.
20 In the case of polyurethane, one component of the mixture is polyisocyanate and the other component is a blend of polyol, surfactant, catalyst, and blowing agent.

Such a reaction injection mould-processable material is heated and in some cases may be injected in fluid form through a sprue, which is arranged in any
25 adequate position. It is also generally known to the person skilled in the art how to arrange such a sprue on a reaction injection moulding device for the injection of reaction injection moulding processable material.

For the mould cavity to be entirely filled with said material and that the moulded part acquires the intended volume and shape, it may be required to allow the material to cure and harden. Injection pressure in the context of the present invention is typically maintained under 10.3bar, preferably between 3.1-
5 10bar.

Referring now to Figs. 2b and 3a-b, to ensure that the mould cavity is properly sealed, thus avoiding the formation of flash on the moulded part, at least one of the mould parts 21, 22 of the present invention has a recess 5 in which at least one pressure absorbing insert 6 is received. The recess 5 has at least
10 two side faces 51, 52 and a bottom face 53 and defines an open face, through which the pressure absorbing insert is exposed in the open, resting condition, when present.

In this embodiment, and not in a way intended to be limiting, the bottom face of the recess also comprises threaded holes 54 for receiving screws used to
15 attach the pressure absorbing insert 6. Other attachment means may also be adequate, such as rivets, plugs, studs or similar.

Referring now to Fig. 4b, the recess 5 is arranged in the mould part separately from, but adjacent to the mould cavity, in such a way that at least one edge of the pressure absorbing insert 6 sits in close contact to the mould part part-
20 ing line 4 in the moulding condition. The recess 5 is further arranged to receive the pressure absorbing insert 6 in such a way that the pressure absorbing insert fits tightly into the recess, the recess thus appropriately securing the pressure absorbing insert (Fig. 3a). The recess is further arranged so that the pressure absorbing insert extends slightly beyond the open face edges of the
25 recess 5. The pressure absorbing insert extends between 0,01 and 0,1mm at 20° Celcius e.g. in mould resting condition, beyond the recess e.g. beyond the recess' open face edge, thereby presenting a pre-moulding tension in the open, resting condition.

Referring now to Figs. 4a-b, the pressure absorbing insert 6 may have any shape or size in the context of this invention. It is, however, preferred that the pressure absorbing insert has a thickness that is consistent with the examples presented herein and allowing for an adequate heat-induced expansion, thus, the pressure absorbing insert has a thickness within the range of a few millimetres to 5cm. Length of the pressure absorbing insert is chosen so to provide adequate sealing of gaps between the mould parts. The pressure absorbing insert may be of any width that is adequate to ensure its correct functionality, but is preferably wide enough to accommodate holes 61 adapted to receive screws or similar devices appropriate for attaching the pressure absorbing insert 6 to the mould part 5.

The pressure absorbing insert may have a rectangular cross-section. In any case, the size and shape of the pressure absorbing insert will be chosen so as to allow adequate permanent or detachable attachment and retention within the open recess.

The pressure absorbing insert thickness dimension may be smaller at the edge that is distal to the parting line in the moulding condition than it is at edge that is proximal to the parting line in the moulding condition, along axis y. This allows for the use of screws or other attachment devices on the pressure absorbing insert arranged more distally from the parting line, so as not to obstruct the transfer of pressure from the moulding part to the pressure absorbing insert when moulding.

As shown in Fig. 4c, mould parts 21, 22 are tapered away from first and second contact faces 41, 42 and parting line 4 in the moulding condition.

Adequate materials of which the pressure absorbing insert may be constructed include, but are not limited to, heat-deformable plastic polymer, such as thermoplastic, or polysiloxane, such as silicone, and heat-deformable synthetic fluoropolymer, such as polytetrafluoroethylene (PTFE).

It should be noted that the above description of preferred embodiments serves only as an example, and that a person skilled in the art will know that numerous variations are possible without deviating from the scope of the claims.

5 As mentioned above, the second aspect of the invention relates to a method of producing a flashless window sash or frame, the method comprising the steps of

providing a mould device 1 adapted for use in a reaction injection mould comprising:

10 two mould parts 21, 22 and

at least one pressure absorbing insert 6 in at least one recess 5 in at least one of said two mould parts,

15 joining said two mould parts thereby defining a parting line 4 and a mould cavity 3 in such a manner that said pressure absorbing insert 6 is externally adjacent to said mould cavity 3, and

injecting reaction injection mould-processable material into the mould cavity 3.

20 The person skilled in the art will understand that the two mould parts or any other moving parts of the mould need to be moved in the correct order in order to correctly interact, guide interlock, open and close. For example, the two mould parts 21, 22 need to interact to define the mould cavity 3 and the parting line 4 in a way adequate to obtain the intended flashless moulded element 9 by implementing the method described herein above.

25 Further, the number and placement of pressure absorbing inserts 6 used in the method may vary, and freely decided upon by the user. The use of pressure absorbing inserts may only be necessary for the moulding of certain window frames or sashes sizes and types. Thus, the first window sash or

frame may exhibit flash, whereafter pressure absorbing inserts 6 may be inserted and secured in the recess 5 so as to counter the force transferred by the injected fluid thereby allowing the production of flashless moulded elements 9.

- 5 By joining the two mould parts 21, 22 and as shown in Figs. 1a and 4c, the pressure absorbing insert is externally adjacent to said mould cavity 3. It will be understood by the user that adjustment of the pressure absorbing insert position will be advantageous when this feature is present. Correct positioning of the pressure absorbing insert 6 will ensure that its parting-line proximal
- 10 edge will be adjacent to the mould cavity 3 in the moulding condition as described herein above. It will also be readily apparent, that several rounds of joining said mould parts 21, 22 so as to form a mould cavity 3 and a parting line 4, injection of reaction mould-processable material into the mould cavity, inspection of the moulded element 9 and adjustment of the pressure absorb-
- 15 ing insert position, may be required for achieving optimal results. To this end, the method may also comprise exchanging pressure absorbing inserts of different hardness.

Furthermore, the method may comprise further processing the injected reaction mould material. Reaction injection moulding often necessitates pro-

20 cessing of the injected material for it to harden. Commonly known processes include, but are not limited to, introducing a curing step at the end of the method. Processing methods are generally known to the skilled person.

List of reference numerals

- 1 mould device
- 2 mould parts
 - 21 first mould part
 - 22 second mould part
- 3 mould cavity
- 4 parting line
 - 41 first contact face
 - 42 second contact face
- 5 recess
 - 51 first side face
 - 52 second side face
 - 53 bottom face
 - 54 threaded hole
- 6 pressure absorbing insert
- 9 window sash / frame

1. Støbeformsanordning (1) indrettet til anvendelse i en reaktionssprøjte-støbeform til fremstilling af en vinduesramme eller karm ved bearbejdning af reaktionssprøjtestøbbart materiale, hvor støbeformsanordningen omfatter mindst et trykabsorberende indlæg (6), en første støbeformsdel (21), og en
5 anden støbeformsdel (22), hvor den anden støbeformsdel (22) er indrettet til sammen med den første støbeformsdel (21) at definere et støbeformshulrum (3) og en skillelinje (4), hvor mindst én af støbeformsdelene (2) har mindst én udsparring (5), i hvilken det mindst ene trykabsorberende indlæg (6) er mod-
10 taget, hvor det mindst ene trykabsorberende indlæg (6) er placeret uden for støbeformshulrummet (3) og støder op til skillelinjen (4), hvor indlægget (6) har mindst en proksimal kant, der er tættest på støbeanordningsskillelinjen, og en distal kant, der er længst væk fra støbeanordningsskillelinjen, hvorved indlægget (6) forsegler støbeformshulrummet (3) langs skillelinjen (4), hvor det mindst ene trykabsorberende indlæg (6) er aftageligt fastgjort til den
15 mindst ene støbeformsdel, og hvor tykkelsesdimensionen af det trykabsorberende indlæg (6) er mindre ved en skillelinjedistal kant end ved en skillelinjeproksimal kant.

2. Støbeanordning (1) ifølge krav 1, hvor det mindst ene trykabsorberende indlæg (6) kan varmeeekspandere inden i udsparringen (5).

20 3. Støbeanordning (1) ifølge krav 2, hvor den proksimale kant af det mindst ene trykabsorberende indlæg (6) ekspanderer op til 0,5mm ind i støbeformhulrummet (3) ved støbning.

4. Støbeanordning (1) ifølge et hvilket som helst af de foregående krav, hvor det trykabsorberende indlæg (6) strækker sig mellem 0,01 og 0,1mm ud
25 over den mindst ene udsparring (5) ved 20 °C.

5. Støbeanordning (1) ifølge et hvilket som helst af de foregående krav, hvor det mindst ene trykabsorberende indlæg (6) har en Shore D-hårdhed mellem 58-65.

6. Støbeanordning (1) ifølge et hvilket som helst af de foregående krav, hvor det mindst ene trykabsorberende indlæg (6) er en varmedeformerbar syntetisk fluorpolymer, såsom polytetrafluoroethylen (PTFE).

7. Støbeanordning (1) ifølge et hvilket som helst af de foregående krav, hvor det mindst ene trykabsorberende indlæg (6) er integreret i mindst én støbeformsdel.

8. Støbeanordning (1) ifølge et hvilket som helst af kravene 1 til 6, hvor det mindst ene trykabsorberende indlæg (6) er justerbart inden i udsparringen (5) langs en akse x i det væsentlige parallelt med skillelinjen (4) og med en længdedimension af det trykabsorberende indlæg (6).

9. Støbeanordning (1) ifølge et hvilket som helst af kravene 1 til 6 og 8, hvor det mindst ene trykabsorberende indlæg (6) er justerbart inden i udsparringen (5) langs en akse y i det væsentlige parallelt med en breddedimension af det trykabsorberende indlæg (6).

10. Støbeanordning (1) ifølge et hvilket som helst af kravene 1 til 6 og 8 og 9, hvor det mindst ene trykabsorberende indlæg (6) er justerbart inden i udsparringen (5) langs en akse z i det væsentlige parallelt med en tykkelsesdimension af det trykabsorberende indlæg (6).

11. Støbeanordning (1) ifølge et hvilket som helst af de foregående krav, hvor støbeanordningen (1) er indrettet til at støbe ved et sprøjtetryk under 14 bar.

12. Fremgangsmåde til at fremstille en gratfri vinduesramme eller -karm, hvor fremgangsmåden omfatter:

a. at tilvejebringe en støbeformsanordning (1) indrettet til anvendelse i en reaktionssprøjttestøbeform, som omfatter:

i. to støbeformsdele (2),

- 5 ii. mindst ét trykabsorberende indlæg (6) i mindst én udsparring (5) i mindst én af de to støbeformsdele, hvor indlægget (6) har mindst en proksimal kant, der er tættest på støbeanordningsskillevinjen, og en distal kant, som er længst væk fra støbeanordningsskillevinjen og er aftageligt fastgjort til den mindst ene støbedel, og hvor tykkelsesdimensionen af det trykabsorberende indlæg (6) er mindre ved en skillevinjedistal kant end ved en skillevinje-proksimal kant,
- 10 b. at forbinde de to støbeformsdele (2), hvorved der defineres en skillevinje (4) og et støbeformshulrum (3) på en sådan måde, at det trykabsorberende indlæg (6) er uden for og stødende op til støbeformshulrummet (3) ved en skillevinje (4), og
- 15 c. at sprøjte reaktionssprøjttestøbbart materiale ind i støbeformshulrummet (3).

13. Fremgangsmåde ifølge krav 12, hvor sprøjtetrykket påført på det reaktionssprøjttestøbbare materiale under indsprøjtning er under 14 bar.

20 14. Fremgangsmåde ifølge enten krav 12 eller 13, hvor det reaktionssprøjttestøbbare materiale bearbejdes yderligere.

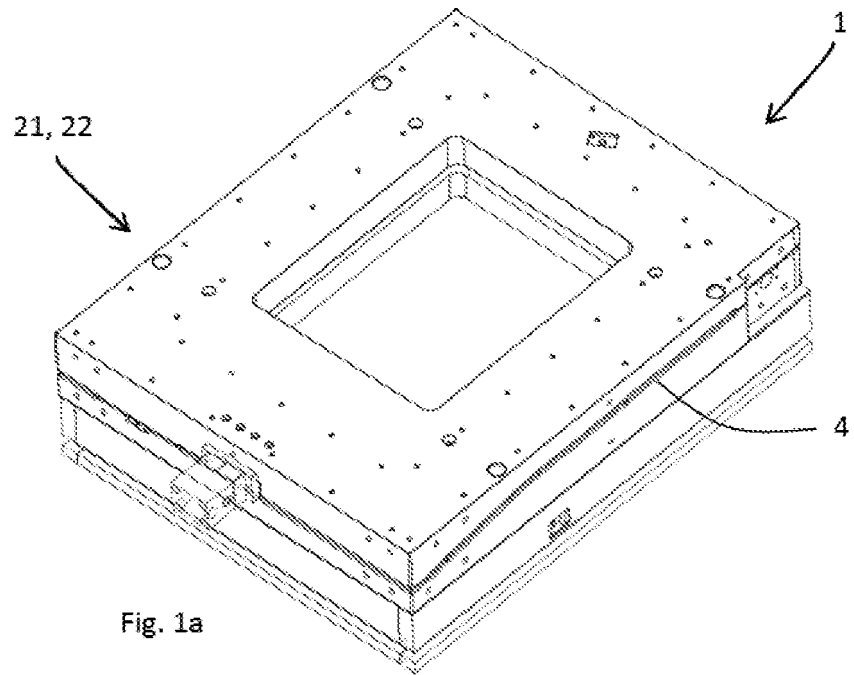


Fig. 1a

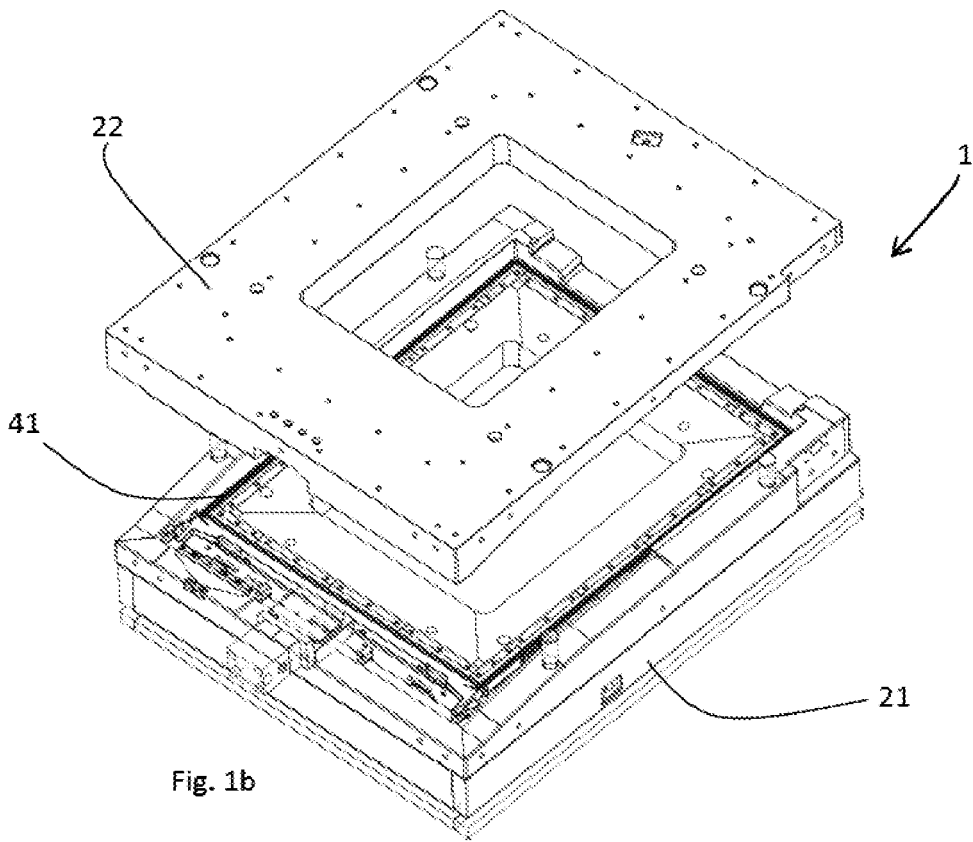


Fig. 1b

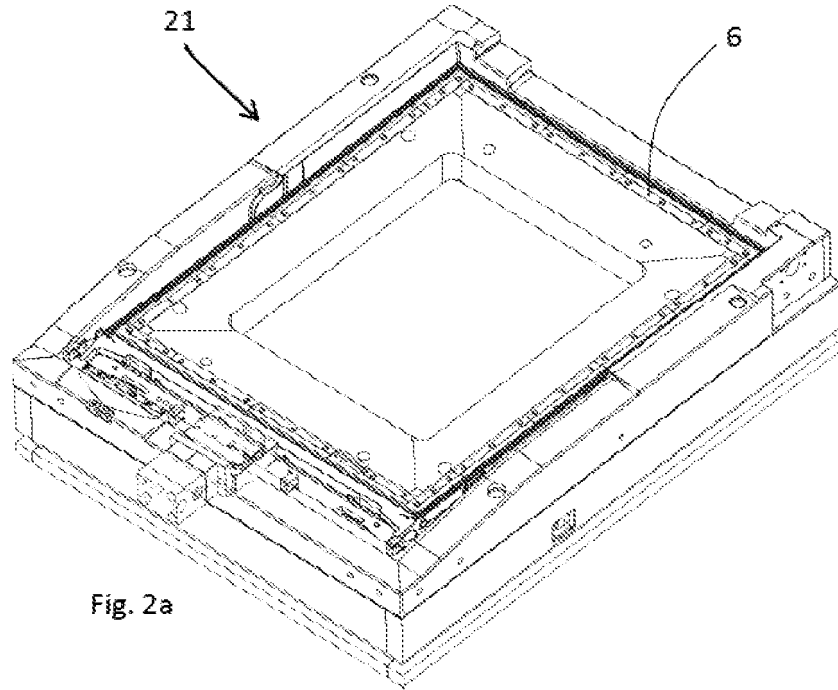


Fig. 2a

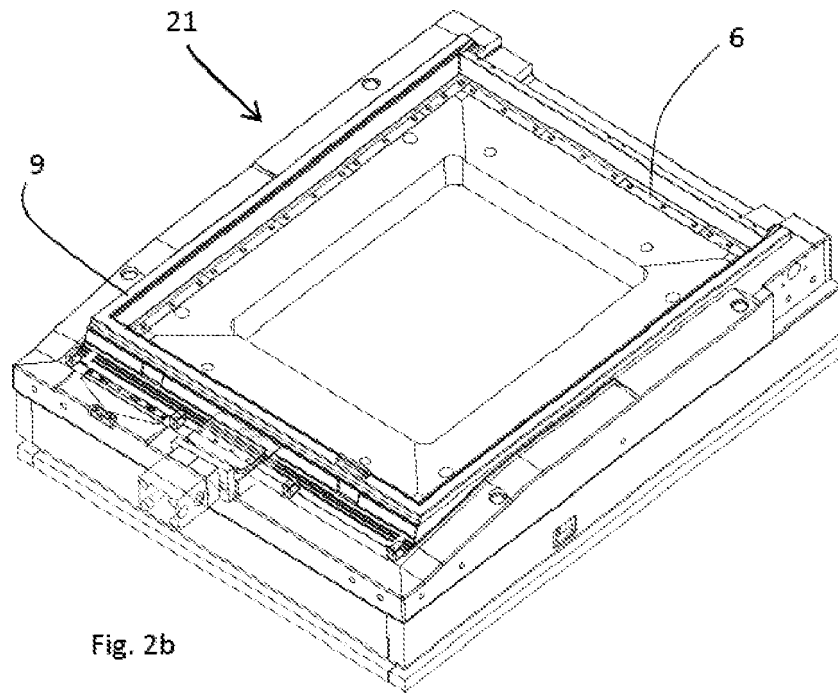


Fig. 2b

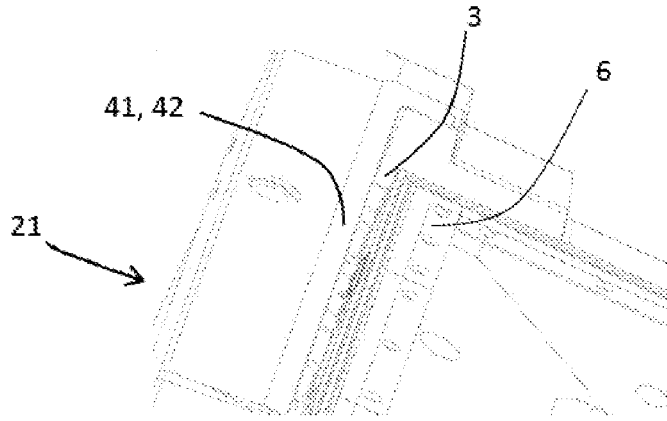


Fig. 3a

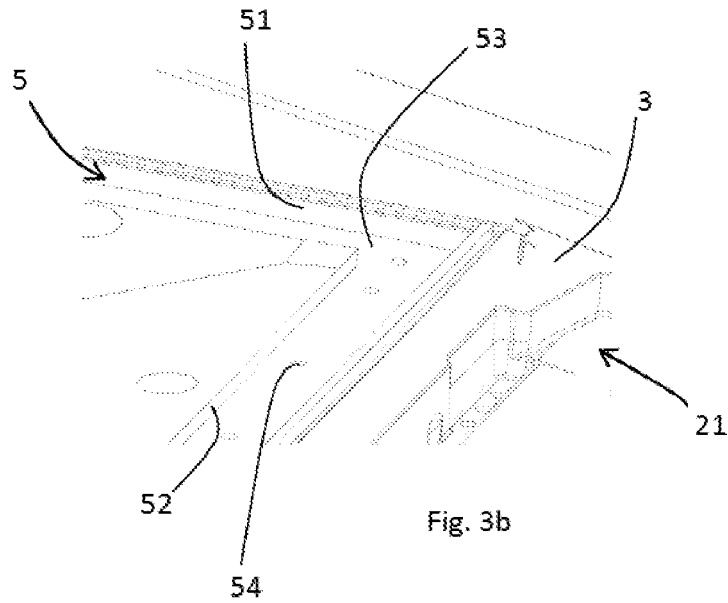


Fig. 3b

