



LESSON 07 - DOUBLE WALLS

Double



Design Considerations

Double Wall Products

For material to flow and form properly, it is recommended that the distance between the parallel walls be a minimum of five times the nominal wall thickness of the part

Wall Thickness

Uniform wall thickness products is one of the inherent benefits of the Rotational molding process if all areas of the mold achieve uniform heating.

Basically the hotter the inside surface of the mold gets the more material will form in that area. Therefore shielded areas and deep cores will reduce the amount of heat that are gets resulting in thinner walls in those areas. Steps must be incorporated in the mold design to ensure even wall thickness.

Through the use of air amplifiers, preheating molds, black paint, heat fins and pins, and protherm, the molder can actually control the product wall thickness to achieve different wall thickness as required by a specific product design.