



SNAPSHOT:

Preferred Volume: 1 to 100 units

Prices Beginning at: \$140

Single Tool Production: 2-3 parts per day

AT A GLANCE:

A closed mold process, parts are produced using two tool halves, one flexible and one rigid, and cores. One or both halves can be gel coated and a dry glass laminate is inlaid. Once the mold halves have been assembled, resin is either pumped in using vacuum pressure or a pressure pump filling the cavity then holding to cure. This process offers finished parts with two molded sides.

PERFECT FOR:

Boating & Marine Components, Playground Equipment, Sanitation Disposal Covers

NOTABLE CUSTOMERS:

American Standard, R&D

LRTM

ATTRIBUTES



LIGHT WEIGHT



LONG LIFE EXPECTANCY



PRODUCT CONSISTENCY



RAPID PRODUCTION

Creative Strategy

SIZE & COMPLEXITY

- Maximum 10' x 10'
- Considerations: hardware, parting lines and substrates

MATERIALS

- Resin surface coat, layers of fiberglass mat and vacuum infused or pressure pumped resin
- Considerations: compression strength, corrosion resistance, flexural, service temperature and tensile

COLOR CHART: *view online at www.rsalberts.com*

DRAFT

Amount of taper for molded or cast parts perpendicular to the parting line. An angle is incorporated into a wall of a mold so that the opening of the cavity is wider than its base. Draft angles allow for easier ejection of the part from the mold.

- Smooth Texture: 0° draft acceptable in some cases, 1° draft preferred minimum
- Light Texture: 2° draft preferred minimum
- Heavy Texture: 3° draft preferred minimum

WALL THICKNESS AND RADIUS

- Minimum .0625"
- Maximum .500"
- Preferred minimum corner radius .250"

SURFACE FINISH

With a closed mold process, the tool side and non-tool side can capture a smooth, polished finish. The gel coat's cosmetic finish may reveal the fabric print without a barrier coat.

TOLERANCES

Allowable variation for any given size in order to achieve proper function when considering the design intent. As with all molded products, part material's shrink value should be considered when building your pattern and mold.

- Tool side $\pm .010$ "
- Non-tool side $\pm .020$ "



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