

Title (en)  
PRODUCTION METHOD PREVENTING MICRO-SCRATCHES ON PLASTIC PATTERNED SURFACES

Title (de)  
HERSTELLUNGSVERFAHREN ZUR VERHINDERUNG VON MIKROKRATZERN AUF KUNSTSTOFFSTRUKTURIERTEN OBERFLÄCHEN

Title (fr)  
PROCÉDÉ DE PRODUCTION EMPÊCHANT LES MICRO-RAYURES SUR DES SURFACES EN PLASTIQUE À MOTIFS

Publication  
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Application  
**EP 17712265 A 20170206**

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Abstract (en)  
[origin: WO2018143900A1] The invention is a patterned plastic surface (100) production method, and it is characterized in that; it comprises the operation steps of : carrying out a mould filling analysis which consists of the steps of determining the required pressure value in the closure system (300), selecting the distance between the hot runners, and selecting the number of hot runners, carrying out an injection stage where pressure-velocity profiles are applied until the geometry of the relevant part is filled up to hundred percent, a filling stage is carried out, in which ninety five percent of the volume of the relevant part is filled, after the ninety-five percent part of the relevant part is filled, an ironing operation is carried out, in which the remaining portion is filled with pressure and the pattern surface is copied, a cooling stage is carried out, in which the relevant part is kept in the mould for solidification, a closure stage is carried out, in which the female mould (302) and the male mould (301) are combined and the required tonnage is applied.

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