
**Tools for moulding — Tool
specification sheet for injection moulds**

*Outillage de moulage — Formulaire de spécifications d'outils pour
moules d'injection*

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Contents

	Page
Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Use of the specification sheet	1
5 Tool specification sheet	2

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

This second edition cancels and replaces the first edition (ISO 16916:2004), which has been technically revised. Additional information has been added to Clause 5 in "4.5 Demoulding".

Tools for moulding — Tool specification sheet for injection moulds

1 Scope

This International Standard defines the description and specification of injection moulds to be used when requesting tools (stage of tender) and ordering tools. This International Standard gives data for material acquisition, equipment, structural design of injection moulds including the surfaces of the tool. Information relating to machine-specific data, types of operation and warranty is also contained in this specification sheet.

This International Standard does not apply to compression moulds and die casting dies.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 12165:2000, *Tools for moulding — Components of compression and injection moulds and diecasting dies — Terms and symbols*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 12165 apply.

4 Use of the specification sheet

By using this specification sheet, the offers of various suppliers can be compared with each other. In consideration of these specification misunderstandings, misinterpretations or claims to damages shall already be eliminated or minimized at the time when the tools are ordered.

The user of this specification sheet is permitted to make copies.

5 Tool specification sheet

1 General information		
Buyer:		Date:
Person to contact for all technical questions:		Request No.:
		Telephone:
		Telefax:
		E-mail
Offer No.:	Drawing No.:	State of modification:
Moulding designation:		Total amount of pieces planned:
Part drawing No.:	Prototype tool	<input type="checkbox"/>
	Production tool	<input type="checkbox"/>
Drawing for request: <input type="checkbox"/>	Approved moulding drawing: <input type="checkbox"/>	
Type of resin, compound:	Shrinkage:	
NOTE Important		
Number of cavities:		
Subsequent specification for mould offer:		<input type="checkbox"/>
Subsequent specification for mould ordering:		<input type="checkbox"/>
Supplier of standards:		
External supplier: (external work bench)		
2 Guidelines		
2.1 The mould design concept shall be presented to the customer for approval prior to purchasing the material and starting the production of the mould.		
2.2 The manufacture of the cores and cavities shall be carried out in accordance with the actual mould design.		
2.3 If there are any uncertainties with respect to the drawing data, agreement with the customer is necessary in each case.		
2.4 Sampling of the mould should preferably be done in the hardened state.		
2.5 Sampling of the mould shall be carried out with the moulding compound given in the moulding drawing.		
2.6 The performance of the mould in full automatic cycle shall be verified.		
2.7 The rights of ownership of electrodes, software (CNC programmes) and original construction documents are handed over to:		
		<input type="checkbox"/> customer
		<input type="checkbox"/> supplier
2.8 The buyer shall specify the data relating to the contents of the mould type plate.		
3 Description of mould order		
3.1 To be provided for offer <input type="checkbox"/> and order <input type="checkbox"/>		
	provided by the customer	provided by the orderer
Moulding drawing	<input type="checkbox"/>	<input type="checkbox"/>
CAD data	<input type="checkbox"/>	<input type="checkbox"/>
Sample	<input type="checkbox"/>	<input type="checkbox"/>

	provided by the customer	provided by the orderer
Mould design	<input type="checkbox"/>	<input type="checkbox"/>
Master pattern	<input type="checkbox"/>	<input type="checkbox"/>
Shrinkage pattern	<input type="checkbox"/>	<input type="checkbox"/>
Raw material	<input type="checkbox"/>	<input type="checkbox"/>
Mould assembly	<input type="checkbox"/>	<input type="checkbox"/>
Hot runner	<input type="checkbox"/>	<input type="checkbox"/>
Standard parts	<input type="checkbox"/>	<input type="checkbox"/>
Electrodes	<input type="checkbox"/>	<input type="checkbox"/>
Machine data sheet	<input type="checkbox"/>	<input type="checkbox"/>
Other	<input type="checkbox"/>	<input type="checkbox"/>
3.2 Scope of delivery relative to the mould		
	by the customer	by the orderer
Design with parts list	<input type="checkbox"/>	<input type="checkbox"/>
Drawings of components, cores and cavities	<input type="checkbox"/>	<input type="checkbox"/>
Drawing of plates	<input type="checkbox"/>	<input type="checkbox"/>
Drawing of electrodes	<input type="checkbox"/>	<input type="checkbox"/>
Drawing of wire pattern	<input type="checkbox"/>	<input type="checkbox"/>
CAD data	<input type="checkbox"/>	<input type="checkbox"/>
List of coordinates	<input type="checkbox"/>	<input type="checkbox"/>
Mould type plate (visible on the tool)	<input type="checkbox"/>	<input type="checkbox"/>
Set of electrodes	<input type="checkbox"/>	<input type="checkbox"/>
NC programmes	<input type="checkbox"/>	<input type="checkbox"/>
Connection cables	<input type="checkbox"/>	<input type="checkbox"/>
3.3 Sampling		
	by the customer	by the orderer
Samples	<input type="checkbox"/>	<input type="checkbox"/>
Test report	<input type="checkbox"/>	<input type="checkbox"/>
4 Mould design		
4.1 Type of mould		
Square mould assembly	<input type="checkbox"/>	
Round mould assembly	<input type="checkbox"/>	
Standard mould	<input type="checkbox"/>	
Split mould	<input type="checkbox"/>	
Stripper plate mould	<input type="checkbox"/>	
Three-plate mould	<input type="checkbox"/>	
Stack mould	<input type="checkbox"/>	
Hot-runner mould	<input type="checkbox"/>	

4.2 Setting up/Transport		
4.2.1 Setting up		
	Supplier	National standard or ISO
Lifting device	<input type="checkbox"/>	<input type="checkbox"/>
Transport securing unit	<input type="checkbox"/>	<input type="checkbox"/>
Resting feet	<input type="checkbox"/>	<input type="checkbox"/>
Lifting eye bolt	<input type="checkbox"/>	<input type="checkbox"/>
Stop screw	<input type="checkbox"/>	<input type="checkbox"/>
Tool centring	<input type="checkbox"/>	<input type="checkbox"/>
Locating ring		
— movable half (MH)	<input type="checkbox"/>	<input type="checkbox"/>
— fixed half (FH)	<input type="checkbox"/>	<input type="checkbox"/>
4.2.2 Clamping on machine		
	Supplier	National standard or ISO
Mould clamping by means of		
— screws	<input type="checkbox"/>	<input type="checkbox"/>
— clamping units	<input type="checkbox"/>	<input type="checkbox"/>
— quick-action clamping	<input type="checkbox"/>	<input type="checkbox"/>
— magnetic clamping plate	<input type="checkbox"/>	<input type="checkbox"/>
Clamping plates		
— flush on all sides	<input type="checkbox"/>	<input type="checkbox"/>
— overhanging in lateral direction	<input type="checkbox"/>	<input type="checkbox"/>
— overhanging in longitudinal direction	<input type="checkbox"/>	<input type="checkbox"/>
— overhanging on all sides	<input type="checkbox"/>	<input type="checkbox"/>
Special clamping plates	<input type="checkbox"/>	<input type="checkbox"/>
Adapter plates	<input type="checkbox"/>	<input type="checkbox"/>
Clamping grooves	<input type="checkbox"/>	<input type="checkbox"/>
4.3 Type of gating		
	Supplier	National standard or ISO
Sprue gate	<input type="checkbox"/>	<input type="checkbox"/>
Sprue on subrunner	<input type="checkbox"/>	<input type="checkbox"/>
Tunnel gate	<input type="checkbox"/>	<input type="checkbox"/>
Film gate	<input type="checkbox"/>	<input type="checkbox"/>
Pin-point gate	<input type="checkbox"/>	<input type="checkbox"/>
Ring gate	<input type="checkbox"/>	<input type="checkbox"/>
Umbrella gate	<input type="checkbox"/>	<input type="checkbox"/>
Three-plate system	<input type="checkbox"/>	<input type="checkbox"/>
Side-gate in mould parting area	<input type="checkbox"/>	<input type="checkbox"/>

	Supplier	National standard or ISO
Hot-runner — Manifold block with distributor bushing		
— heated internally	<input type="checkbox"/>	<input type="checkbox"/>
— heated externally	<input type="checkbox"/>	<input type="checkbox"/>
Heated nozzle with pin-point gate	<input type="checkbox"/>	<input type="checkbox"/>
Heated nozzle with open gate	<input type="checkbox"/>	<input type="checkbox"/>
Heated nozzle with needle valve	<input type="checkbox"/>	<input type="checkbox"/>
4.4 Cooling/heating		
4.4.1 Expected mould temperature in degree Celsius		
Fixed half (FH): _____ Movable half (MH): _____		
Number of cooling/heating circuits (FH): _____ Number of cooling/heating circuits (MH): _____		
4.4.2 Cooled/heated mould components		
Inserts	<input type="checkbox"/>	
Cores	<input type="checkbox"/>	
Threaded cores	<input type="checkbox"/>	
Slides	<input type="checkbox"/>	
Cavity plates	<input type="checkbox"/>	
Backing plates	<input type="checkbox"/>	
Clamping plates	<input type="checkbox"/>	
4.4.3 Thermal insulating sheets		
	Supplier	National standard or ISO
Fixed half (FH)	<input type="checkbox"/>	<input type="checkbox"/>
Movable half (MH)	<input type="checkbox"/>	<input type="checkbox"/>
4.4.4 Cooling nipple		
	Supplier	National standard or ISO
Design		
— with open passage	<input type="checkbox"/>	<input type="checkbox"/>
— with valve	<input type="checkbox"/>	<input type="checkbox"/>
Mounting position		
— countersunk	<input type="checkbox"/>	<input type="checkbox"/>
— projecting	<input type="checkbox"/>	<input type="checkbox"/>
Size of connecting thread	<input type="checkbox"/>	<input type="checkbox"/>
4.4.5 Electric mould heating		
	Supplier	National standard or ISO
Cartridge heaters		
— cylindrical	<input type="checkbox"/>	<input type="checkbox"/>
— tapered	<input type="checkbox"/>	<input type="checkbox"/>
Heating coil	<input type="checkbox"/>	<input type="checkbox"/>
Band heater	<input type="checkbox"/>	<input type="checkbox"/>

4.5 Demoulding			
Slide	<input type="checkbox"/>	In horizontal position	<input type="checkbox"/> Position of rotating wedge <input type="checkbox"/>
Slide drive system:			
Angle pin	<input type="checkbox"/>	Hydraulic system	<input type="checkbox"/> Locking piece <input type="checkbox"/>
Other			
Ejector system:	<input type="checkbox"/>	Fixed half	<input type="checkbox"/> Movable half <input type="checkbox"/>
Ejector plates, guided:			
Slide guide	<input type="checkbox"/>	Ball guide	<input type="checkbox"/>
Other	<input type="checkbox"/>		
Air activity:		Air valve	<input type="checkbox"/> Blow off strip <input type="checkbox"/>
		Supplier	National standard or ISO
Two-stage ejector	<input type="checkbox"/>	<input type="checkbox"/>
Latch locking unit	<input type="checkbox"/>	<input type="checkbox"/>
Angle ejector	<input type="checkbox"/>	<input type="checkbox"/>
Thread removal by:			
— helical spindle	<input type="checkbox"/>	<input type="checkbox"/>
— rack hydraulic system	<input type="checkbox"/>	<input type="checkbox"/>
— collapsible core	<input type="checkbox"/>	<input type="checkbox"/>
Drive:			
— hydromotor	<input type="checkbox"/>	<input type="checkbox"/>
— hydraulic system	<input type="checkbox"/>	<input type="checkbox"/>
— electrically, e.g. servo motor	<input type="checkbox"/>	<input type="checkbox"/>
4.6 Process control			
		Supplier	National standard or ISO
Internal mould pressure:			
— pressure transducer	<input type="checkbox"/>	<input type="checkbox"/>
— measuring pin	<input type="checkbox"/>	<input type="checkbox"/>
Temperature control device	<input type="checkbox"/>	<input type="checkbox"/>
Thermocouple	<input type="checkbox"/>	
Position monitoring by micro switch:			
Slide	on <input type="checkbox"/>	off <input type="checkbox"/>
Ejector	on <input type="checkbox"/>	off <input type="checkbox"/>
Core puller	on <input type="checkbox"/>	off <input type="checkbox"/>

4.7 Mould centring of fixed half and movable half by								
				Supplier		National standard or ISO		
Tool centring of fixed half and movable half by								
— tapered locating units				<input type="checkbox"/>		<input type="checkbox"/>		
— prismatic locating units				<input type="checkbox"/>		<input type="checkbox"/>		
— self-centring inserts				<input type="checkbox"/>		<input type="checkbox"/>		
— square locating units				<input type="checkbox"/>		<input type="checkbox"/>		
5 Mould steel grades, heat treatment								
Designation	Fixed half	Movable half	Hardened	Case-hardened	Tempered	Nitrided	Other treatment	Hardness
Clamping plate								
Cavity plate								
Backing plate								
Ejector retainer plate								
Ejector base plate								
Risers								
Inserts								
Slides								
Other								
6 Surfaces								
Surfaces shall be manufactured in accordance with the specification of the moulding drawing.								
Within the area of direction of removal from the mould: line-polished, parallel to the direction of removal.								
Coating of cores and cavities								
	Fixed half				Movable half			
TIC	<input type="checkbox"/>				<input type="checkbox"/>			
Chromium-plated	<input type="checkbox"/>				<input type="checkbox"/>			
Nickel-plated	<input type="checkbox"/>				<input type="checkbox"/>			
Other coating	<input type="checkbox"/>				<input type="checkbox"/>			