

Early Cost Estimation for Injection Molded Components

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Cost and performance estimation are frequently used at early stages of product development to determine feasibility and drive critical design decisions. Early cost estimation has been hampered by the unavailability and uncertainty of information. This paper derives cost estimates from a complexity metric as defined by the number of dimensions that uniquely define the part geometry. Dimensionality and other critical design variables can be automatically assessed within modern computer aided design systems throughout the product development process to provide continual feedback regarding tooling, process, and material costs. The complexity-based models were developed and tested with empirical data for thirty injection molded parts from different suppliers and was found to have a highly significant correlation with mold costs and tooling lead-times. Models for estimating material and processing costs and yield at the early stages of design are also developed. The developed methods enable real time evaluation of the effects of a product design on its tooling cost, tooling lead time, processing costs, and yield at the early stages of design.

INTRODUCTION

The injection molding process is increasingly being used in the manufacture of complex net shaped parts of industrial and domestic electronic and electrical appliances. Designers are taking advantage of improvements in the process capability and engineering materials by consolidating multiple parts and functions into complex parts. One of the most frequently used set of guidelines for parts consolidation is the Design for Manufacture and Assembly (DFMA) guidelines developed by Boothroyd and Dewhurst [1]. One significant benefit of DFMA is the considerable savings in assembly cost from fewer parts that need to be assembled. Other inherent benefits of DFMA are the encouragement of teamwork between design and manufacturing, and the improved product reliability from the reduced probability of system failure because of component failure.

In spite of expected savings in assembly costs, complex parts have longer tooling lead-times, higher tooling costs, and potentially lower production yields. Hence, the net benefits of parts consolidation may be uncertain. However, the effects of parts consolidation on mold tooling cost and lead-time have not previously been quantified. The amortized tooling costs of injection molded parts constitute a very significant portion of their manufacturing costs, especially for technical

applications. Tooling lead-times are also very important factors in today's very competitive market environments.

The early stages of product design provide a good opportunity for the optimization of these factors. However, in industry cost estimations are usually done when the design is well detailed, and by departments that are external to design. At this late stage of design, there is considerable inertia against any drastic changes. Tools for evaluating alternative design configurations for costs and tooling lead-times, from the computer-aided product data, will greatly facilitate optimization of component consolidation.

RESEARCH OBJECTIVES

The research vision is to develop real-time design evaluation techniques that are available at very early stages of design. Advanced analysis techniques have been developed to provide many estimates of design performance. Typical types of analyses used in molded part design include structural (stiffness, impact, creep, fatigue), manufacturability (pressure distribution, cooling, shrinkage, fiber orientation), and economic (amortized tooling cost, material costs, machine costs). However, these numerical simulations may require complex meshes and boundary conditions to be built on top of detailed geometry. As such, advanced analyses tend

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