

Two-shot co-injection molding is preferred over insert-molding

Use the correct type of TPE for a given substrate

Ensure adequate thickness of TPE over-mold (thicker is better)

Ensure that TPE material is dry (substrate material too)

Use melt temperature on the high side of the range

Use mold temperature on the high side of the range

Injection speed should be as fast as possible

Vent the mold as much as possible

Texture substrate material if possible

Ensure substrate material is clean (if insert molding)

Pre-heat substrate material (if insert molding)

Flame or corona treat substrate material (if insert molding)

Use mechanical interlocks for additional over-mold adhesion

Use good shut-offs (do NOT feather / thin)

Ensure resin rich surface if substrate material is reinforced