

Porosity (VE)

Porosity (or micro-voids) might be observed on parts usually made of reinforced polymers for some specific processing conditions and/or the design (gate included). The related property to look at while trying to predict it is the volumetric shrinkage. As a reminder, it is the percentage increase in local density from the end of the packing phase to when the part has cooled to the ambient temperature. If for some reasons, the local packing efficiency is limited, porosity might occur (and/or sink marks at the surface for unreinforced polymers). In order to correlate somehow the volumetric shrinkage distribution as predicted by Moldflow or Moldex, an internal study was performed, as described in this [document](#).