Compression Molding Cycle Time

How-to guide: what the workbook does, how to use it and what every number means. mfgcalcs.com

Compression Molding Cycle Time

Work out every compression moulding job's cycle, parts per hour and the press hours its order needs, and see which presses' jobs fit the hours they have.

For: Process engineers, production planners and estimators at rubber, elastomer, composite and thermoset compression moulders.

Version 1.0.0 · updated 11 November 2026

Quick start

1. On Setup, type the plant and planning period, and list your presses with the hours each has in the period.
2. On Jobs, give each job a row: press, order quantity, cavities, the load, close, cure and demould minutes, and an allowance.
3. Fix anything the Check column names.
4. Open the Dashboard: required against available hours by press, and where each cycle's minutes go.

What is in the workbook

Start Here	Read this first: what the workbook does and how to use it.
Setup	Plant, planning period, the near-capacity threshold, and the presses with their available hours.
Jobs	One row per moulding job: cycle segments, cavities and quantity in; parts per hour and press hours out.
Dashboard	Press hours required against available for every press, and where each job's cycle minutes go.
Method	How every number is calculated, with assumptions, limits and sources.
Verify	Self-check: the workbook's formulas recomputed on fixed inputs against an independent reference.

What each number means

Quantity	How it is calculated	Units
Cycle	Load + close and breathe + cure + open and demould.	min
Parts per minute	Cavities / cycle.	parts/min
Parts per hour	Parts per minute x 60.	parts/h
Cure share	Cure / cycle.	%
Base hours	Order quantity / parts per minute / 60.	h
Required hours	Base hours x (1 + allowance).	h

Quantity	How it is calculated	Units
Press load	Required hours of the press's jobs / its available hours.	%
Status	Over capacity above 100%; Near capacity from the threshold on Setup; Under capacity below it.	-

Assumptions, limitations, sources and the self-check (the Verify sheet, which recomputes the workbook's formulas on fixed test inputs) are in the workbook. The last page shows the Dashboard with the example data for Dunmore Rubber, a fictional business.

Free from MFG Calcs - keep this credit when you share it.

Engineering estimates for planning and improvement work. Verify the results against your own process, data and standards before you rely on them.

Compression Molding Cycle Time

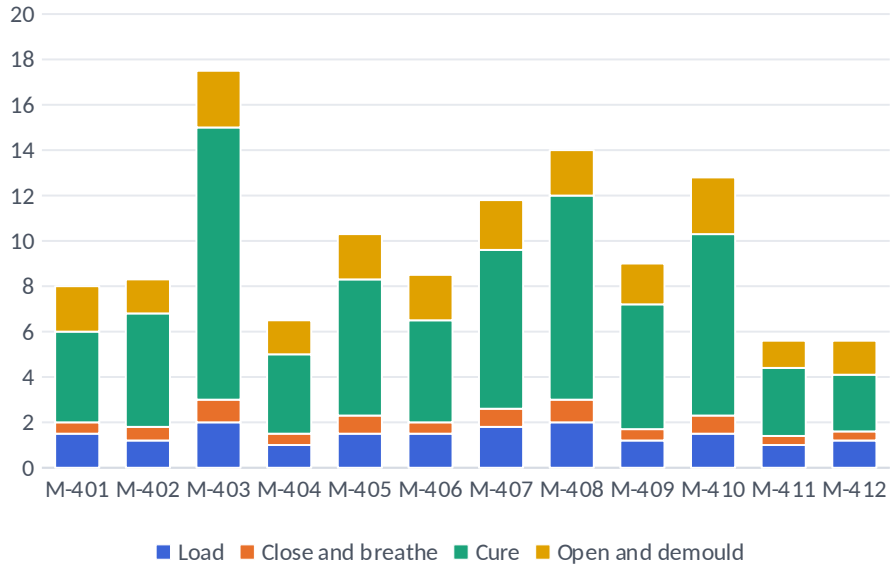
Press hours required against available for every press, and where each job's cycle minutes go.

mfgcalcs.com

Dunmore Rubber, moulding hall (example), Week 46: 12 jobs, 69,600 parts on 6 presses.

JOBS	PRESS HOURS REQUIRED	PRESSES OVER CAPACITY	BUSIEST PRESS LOAD
12	519.3	1	142.6%
Rows on Jobs	With each job's allowance	Required above available	Required / available hours

Where each cycle's minutes go



Required against available hours by press

