

	Injection Trial Data / 注塑工艺参数表	Mould Manufacturing No. / 模具制造编号			
		Trial No. / 试模次数	T-1		
		Record by / 工艺员	Elle	Date of trial / 试模日	2015/7/6

Information of Product / 产品信息				
Customer / 顾客	Customer company co., Ltd			
Part Name / 产品名称	0			
Part Number / 产品型号	0			
	Water Jet / 888	Material Code / 材料编号	Product Weight (g) / 制品重量	Runner Weight (g) / 料筒重量
	ABS	GP22	20	5.5

Specification of Trial Injection Machine / 试模注塑机信息	
Injection Machine Model Name & No. / 注塑机名称、型号	HTF 160T
Maximum Clamping Force (Ton) / 最大锁模力	160
Maximum Inj. Pressure (MPa) / 最大注塑压力	160
Screw Diameter (mm) / 螺杆直径	45
Maximum Inj. Capacity (cm <sup>3</sup> ) / 最大注塑容量	320

Injection Trial Data / 注塑工艺参数				
● Injection Machine Model / 注塑机型号	FANUC100			
● Clamping Force (Ton) / 锁模力	60			
● Cycle Time (sec) / 成型周期	Take out samples by hands. / 用手取出样品			
	Cooling Time / 冷却时间		Open/Close Time / 开关模	
	15		0	
	Open / 开模	*Take out / 取出	Close / 关模	
	4	3	4	
	Fill Time / 填充时间	Packing / 保压	Total Cycle Time 成型周期	
	1.5	5.4	32	
● Drying Material / 材料干燥	Temp. (C) / 温度	80	Time (hours) / 小时	4
● Material Temperature (C) / 熔体温度	Temp. setting / 设定温度			
	230	245	240	230
			220	0
				/
● Charge / 预塑	Charge End Position (mm) / 预塑位置			
	80			
	Screw Rotate Speed (rpm) / 螺杆转速			
	80			
	Back Pressure (Bar) / 背压			
	5			
	Sack Back Offset (mm) / 射退距离			
	5			

Injection Trial Data / 注塑工艺参数				
● Injection / 注射	Inj. Control Position (mm) / 注射控制位置			
	/	0	38	60
	5	4	3	2
	/	0	0	1000
	/	0	30	30
	Inj. Pressure (MPa) / 注射压力			
	Inj. Speed (cm/s) / 注射速度			
	Packing Pressure Transfer Position (mm) / 转保压位置			
	38			
	Cushion (mm) / 保压持点位置			
	11			
	1st. Packing / 第一段保压	Time (s) / 时间	Pres. (MPa) / 压力	Speed (cm/s) / 速度
		5	800	10
	2nd. Packing / 第二段保压	/	/	/
	3rd. Packing / 第三段保压	/	/	/
● Mould Temperature Control / 控制模具温度	Stationary side / 固定侧		Movement side / 移动侧	
Core Temp. Setting / 设定温度	55		35	
Surface Temp. (C) / 模具表面温度	55		35	

# Injection Molding Universal Setup Sheet

**Arturo Cuomo**



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web may 6 2015 by jesse schedeen posted may 6 2015 1 01 pm of the three series to debut in dc s slowly growing earth one line so far superman batman and teen titans batman earth one is easily

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jul 8 1999 the worry when faced with the follow up to books as good as harry potter and the philosopher s stone and harry potter and the chamber of secrets both winners of the nestlé smarties prize gold award is that it won t be as good with j k rowling s harry potter and the prisoner of azkaban any concerns are banished from page one this the third in the series

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oct 1 2001 harry potter and the prisoner of azkaban is an outstanding third book in this series rowling continues to develop each character carefully and masterfully she is without question one of the most gifted writers of our time

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