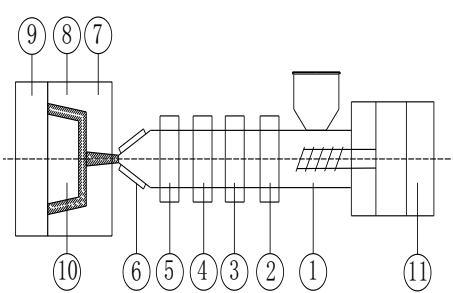


Customer	XXX	product name	HANDLE
Date of molding	Jan. 31 2021	mould number	XXX
Tiebar Distance(LxWmm)	890x940	Part Number	xxx
Clamp Force (T)	700	Material:name/code	ABS:TERLURAN HI-10:BK
Barrel Capacity (g)	2262	shrinkage	1.006
		color:	Black
		Number of cavities	4

Real weights

Product weight	1037.5g/4pcs	gram
Shot weight	1037.5+11.2=1048.7g	gram



Actual times

Cycle time	255	sec
Injection time	10	sec
Injection speed	15%	sec
Plasticize time		sec
1st holding time	5	sec
Cylinder entering time		sec
Cylinder in Speed:	Pressure:	
Cylinder going out time		sec
Cylinder out Speed:	Pressure:	
Cooling time	180	sec
Ejection (actual strokes)		
Screw speed		sec

Temperatures

Temperature pre-drying	80	°C
Pre-drying Time	3	Hours
Temperature zone ①	200	°C
Temperature zone ②	210	°C
Temperature zone ③	220	°C
Temperature zone ④	230	°C
Temperature zone ⑤	230	°C
Temperature nozzle ⑥	230	°C

Pressures

Mould safety		kN	Hot Runner Temperature
Clamping force	140	g/cm2	Zone 1
Mold Close	Position	Speed	Zone 2
Slow Mold Open	Position	Speed	Zone 3
Fast Mold Open	Position	Speed	Zone 4
Mold Open Limit	Position	Speed	Zone 5
			Zone 6~11

1st Injection	Position	240	Speed	15%	Pressure	65%
2nd Injection	Position	230	Speed	35%	Pressure	140%
3rd Injection	Position	58	Speed	80%	Pressure	110%
holding pressure-	Position		Speed		Pressure	
First Gag	Time	15	Speed	10%	Pressure (bar)	90
Second Gas	Time	60	Speed	15%	Pressure (bar)	115
First Gag	Time	15	Speed		Pressure (bar)	90
Second Gas	Time	60	Speed		Pressure (bar)	115
Back pressure; (11) set		8 kg/cm ²	Speed	60%	Pressure	120%
Melting	Position	250+5	Speed	40%	Pressure	100%
Ejector Forward			Speed	10%	Pressure	30%
Ejector backward			Speed		Pressure	

Gas Circuit I
Gas Circuit II

Remarks: The mold could run automatically well. 35 °C hot water was used in both cavity and core side. Delayer Time: 0s, 0.8s, 1.98s, 1.88s.