Ist holding time       5       Sec       Pre-drying Time       3       46         Cylinder entering time       sec       0         Cylinder in Speed:       Pressure:       Temperature zone ①       200         Cylinder out Speed:       Pressure:       Temperature zone ②       210       0         Cylinder out Speed:       Pressure:       Temperature zone ③       220       0         Cooling time       180       sec       Temperature zone ④       230       0         Ejection (actual strokes)       Temperature zone ⑤       230       0       0         Screw speed       Sec       Temperature nozzle ⑥       230       0       0         Pressures       Real temperatures mould       Mould safety       N       Hot Runner Temperature       0       0         Mold Close       Position       Speed       Zone 1       230       0       0         Sow Mold Open Position       Speed       Zone 2       230       0       0         Mold Open Limit       Position       Speed       Zone 3       230       0         Stat Injection       Position       Speed       Zone 5       230       0         Tast Injection       Position       Speed </th <th colspan="3">Customer XXX</th> <th></th> <th colspan="2">product name H</th> <th colspan="2">ANDLE</th>	Customer XXX				product name H		ANDLE		
lebar Distance(LxWmm) 890×940       Screw       80       Material:name/code       ABS:TERLURAN HI-10:B         Barel Capacity (g)       2262       Shrinkage       1.006         Barel Capacity (g)       2262       Black         Real weights       1037.5g/4pcs       gram         Product weight       1037.5g/4pcs       gram         Shot weight       1037.5g/4pcs       gram         Actual times       255       sec         Cycle time       255       sec         Injection time       10       sec         Temperature pre-drying       80       C         Injection speed       15%       sec         Temperature pre-drying       80       C         Vinder online       5       sec         Cylinder out Speed:       Pressure:       Temperature zone ©       220         Cylinder out Speed:       Pressure:       Temperature zone ©       230       C         Cylinder out Speed:       Pressure:       Temperature zone ©       230       C         Cylinder out Speed:       Pressure       Temperature zone ©       230       C         Cylinder out Speed:       Pressure       Temperature zone ©       230       C         Cylinde						mould number	XX	X	
Barrel Capacity (g) 2262 color: Black Number of cavities 4 Actual times Cycle time 255 sec Injection time 100 sec Injection speed 15% sec Injection speed 15% sec Cylinder entering time 5 sec Cylinder ontering time 5 sec Cylinder onterving time 5 sec Cooling time 180 sec Temperature zone 3 220 Cooling time 180 sec Temperature zone 3 230 Cooling time 5 speed Cone 2 230 Cooling time 5 speed Cone 2 230 Cooling time 5 speed Cone 2 230 Cooling time 5 speed Cone 6-11 230 Cone 6-11 Cone 6-1 Cone	Date of molding	Jan. 31	2021			Part Number	XX	X	
Barrel Capacity (g) 2262 color: Black Number of cavities 4 Actual times Cycle time 255 sec Injection time 100 sec Injection speed 15% sec Injection speed 15% sec Cylinder entering time 5 sec Cylinder ontering time 5 sec Cylinder onterving time 5 sec Cooling time 180 sec Temperature zone 3 220 Cooling time 180 sec Temperature zone 3 230 Cooling time 5 speed Cone 2 230 Cooling time 5 speed Cone 2 230 Cooling time 5 speed Cone 2 230 Cooling time 5 speed Cone 6-11 230 Cone 6-11 Cone 6-1 Cone	Tiebar Distance(LxWmm) 890×940 Screw				80	Material:name/co	de AE	S:TERLURAN HI-	10:Bł
Number of cavities       4         Real weights       1037.5g/4pcs       gram         Product weight       1037.5g/4pcs       gram         Shot weight       1037.5111.2=1048.7g gram       Image: Comparison of	Clamp Force (T) 700 Diameter(mm)					shrinkage			
Real weights       1037.5g/4pcs       gram         Shot weight       1037.5f/1.2=1048.7g gram       Image: Construct of the second se	Barrel Capacity (g)	226	2					ack	
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         Injection speed       15%       sec         Plasticize time       sec       remperature pre-drying       80         Cylinder entering time       sec       remperature zone ①       200         Cylinder out Speed:       Pressure:       Temperature zone ②       210         Cylinder out Speed:       Pressure:       Temperature zone ③       220         Cooling time       180       sec       Temperature zone ④       230       °         Cylinder out Speed:       Pressure:       Temperature zone ④       230       °         Cylinder out Speed:       Pressure:       Temperature zone ④       230       °         Serew speed       sec       Temperature zone ④       230       °         Mold safety       KN       Hot Runer Temperatures       230       °         Mold Safety       KN       Hot Runer Temperature       230       °         St Injection       Speed       Zone 1 <td>Pool woight</td> <td><b>C</b></td> <td></td> <td></td> <td></td> <td>Number of cavitie</td> <td>es 4</td> <td></td> <td></td>	Pool woight	<b>C</b>				Number of cavitie	es 4		
Shot weight       1037.5+11.2=1048.7g gram         Actual times       255         Cycle time       255         Injection time       10         sec       10         Injection speed       15%         sec       Temperature pre-drying         Plasticize time       5         sec       Temperature pre-drying         Quinder entring time       5         Sec       Pre-drying Time         Cylinder out Speed:       Pressure:         Temperature zone       220         Cylinder out Speed:       Pressure:         Temperature zone       230         Cooling time       180         Sec       Temperature zone         Cooling time       180         Sec       Temperature zone         Cooling time       180         Sec       Temperature zone         Catual strokes)       Temperature zone         Serew speed       Sec         Temperature sone       230         Catual strokes)       Temperature zone         Serew speed       Sec         Temperature zone       230         Serew speed       Sec         Sow Mold Open Position       Spee			1037 5	alance	arom	(9)(8)(7)			
Actual times       255       sec         Cycle time       10       sec       10       if (if (if (if (if (if (if (if (if (if (									
Actual times       255       sec         Injection time       10       sec         Injection speed       15%       sec         Plasticize time       sec       Temperature pre-drying       80         St holding time       5       sec       Temperature pre-drying       80       0         St holding time       5       sec       Temperature zone 0       200         Cylinder entering time       sec       Temperature zone 0       200         Cylinder out Speed:       Pressure:       Temperature zone 0       200         Cylinder out Speed:       Pressure:       Temperature zone 0       230       0         Cooling time       180       Sec       Temperature zone 0       230       0         Cooling time       180       Sec       Temperature zone 0       230       0         Screw speed       Sec       Temperature mozzle 0       230       0         Mould safety       KN       Hot Runner Temperature       230       0         Mould close       Position       Speed       Zone 2       230       0         Sow Mold Open       Position       Speed       Zone 5       230       0         Mold Close       Position <td>Shot weight</td> <td></td> <td>1037.5+11</td> <td>.2=1048.7g</td> <td>gram</td> <td></td> <td>╕п┶┵</td> <td></td> <td></td>	Shot weight		1037.5+11	.2=1048.7g	gram		╕п┶┵		
Cycle time         255         sec         Important construction           Injection time         10         sec         Important construction         Important construction           Plasticize time         sec         Temperature pre-drying         80         Sec           Plasticize time         sec         Temperature pre-drying         80         Sec           Cyclinder entering time         5         sec         Pre-drying         Important construction         200           Cylinder entering time         sec         Temperature zone Important cons Importa	Actual times						+-+ <i>[7]]]</i>		
Injection time         10         sec         10         6         13         10           Injection speed         15%         sec         Temperatures         Plasticize time         80         0           Plasticize time         5         sec         Temperature pre-drying         80         0           Ist holding time         5         sec         Temperature pre-drying Time         3         Max           Cylinder entering time         Sec         Temperature zone 10         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200         200			2	55	sec				
Injection speed       15%       sec       Temperatures         Plasticize time       \$ec       Temperature pre-drying       80       6         Stat holding time       5       sec       Pre-drying Time       3       Ha         Cylinder entering time       5       sec       Pre-drying Time       3       Ha         Cylinder out speed:       Pressure:       Temperature zone ①       200       200         Cylinder out speed:       Pressure:       Temperature zone ②       210       °         Cylinder out speed:       Pressure:       Temperature zone ③       220       °         Cooling time       180       sec       Temperature zone ③       230       °         Cooling time       180       sec       Temperature zone ⑤       230       °         Serw speed       Sec       Temperature nozzle ⑥       230       °         Pressures       Real temperatures mould       Mould safety       KN       Hot Runner Temperature       °         Calamping force       140       J/cm2 Zone 1       230       °       °         Stat Mold Open       Position       Speed       Zone 2       230       °         Mold Open       Position       Speed			1	0	sec	(10) $(6)$ $(5)$ $(4)$	(3)(2)(1)		
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Ist holding time     5     Sec     Pre-drying Time     3     Har       Cylinder entering time     Sec     Temperature zone ①     200       Cylinder in Speed:     Pressure:     Temperature zone ②     210     0       Cylinder out Speed:     Pressure:     Temperature zone ②     220       Cooling time     180     Sec     Temperature zone ③     220       Cooling time     180     Sec     Temperature zone ③     230     0       Screw speed     Sec     Temperature zone ⑤     230     0       Screw speed     Sec     Temperature nozzle ⑥     230     0       Mold Close     Position     Speed     Zone 1     230     0       Sow Mold Open     Position     Speed     Zone 2     230     0       Sow Mold Open     Position     Speed     Zone 2     230     0       Kold Close     Position     Speed     Zone 2     230     0       Kold Open     Position     Speed     Zone 2     230     0       Kold Open Position     Speed     Zone 3     230     0       Kold Open Limit     Position     Speed     Zone 5     230     0       Ist Injection     Position     Speed     Speed     Pressu					sec	Temperature pre	-drying	80	°(
Cylinder entering time       sec       o         Cylinder in Speed:       Pressure:       Temperature zone ①       200         Cylinder going out time       sec       Temperature zone ②       210       o         Cylinder out Speed:       Pressure:       Temperature zone ③       220         Cooling time       180       sec       Temperature zone ③       230       o         Cooling time       180       sec       Temperature zone ⑤       230       o         Ejection (actual strokes)       Temperature zone ⑥       230       o       o         Screw speed       sec       Temperature nozzle ⑥       230       o         Pressures       Real temperatures mould       Mould safety       KN       Hot Runner Temperature         Clamping force       140       j/cm2       Zone 1       230       o         Mold Cose       Position       Speed       Zone 2       230       o         Sow Mold Open       Position       Speed       Zone 4       230       o         Mold Open       Position       Speed       Zone 5       230       o         Stat Mold Open       Position       Speed       Zone 5       230       o         Mold Op	Ist holding time		ţ	5	sec			3	Hou
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Cylinder out Speed:         Pressure:         Temperature zone ③         220           Cooling time         180         sec         Temperature zone ④         230         °           Ejection (actual strokes)         Temperature zone ⑤         230         °           Screw speed         sec         Temperature zone ⑥         230         °           Pressures         Real temperature nozzle ⑥         230         °           Mould safety         kN         Hot Runner Temperatures         230         °           Mould safety         kN         Hot Runner Temperature         230         °           Mould Safety         kN         Hot Runner Temperature         230         °           Mould Close         Position         Speed         Zone 1         230         °           Slow Mold Open         Position         Speed         Zone 3         230         °           Mold Open         Position         Speed         Zone 4         230         °           Mold Open         Position         Speed         Zone 5         230         °           Temperature zone 65%         Zone 6         230         °         °           And Injection         Position         Speed		time						210	°(
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Screw speed       sec       Temperature nozzle (©)       230       0         Pressures       Real temperatures mould         Mould safety       kN       Hot Runner Temperature         Clamping force       140       3/cm2       Zone 1       230       0         Mold Close       Position       Speed       Zone 2       230       0         Mold Close       Position       Speed       Zone 2       230       0         Slow Mold Open       Position       Speed       Zone 3       230       0         Fast Mold Open       Position       Speed       Zone 4       230       0         Mold Open Limit       Position       Speed       Zone 5       230       0         Mold Open Limit       Position       Speed       Zone 5       230       0         Zone 6~11       230       Speed       Zone 5       230       0         Its Injection       Position       Speed       15%       Pressure       65%         2nd Injection       Position       58       Speed       80%       Pressure       110%         Shoding pressure       Position       Speed       10%       Pressure       110%       Gas Circuit I <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>~</td> <td>230</td> <td>)°</td>							~	230	)°
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	Ejector backward			Speed		Pressure	2070		