

	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	Elia	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 (cm3) / 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		
Fill Time / 填充时间	Packing / 保压	Charge Time / 成型时间	Open / 开模	*Take out / 取出	
1.5		5.4	4	3	
			Close / 关模	4	
			Total Cycle Time 成型周期		
			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
/	/	4	3	2
/	/	0	0	1000
/	/	0	30	30
		Inj. Pressure (MPa) / 注射压力		
		Inj. Speed (cm/s) / 注射速度		
Back 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
2nd. Packing / 第二段保压		5	800	10
3rd. Packing / 第三段保压		/	/	/
● Mould Temperature Control / 控制模具温度		Stationary side / 固定侧		
Core Temp. Setting / 设定温度		55		
Surface Temp. (C) / 模具表面温度		55		
		Movement side / 移动侧		
		35		
		35		

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