

| | | | | | |
|---|--------------------------------|----------------------------------|------|---------------------|----------|
|  | 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 (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 | |
| | 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 |
| | / | 0 | 60 | 70 |
| | 5 | 4 | 3 | 2 |
| | / | 0 | 0 | 1 |
| | / | / | 0 | 1000 |
| | / | / | 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 |
| | | 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

Xiaolong Qi



Injection Molding Universal Setup Sheet:

Injection Molding Universal Setup Sheet Book Review: Unveiling the Power of Words

In a world driven by information and connectivity, the ability of words has been evident than ever. They have the capacity to inspire, provoke, and ignite change. Such may be the essence of the book **Injection Molding Universal Setup Sheet**, a literary masterpiece that delves deep into the significance of words and their affect our lives. Published by a renowned author, this captivating work takes readers on a transformative journey, unraveling the secrets and potential behind every word. In this review, we shall explore the book's key themes, examine its writing style, and analyze its overall affect readers.

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