

	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	

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AW Rasmussen



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