

	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				1.60	
Maximum Inj. Pressure (MPa) / 最大注塑压力				1.09	
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	Close / 关模
1.5		5.4	4	3	4
Total Cycle Time 成型周期					32
● Drying Material / 材料干燥			Temp. (C) / 温度	80	Time (hours) / 小时
● 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			85		
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	70
/	/	4	3	2	1
/	/	0	0	0	1000
/	/	0	30	30	30
Inj. Pressure (MPa) / 注射压力					
Inj. Speed (cm/s) / 注射速度					
Packing 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		/	800	10	
3rd. Packing / 第三段保压		/	/	/	
● Mould Temperature Control / 控制模具温度					
Cooling / 冷却		Stationary side / 固定侧		Movement side / 移动侧	
Temp. Setting / 设定温度		55		35	
Surface Temp. (C) / 模具表面温度		55		35	

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