

	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				1.0P	
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			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	70
/	/	5	4	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		6	800	10	
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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web die intensivpflege ist ein spezialgebiet der krankenpflege und ein kernbestandteil der intensivmedizinischen versorgung zugleich ist sie eine gemeinsame schnittstelle unterschiedlicher fachrichtungen

[fachpflegekraft für intensivpflege und anästhesie wikipedia](#) - Feb 10 2023

web fachgesundheits und krankenpflegekräfte fachkrankenschwestern und pfleger für anästhesie und intensivpflege sind gesundheits und krankenpflegekräfte die in der intensiv oder der anästhesiepflege arbeiten und zusätzlich zur dreijährigen grundausbildung eine in der regel zweijährige fachweiterbildung abgeschlossen haben