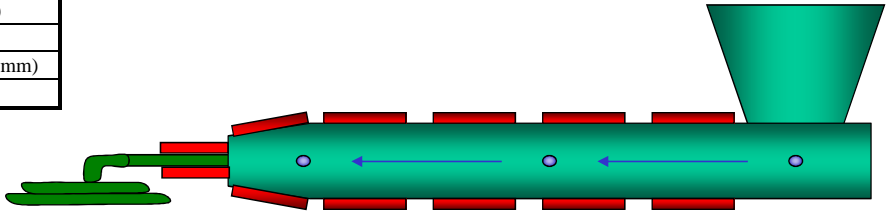


Molding Processing Sheet

Setup Date		Mold #		Press No		Machine																							
Date Last Modified		Part Description				Screw diameter	mm																						
Resin and Color						Screw diameter	inches																						
Drying Conditions	Temp	F	C	Cavities		Max Hydraulic Pressure	kg/cm2																						
	Time	hrs	Dew Point	Barrel Size gr (PS)		Max Injection Pressure	kg/cm2																						
Specific Gravity (<i>Current material</i>)		% Barrel Used				Intensification Ratio																							
Specific Gravity (<i>Polystyrene</i>)	1.04	<i>Recommended 25-75%</i>	Residence Time		min		sec																						
Shot Size (mm)	Cushion (mm)																												
Transfer Point (mm)	Maximum Stroke (mm)																												
Velocity Stage Shot Weight	grams	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td rowspan="3" style="width: 10%;">Injection Unit Temp</td> <td>Melt</td> <td>Nozzle</td> <td>Front</td> <td>Middle</td> <td>Rear</td> <td>Feed Throat</td> <td>C or F</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>C</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>F</td> </tr> </table>						Injection Unit Temp	Melt	Nozzle	Front	Middle	Rear	Feed Throat	C or F							C							F
Injection Unit Temp	Melt								Nozzle	Front	Middle	Rear	Feed Throat	C or F															
														C															
							F																						
Total Shot Weight	grams																												
Good Part Weight	grams																												
		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td rowspan="3" style="width: 10%;">Mold Temp</td> <td>Cavity</td> <td>Core</td> <td>Slide 1 or Floating Plate</td> <td>Slide 2 or Floating Plate</td> <td>Slide 3 or Floating Plate</td> <td>C or F</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td>C</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td>F</td> </tr> </table>						Mold Temp	Cavity	Core	Slide 1 or Floating Plate	Slide 2 or Floating Plate	Slide 3 or Floating Plate	C or F						C						F			
Mold Temp	Cavity								Core	Slide 1 or Floating Plate	Slide 2 or Floating Plate	Slide 3 or Floating Plate	C or F																
													C																
						F																							
Injection Velocity Profile							Units																						
Inj. Velocity							mm/sec																						
Inj. Pressure							kg/cm ²																						
Position							mm																						
Time							sec																						
Hold Profile							Units																						
Velocity							mm/sec																						
Pressure							kg/cm ²																						
Time							sec																						
Times (seconds)																													
Actual Fill																													
Hold (2 nd stage)																													
Gate Seal																													
Cooling																													
Mold Open/Close																													
Recovery																													
Quoted cycle																													
Actual Cycle																													
Actual Pressures	Hydraulic	Plastic	Units																										
1st Stage Limit Set Point																													
Average Pressure at Transfer Point																													
Pressure Range at Transfer																													
Actual Hold Pressure																													
Actual Back Pressure																													
Screw RPM																													