

| RECORD OF MACHINE SETTINGS & PROCESSING CONDITIONS | | | | | |
|---|--------------------|-----------------|--|------|------------------|
| NAME OF TECHNICIAN: | | | DATE OF MOULDING TRIAL: | | |
| CLAMP FORCE USED (TONS): | | | HYDRAULIC/HEAD PRESSURE: | | |
| MOULD NAME: | | | NUMBER OF CAVITIES: | | |
| FILL TO HOLD CHANGE METHOD USED: | | | POSITION | TIME | PRESSURE |
| MATERIAL DRYER TYPE USED: | | | DRYING TIME (HRS): | | DRYING TEMP (C): |
| TIMES (SECS) | SET | ACTUAL | DISTANCES (MM) | | SET |
| FILL: | | | DOSE: | | |
| HOLD CHANGE: | | | SUCK-BACK: | | |
| HOLD (TOTAL): | | | HOLD CHANGE: | | |
| SCREW RETRACTION: | | | BACK PRESSURE CHANGE: | | |
| COOLING: | | | SCREW REVS CHANGE: | | |
| PAUSE: | | | FINAL CUSHION: | | |
| OVERALL: | | | CARRIAGE RETRACT: | | |
| CARRIAGE RETRACT: | | | MOULD OPEN STOP: | | |
| MOULD SAFETY: | | | START MOULD SAFETY: | | |
| | | | EJECTOR STROKE: | | |
| PRESSURES (BAR) | SET | ACTUAL | SPEEDS | | SET |
| INJECTION FILL: | | | MOULD CLOSE SLOW: | | |
| HOLD CHANGE: | | | MOULD CLOSE FAST: | | |
| HOLD: | | | MOULD OPEN SLOW: | | |
| 1ST BACK PRESSURE: | | | MOULD OPEN FAST: | | |
| 2ND BACK PRESSURE: | | | INJECTION FILL: | | |
| MOULD SAFETY: | | | 1ST SCREW REVS (RPM): | | |
| EJECTOR FORWARD: | | | 2ND SCREW REVS (RPM): | | |
| | | | EJECTOR FORWARD: | | |
| TEMPERATURES (C) | SET | MEASURED | SUCK BACK: | | |
| MOULD FIXED HALF: | | | | | |
| MOULD MOVING HALF: | | | AUTOMATIC OR SEMI-AUTOMATIC: | | |
| SIDE ACTIONS: | | | SPRUCE BREAK BEFORE/AFTER DOSING: | | |
| STRIPPER PLATE: | | | SHOTS PER HOUR: | | |
| MELT: | | | NUMBER OF OPERATORS: | | |
| FILL SPEED PROFILE USED (SPEEDS & SCREW POSITIONS): | | | | | |
| HOLD PRESSURE PROFILE USED (PRESSURE & TIMES): | | | | | |
| ANCILLIARIES USED | TYPE/YES/NO | | HYDRAULIC CORE DETAILS: | | |
| CHILLER | | | | | |
| TEMP CONTROLLER F/H | | | | | |
| TEMP CONTROLLER M/H | | | | | |
| AIR EJECTION | | | | | |
| SPECIAL NOZZLE | | | PARTS HANDLING/FINISHING/PACKING: | | |
| NOZZLE VALVE | | | | | |
| ROBOT | | | | | |
| SPRUE PICKER | | | | | |
| COOLING JIG | | | | | |
| SEE ATTACHED SHEET FOR COOLING CIRCUIT DIAGRAMS | | | | | |
| SPECIAL NOTES (SAFETY/START-UP/SHUT-DOWN/PURGING): | | | | | |
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