

Order No: **X**
 Mold No: **159M120 lens panorama**
 Benennung: **X**
 No. of Cavities: **2**
 Customer:

Molding Parameters

Machine size **150t** tons (max. clamping force) Screw Ø: X
 Material: **PC** Drying: 110 °C x 4 hours

Cavity No.:	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
Part weight in grams:	9.1	9.1	X	x	x	x	x	x	x	x	x	x	x	x	x	x
Sprue / runner weight in g.:	2.0															
Shot weight in grams:	20.2															

Cycle time, fully automatic: 25.0 sec. or Cycle time, manually: x sec.
 Dosing / plasticizing time: 3.0 sec.
 Cooling time: 12.0 sec.

Cylinder temperatures	Hot runner temperatures			
Feeding: °C	Adaptor bushing: x °C	Manifold: x °C		
Zone 1: 290 °C	Nozzle 1: x °C	Nozzle 7: x °C	Nozzle 13: x °C	
Zone 2: 285 °C	Nozzle 2: x °C	Nozzle 8: x °C	Nozzle 14: x °C	
Zone 3: 285 °C	Nozzle 3: x °C	Nozzle 9: x °C	Nozzle 15: x °C	
Zone 4: 280 °C	Nozzle 4: x °C	Nozzle 10: x °C	Nozzle 16: x °C	
Nozzle: 260 °C	Nozzle 5: x °C	Nozzle 11: x °C	Nozzle 17: x °C	
	Nozzle 6: x °C	Nozzle 12: x °C	Nozzle 18: x °C	

Mold temperatures: Fixed side: 120 °C
 Moving Side: 120 °C

Plasticizing / Dosing
 Plasticizing stroke: 21 mm or x cm³ Screw suck back: 30 mm or x cm³
 Screw speed: 45 rpm Back Pressure: x bars

Injection paramters

Injection Pressure:	bars (specific)	Set	Actual		
Injection speed:	mm/sec	140.0			
	or cm ³ /sec	45.0	.		
Injection (filling) time:	sec.	x	x		
Switchover position (to holding pressure):	mm	3.0	x		
	or cm ³	9.0	x		
		x	x		
Holding Pressure	bars (specific)	85.0 €	x		
Holding Pressure injection speed	mm/sec	15.0 €	x		
	or cm ³ /sec	x	x		
Holding time:	sec.	2.0 €	x		
Cushion	mm	7.0	x		
	or cm ³	x	x		
Actual clamping force (set)	tons	1500	x		

Comments: