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ETHODE	ELECTRONICS

## a Satting Chart

upplier Details plier Name:			1100		ung	GII	ari				
olier Name:											
						Tel N	0.:				
act Name:						E-ma	il:				
noral Informati	on										
			Part Nam	<u>.</u>				Tool S/N:			
			Fart Nam					No of opvitiv			
nine type.		APS	Screw Ø	mmj:				NO OI Caville			
erial.		ADO						Pre-neating			
sure recorded.		FIDSUC	inj. cylind	ier ø (mm):				Intensincati	on ratio.	inj.cylinder Ø nee	
ettings			1	-				1		<b></b> 1	
	Noz		Zone 1	Zone 2	Zone	3	Zone 4	Zone 5	Zone 6	Yoke Zone	
Cylinder Temperature:		°C	°(	<u>°C</u>		°C	<u> </u>	°C ℃	°C ₽	°C ₽	
ot Runner Temp	erature:		٠ (	<u> </u>		°C	Ĵ	°C	J°	°C	
		Ejector Side	Nozzl	e Side							
Mould Tempera	iture:	°C		°C							
	Injecti	on		Но	olding				Dosa	age	
Injection Sp	eed	cm <sup>3/</sup> s	Speed				cm <sup>3/</sup> s	Circumfe	erence Spd.	m/min	
1st Injection Fo	rce [PP]	bar	Ramp T	ïme			sec	Back Pro	essure [PP]	bar	
Switch Over	-	cm <sup>3</sup>	1st H	olding Pressure	[PP]		bar	Volume		cm <sup>3</sup>	
Injection Sp	eed	cm <sup>3/</sup> s	H	olding time			sec	Decomp	ression Spd.	cm <sup>3/</sup> s	
2nd Injection Fo	rce [PP]	bar	2nd H	olding Pressure	[PP]		bar	Decomp	ression Vol.	cm³	
Switch Over		cm <sup>3</sup>	H	olding time			sec	l			
Injection Sp	eed	cm <sup>3/</sup> s	3rd H	3rd Holding Pressure [P			bar		Monitoring		
3rd Injection Fo	rce [PP]	bar	H	olding time	sec			Injection	in time sec		
Switch Over	•	cm³	Cooling	time			sec	Inj.press	@ S/Over [PP]	bar	
				CUIVEILFIA	3116 716	้ออนเ	e 10	Max inje	ct press [PP]	bar	
				Convert Fia Hydraul	suc rie lic Pres	soure	e 10	Max inje Cushion	ct press [PP] ing	bar cm <sup>3</sup>	
				Hydraul	suc Fre lic Pres	sure	6 10	Max inje Cushion Total cyc	ct press [PP] ing cle time	bar cm <sup>3</sup> sec	
	M	ould Parameters		Hydraul	SUC FIE	ssure	e 10	Max inje Cushion Total cyc Ejector I	ct press [PP] ing cle time Parameters	bar cm <sup>3</sup> sec	
	M	ould Parameters Mould Closing	Mould	Opening	lic Pres	sure	ב נט	Max inje Cushion Total cyc Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing	bar cm <sup>3</sup> sec Mould Opening	
Speed	M	ould Parameters Mould Closing mm/s	Mould	Opening mm/s	SUC FIE	sure Spee	d	Max inje Cushion Total cyr Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s	bar cm <sup>3</sup> sec Mould Opening mm/s	
Speed 1st Force	M	ould Parameters Mould Closing mm/s KN	Mould	Opening mm/s	Suc Fres	Spee Force	d	Max inje Cushion Total cyr Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN	Mould Opening mm/s	
1st Force S/Over	M	ould Parameters Mould Closing mm/s KN mm	Mould	Dpening Mm/s KN mm	Suc Fres	Spee Force S/Ove	d a	Max inje Cushion Total cyr Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN mm	Mould Opening Mould Opening Mould Mo	
Speed 1st Force S/Over Speed	M	ould Parameters Mould Closing mm/s KN mm mm/s	Mould	Dpening mm/s KN mm mm/s	Suc Fres	Spee Force S/Ove	d er d	Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN mm mm/s	Mould Opening Mould Opening KN KN mm mm/s	
1st Force S/Over Speed 2nd Force	M	Mould Closing Mould Closing mm/s KN mm mm/s KN	Mould	Dpening mm/s KN mm mm/s KN	lic Pres	Spee Force S/Ove Force	d er d	Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN mm mm/s KN	Mould Opening Mould Opening KN KN Mm KN	
1st Force S/Over 2nd Force S/Over	M	Mould Closing Mould Closing KN KN mm mm/s KN mm	Mould	Dpening mm/s KN mm mm/s KN mm KN mm	1st	Spee Force S/Ove Spee S/Ove	d er d er	Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN mm mm/s KN mm/s KN mm	Mould Opening mm/s KN mm/s KN KN mm/s	
1st Force S/Over 2nd Force S/Over S/Over S/Over Speed	M	Mould Closing Mould Closing KN KN mm KN KN Mm mm/s	Mould	Dpening mm/s KN mm mm/s KN mm mm/s	1st	Spee Force S/Ove Spee Force S/Ove	d er er d	Max inje Cushion Total cyc Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN mm KN KN mm/s KN mm	Mould Opening mm/s KN Mould Opening mm/s KN Mmm KN mm/s	
Speed 1st Force S/Over Speed 2nd Force S/Over Speed 3rd Force	M	ould Parameters Mould Closing mm/s KN mm mm/s KN mm mm/s KN	Mould (	Dpening mm/s KN mm mm/s KN mm mm/s KN mm/s KN	Suc Fres lic Pres 1st 2nd 3rd	Spee Force S/Ove Spee Force S/Ove Spee Force	d er d er d d er	Max inje Cushion Total cyr Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN mm mm/s KN mm KN	Mould Opening Mould Opening Mould Opening KN KN Mmms KN KN KN KN KN	
1st Force S/Over 2nd Force 2nd Force S/Over 3rd Force 3rd Force S/Over	M	ould Parameters Mould Closing mm/s KN mm mm/s KN mm/s KN mm/s	Mould	Dpening mm/s KN mm mm/s KN mm mm/s KN mm	1st 2nd	Spee Force S/Ove Spee Force S/Ove Spee Force S/Ove	d er d er d er d er	Max inje Cushion Total cyr Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN mm KN mm/s KN mm mm/s KN mm	Mould Opening Mould Opening KN KN KN KN KN Mm KN KN KN KN Mm	
1st Force S/Over 2nd Force S/Over S/Over 3rd Force S/Over S/Over	<b>M</b>	ould Parameters Mould Closing mm/s KN mm mm/s KN mm mm/s KN mm Clamping Pressure	Mould	Dpening mm/s KN mm mm/s KN mm mm/s KN mm KN mm KN	1st 2nd	Spee Force S/Ove Spee Force S/Ove Spee Force	d er d er d er	Max inje Cushion Total cyr Ejector I Mo	ct press [PP] ing cle time Parameters uld Closing mm/s KN mm mm/s KN mm mm/s KN mm	Mould Opening Mould Opening Mould Opening Mm/s KN Mmm/s KN Mmm KN Mmm/s KN Mmm	

4) First copy to be filled and forward with packing graph during first trials.

5) Another updated copy to be filled and forward when OEE will take place.

6) [PP] denotes plastic pressure while [HP] denotes Hydraulic pressure.



## Matrix for ideal parameters

Type of material	ABS	]								
Injection time of MAX	2 sec	filling	up to 9	95% - 98% of	parts					
Holding pressure to be betw	een	500	bar	plastic pre	ssure u	p to	1000	bar pla	astic pressu	re
	for a MIN of	2	sec	as first holdi	ng time					
Cylinder temperature to be b	between	200	°C	up to	<b>260</b>	°C				
Hot runner to be between		210	°C	up to	<b>260</b>	°C	]			
Mould temperature to be bet	20	°C	up to	70	°C					
If a parameter is exceeded, a note is to be written on notes of our process setting chart stating why.										

Type of material	PP					
Injection time of MAX	2 sec fillir	ng up to 9	95% - 98% of	parts		
Holding pressure to be between	45	50 bar	plastic pre	ssure up to	900	bar plastic pressure
for	a MIN of	3 sec	as first holdi	ng time.		
Cylinder temperature to be betw	veen 19	0° 00	up to	230 °C		
Hot runner to be between	19	0° 00	up to	230 °C		
Mould temperature to be betwee	en 2	<b>0°C</b>	up to	45 °C		
If a parameter is exceeded	l, a note is to	be writte	en on notes	of our proc	ess set	ting chart stating why.

Type of materialPBTInjection time of MAX1.8 sec	] filling up to 95% - 98% of parts
Holding pressure to be between	600 bar plastic pressure up to 1100 bar plastic pressure
for a MIN of	<b>3 sec</b> as first holding time.
Cylinder temperature to be between	<b>250 °C</b> up to <b>290 °C</b>
Hot runner to be between	<b>265 °C</b> up to <b>300 °C</b>
Mould temperature to be between If a parameter is exceeded, a note	50 °C up to 75 °C is to be written on notes of our process setting chart stating why.

Type of material	POM	]									
Injection time of MAX	1.5 sec	filling	up to 9	95% - 98% of	parts						
Holding pressure to be betwee	600	bar	plastic pre	ssure ι	ıp to	1100	bar	plastic p	oressure		
f	or a MIN of	3	sec	as first holdi	ng time	Э.					
Cylinder temperature to be b	etween	175	°C	up to	200	°C	]				
Hot runner to be between		180	°C	up to	220	°C	]				
Mould temperature to be betw	<b>50</b>	°C	up to	75	°C	]					
If a parameter is exceed	led, a note i	s to be	e writt	en on notes	of our	proc	ess set	ting o	chart stat	ting why.	



<b>Type of material</b> Injection time of MAX	PA6.	filling	up to 9	95% - 98% of	f parts				
Holding pressure to be between	een	750	bar	plastic pre	ssure up	o to	1200	bar plastic pressure	
· · · · · · · · · · · · · · · · · · ·	for a MIN of	3	Sec	as first holdi	ng time.				
Cylinder temperature to be b	etween	255	°C	up to	300	°C			
Hot runner to be between			°C	up to	325	°C			
Mould temperature to be bet	<b>50</b>	°C	up to	75	°C				
If a parameter is excee	ded, a note i	s to be	e writte	en on notes	of our p	oroce	ss set	ting chart stating why	<b>/</b> .

Type of materialPCInjection time of MAX1.5 s	ec filling up to 95% - 98% of parts
Holding pressure to be between	600 bar plastic pressure up to 1200 bar plastic pressure
for a MIN	l of <b>3 sec</b> as first holding time.
Cylinder temperature to be between	<b>255 °C</b> up to <b>300 °C</b>
Hot runner to be between	<b>275 °C</b> up to <b>320 °C</b>
Mould temperature to be between	<b>20 °C</b> up to <b>80 °C</b>
If a parameter is exceeded, a n	ote is to be written on notes of our process setting chart stating why.

Type of material PC_ABS	]
Injection time of MAX 2 sec	filling up to 95% - 98% of parts
Holding pressure to be between	600 bar plastic pressure up to 1200 bar plastic pressure
for a MIN of	<b>3 sec</b> as first holding time.
Cylinder temperature to be between	<b>255 °C</b> up to <b>290 °C</b>
Hot runner to be between	<b>265 °C</b> up to <b>310 °C</b>
Mould temperature to be between If a parameter is exceeded, a note i	<b>20 °C</b> up to <b>80 °C</b> is to be written on notes of our process setting chart stating why.

Type of material	PC_A_S	URFA	CE	]						
Injection time of MAX	2 sec	filling	up to §	95% - 98% of	parts					
Holding pressure to be betwe	500	bar	plastic pre	ssure u	ıp to	1000	bar	plastic pressure		
f	or a MIN of	2	sec	as first holdi	ng time	<b>.</b>				
Cylinder temperature to be be	etween	200	°C	up to	<b>260</b>	°C				
Hot runner to be between		210	°C	up to	<b>260</b>	°C				
Mould temperature to be betw	20	°C	up to	70	°C					
If a parameter is exceed	led, a note i	s to be	e writt	en on notes	of our	proc	ess sett	ting cl	hart stating why	

	THOD	DDE ELECTRONICS Packing Graph Date:									
1. Supplier	Details	;				-					
Supplier Na	ame:						Tel No.:				
Contact Nar	me:						E-mail:				
2. General I	nforma	tion									
Part No.:					Part Name:			Tool S/N:			
Machine typ	pe:				Screw Ø [mm]:			No of cavities:			
Material:				ABS	Master batch [%]:			Pre-heating:	heating: °C		
		Tick Holdii	۲ ng	Holding Pressure	Net Weight S	cale 1	st Holding	Remar	ks:		
		Time	e	Time (seconds)	(grame)		(a/cm <sup>2</sup> ) V				
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						Conv to Pla	vert Hydraulic Istic Pressure				
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ght S.	0,0										
t Wei	0,0										
Ne	0,4 -										
	0,2 -										
	0 -	1		2	3 Holdin	4 Ig Pressure Tin	5 ne (Seconds)	6	7	8	
Notes: •	Input i	informatio	n nee	eded in grey sha	aded areas. All othe	er information	vill be automaticall	y copied from the	Process	Setting	Chart'
•	<ul> <li>If Erro</li> <li>submi</li> <li>Once f</li> <li>Take a</li> </ul>	r message tting the p the proces a complete	es aro backin ss is e sho	e shown on the ng graph to Meti set-up, and the j t and weigh eac	rignt hand side of t hode. packing graph is di h part individually.	the remarks se rafted, tick the Record the ind	ction, please rectify most sensible hold lividual weight in th	γ τηe process and ling time. ηe table below.	update th	ne values	s before
Cavity n	10.	1	I	2	3	4	5	6	7		8
Weight	in				, , , , , , , , , , , , , , , , , , ,		, j	ÿ	,		