



PT. SANWA ENGINEERING BATAM

Company Confidential

MOLDING DATA SHEET

Form : HM-00-010A

Part Number	Part Name	Material	Machine Description		Customer
PA03670-Y581	FB TOP COVER-L5	POLYREX PH-88 H19-A23-H8 L.GREY PS	Toshiba - Ton	550	SIIX
			Machine No	A-12	

PH 3 PH 2 PH 1			VH		VI 4		VI 3		VI 2		VI 1		P1		SRN				
27 35 18			20		27		75		70		35		92		35				
TRH 2 TRH 1			LS 4		LS 4C		LS 4B		LS 4A		LS 5		LS 10		BP				
2 2			22		32		55		92		120		3.0		20				
VOS2 VO 2 VO 1 VOS1				VC 1				VC 2				VC S				PCL		PCH	
8 22 15 9				40				30				17				70		90	

1	620	500	285	85	200	30	2.5	GENERAL TOLERANCE 5%		
EJECT COUI	LS 3	LS 3B	LS 3D	LS 3A	LS 2D	LS 2A	LS 2			
LS 32	VR	VE	LS 31		SPRUE BREAK			TR4 INTERVAL	TR3 COOLING	TR1 INJECT
25	85	3	136					2.5	37	9.0
					√					

Temperature Measurement

Description	A		B		C		D	
Cavity	NW	NW	NW	NW	NW	NW	NW	NW
Core	CH15	CH15	CH15	CH15	CH15	CH15	CH15	CH15
Slider	NW	NW	NW	NW	NW	NW	NW	NW
Hopper	Temp	Set	80	Act	80	Time	4 Hrs	

BARREL TEMPERATURE +/- 5 C

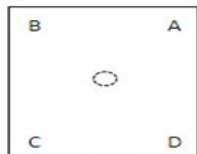
HN	H1	H2	H3	H4
250	245	235	235	220

FILL TIME	2.53	SEC
CHARGE TIME	13.10	SEC
CYCLE TIME	75.00	SEC
ACT- CUSH	5.80	MM

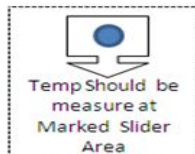
HOT RUNNER TEMP CONTROLLER +/- 5 C

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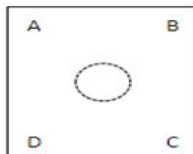
Operation View



Mold - Core



Mold - Slider



Mold - Cavity

M / C Mode



Revision :

Prepared By : Mani

Date : 19.12.19

Verify by : Balaji

Date : 19.12.19

Approved By : Pang TG

Date : 19.12.19