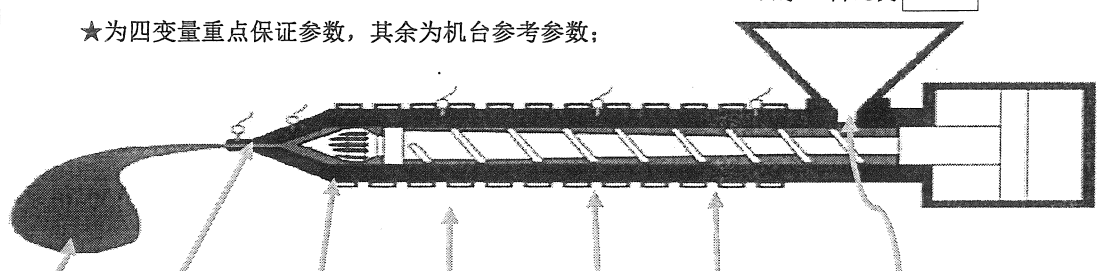


| | | | | | | | | | | | |
|------|-------|-----------|------|-------|------|------|-------|-------|------|-------|--------|
| 模具信息 | 模具编号: | ZW-4492-A | 产品信息 | 产品名称: | 测试样条 | 材料信息 | 材料名称: | PA66 | 机台信息 | 机台编号: | C12 |
| | 模具类型: | 两板模 | | 客户图番: | / | | 材料型号: | 1300G | | 机台品牌: | NISSEI |
| | 型腔数: | 2/2 | | 客户名称: | / | | 材料类型: | 结晶性材料 | | 机台吨位: | 110 T |

塑料温度相关工艺参数

| | | | | | | | | | | | | | | | | | | | | |
|---------|--|-------|-------|-------|---|---|---|---|-------|-------|----------|-------|-----------|--------|--------|--|--|--|--|--|
| 干燥时间/H | ★为四变量重点保证参数，其余为机台参考参数； | | | | | | | | | | ★水口料比例 | 0 % | ★背压/Mpa | 5 | | | | | | |
| 干燥温度/℃ |  | | | | | | | | | | 螺杆转速/rpm | 80 | 线速度(mm/s) | 134.04 | | | | | | |
| 干燥设备 | | | | | | | | | | | ★计量时间/s | 6.2 | | | | | | | | |
| 热风干燥 | | | | | | | | | | | | | | | | | | | | |
| 材料含水率 % | | | | | | | | | | | | | | | | | | | | |
| / | | | | | | | | | | | | | | | | | | | | |
| 295 | | | | | | | | | | | | | | | | | | | | |
| ★塑料温度 | | | | | | | | | | | | | | | | | | | | |
| 射嘴温度 | | | | | | | | | 端盖温度 | 前段温度 | 中段温度 | 后端温度 | 下料口温度 | 油温 | ★热流道/℃ | | | | | |
| / | | | | | | | | | / | / | / | / | / | / | / | | | | | |
| 热咀8温度 | 热咀7温度 | 热咀6温度 | 热咀5温度 | 热咀4温度 | | | | | 热咀3温度 | 热咀2温度 | 热咀1温度 | 分流板温度 | 主流道温度 | | | | | | | |
| / | / | / | / | / | / | / | / | / | / | | | | | | | | | | | |

塑料流动/压力相关工艺参数

| | | | | | | | | | | | | | | | | | |
|-------------|-------|-------|---------|---------|-------------|-----|--------|------|-------|-------|-----------|-----------|----|----|----|----|---|
| 第3段 第2段 第1段 | | | V/P切换位置 | | 第三段 第二段 第一段 | | | 螺杆位置 | | + | 抽胶距离 | | | | | | |
| 保压时间★ | / | 9 | 3 | s | 11 | mm | | 11 | 13 | 40 | mm | 3 | | | | | |
| 保压压力 | / | 110 | 40 | MPa | 塑料填充工艺参数 | | | | | | | 抽胶速度/mm/s | | | | | |
| 产品重量★ | / | 25.98 | 24.09 | g | | | | | | | | 20 | | | | | |
| 保压速度 | 20 | | mm/s | V/P切换压力 | | MPa | | 20 | | 60 | 螺杆速度/mm/s | 螺杆直径/mm | | | | | |
| 料垫位置 | 3.92 | | mm | 充填峰值压力 | | MPa | | 0.58 | | 0.5 | ★充填时间/s | 32 | | | | | |
| 型腔峰值压力★ | ★上限时间 | | 上限压力 | | | | 带水口 | | 28.91 | 27.48 | ★充填重量/g | 顶针直径/mm | | | | | |
| / | MPa | 9 | s | 200 | | | -15.25 | | 20.11 | 48.25 | 体积流量cm³/s | 5 | | | | | |
| 模穴号 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | |
| 产品重量 | / | / | / | / | / | / | / | / | / | / | / | / | / | / | / | / | g |

塑料冷却相关工艺参数

| | | | | | | | | | |
|-------|-------|-------|---|----|------|------|-----------|--|---|
| 前模 | | 后模 | | 行位 | 前模镶件 | 后模镶件 | ★冷却时间: | 12 | s |
| 冷却介质 | 水温 | 水温 | 无 | 无 | 无 | 无 | ★产品表面温度: | / | ℃ |
| 介质温度 | 90 | 90 | | | | | ★水路连接图: | <input type="checkbox"/> 无 <input checked="" type="checkbox"/> 有 | |
| ★模具温度 | 84/86 | 83/85 | | | | | ★模温测量图: | <input type="checkbox"/> 无 <input checked="" type="checkbox"/> 有 | |
| ★体积速率 | / | / | / | / | / | / | ★产品温度测量图: | <input type="checkbox"/> 无 <input checked="" type="checkbox"/> 有 | |
| | | | | | | | | L/min | |

其他相关工艺参数

| | | | | | | | | | | | | | | | |
|----------|----------|------|-------|------|--------|--------|--------|------|------|---------|---|-------------------------------|------|----|---|
| | | 高速锁模 | | 中间低速 | | 低速锁模速度 | | 低压/% | | ★高压/TON | | 模具安装参数 | | | |
| 合模 设置 | 锁模速度/%: | 40 | | / | | 15 | | 3 | | 100 | | <input type="checkbox"/> 中间低速 | 型闭速度 | 10 | % |
| | 锁模位置/mm: | / | | / | | 15 | | 0.89 | | 型闭压力 | 8 | | % | | |
| | 中间低速始 | | 中间低速终 | | 低速低压位置 | | 高速高压位置 | | 型开速度 | 10 | % | | | | |

| | | | | | | | | | | | | | | | | | | | |
|----------|------|-----|------|-----|------|------|------|------|--------|------|-------|------|---------|-----|-------|-----|-------|------|--|
| 终期开模 | | 高速2 | | 高速1 | | 初期开模 | | 顶出次数 | | 1次 | | 顶出模式 | | 1 | | | | | |
| 开模 设置 | 30 | | / | | 40 | | 30 | | 顶出压力 | | 顶出EV1 | | 顶出EV2 | | 2速度转换 | | 前进限位 | | |
| | 型开停止 | | 慢速距离 | | 高速2始 | | 高速1始 | | 40% | | 30% | | / % | | / mm | | 22 mm | | |
| | 260 | | 30 | | / | | 20 | | 反复后退位置 | | 后退EV4 | | 反复顶出EV3 | | 后退压力 | | 以及限位限 | | |
| | | | | | | | | | | / mm | | 60% | | / % | | 30% | | / mm | |
| | | | | | | | | | | | | | | | | | | | |
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