

INJECTION MOLDING APPLICATION PROCESS ASSISTANCE REQUEST

Version 7/15/2016 - R5

A. PURPOSE:

This document is intended to assist with communication regarding process related issues and suggestions. PLEASE FILL IN YELLOW CELLS WITH AS MUCH INFORMATION AS AVAILABLE.

B. CUSTOMER INFORMATION:

Name	
Company	
Location	
Email	
Telephone	

C. BACKGROUND INFORMATION:

To ensure a good understanding of the existing process / mold application, please fill out the attached description of your existing molding application and associated machine and process data.

D. PROBLEM DESCRIPTION(S) / SUGGESTION(S):

Please describe the problems being encountered with the existing process / mold application.

Problem 1 Customer Input	
Suggestion 1	
Problem 2 Customer Input	
Suggestion 2	
Problem 3 Customer Input	
Suggestion 3	
Problem 4 Customer Input	
Suggestion 4	
Problem 5 Customer Input	
Suggestion 5	

E. FORWARD THIS REQUEST TO:service@absolutehaitian.com**F. DATE:**

INJECTION MOLDING APPLICATION PROCESS / CYCLE TIME DATA

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1. EXISTING MACHINE (IF APPLICABLE)	
Manufacturer	
Model	
Year of Mfr.	
Clamp Tonnage (US Tons)	
Injection Unit Designation	
Shot Size (oz)	
Screw Diameter (mm)	
Screw L/D	
Screw Geometry	
Screw Compression Ratio	
2. PART/MOLD DATA	
Part Name	
Material	
Mold Configuration	
Sprue Configuration	
Runner Configuration	
Gate Configuration	
Ejector Configuration	
Ejector Pattern	
No. Cores - Moving	
No. Cores - Stationary	
Core Function	
No. Air Valves - Moving	
No. Air Valves - Stationary	
No. Cavities	
Projected Area - Each Part (sq. in)	
Projected Area - Sprue and Runner (sq. in)	
Projected Area - Total (sq. in)	
Ave. Wall Thickness (in)	
Min. Wall Thickness (in)	
Max. Flow Length (in)	
Flow Ratio	
Required US Tons / sq. in.	
Estimated Clamp Force - US Tons	
Mold Width - Horizontal (in)	
Mold Height - Vertical (in)	
Mold Stack Height (in)	
Required Opening Stroke (in)	
Required Ejector Stroke (in)	
Required Ejector Force (US Tons)	
Mold Weight (lbs)	
Target Cycle Time (s)	
Nozzle Radius (in)	
Nozzle Orifice (in)	
Nozzle Platen Penetration (in)	
3. INJECTION UNIT APPLICATION DATA	
Application Shot Size (g)	
Material	
Melt Density	
Desired Shot Utilization (%)	
Max. Injection Pressure (psi)	
4. CYCLE TIME APPLICATION DATA	
Injection Time- Fill (s)	
Injection Time - Hold (s)	
Cooling Time (s)	
Clamp Opening Time (s)	
Clamp Open Dwell Time (s)	
- Ejector Movement	
- Core Movement	
- Robot Take Out	
Clamp Closing Time (s)	
Recovery Time (s)	
Parallel Movement of Ejectors with Clamp	
Parallel Movement of Core(s) with Clamp	
Parallel Movement of Core(s) and Ejectors with Clamp	
Parallel Movement of Screw Rotate with Clamp	
OVERALL CYCLE TIME (s)	