

MOLD TRIAL RECORD

Date:

A. General Mold Trial Data:

Customer		Try out(N)		Mold No.	
Prod.type		Machine T (T)		Try Out(H)	hr
Item Name		Mold Shop		Try Out(M)	kg
Material		Color		Mold Maker	Part.W.
Sampling		Pcs	Try Out (N)	Shots	Gate W.
Material Batch Number					

B. Injection Molding Machine set-up:

Clamping Force :

Injection Pressure Parameters (射出)						Hold Pressure Parameters (保壓)					
Injection Press. (kg/cm ²)壓力	Inject. Speed (%) 速度	Position (mm)位置	Hold Press (kg/cm ²)壓力	Hold Speed (%)速度	Hold Time(sec)位置	Injection Press. (kg/cm ²)壓力	Inject. Speed (%) 速度	Position (mm)位置	Hold Press (kg/cm ²)壓力	Hold Speed (%)速度	Hold Time(sec)位置
1st		1st		1st		1st		1st		1st	
2nd		2nd		2nd		2nd		2nd		2nd	
3rd		3rd		3rd		3rd		3rd		3rd	
4th		4th		4 th (H)		4th		4th		4th	

F5 Temperature in the screw zones (°C) 料管溫度		Mold Temperature (°C) 模具溫度					F4	Press 壓力	Speed 速度	Locate 位置
1		Core 公模		Cavity 母模			1 st Add M 入料			
2			°C		°C		2 nd Add M 入料			
3		Hot Runner (°C) 熱膠道					Release 鬆退			
4		1	2	3	4	5	Inject (T) 射出時間			
5							Cooling (T) 冷卻時間			
6							Cycle (T) 循環時間			

C. Review of the disadvantages found on molded part (X):

1	Sticking	挽模	11	Shrinkage	縮水	21	頂破拖傷	31	膠屑浮表面
2	Checking	龜裂	12	Scratch	拖傷	22	頂出龜裂	32	頂針彈簧未設
3	Crazing	破裂	13	Shock Line	擠傷	23	離模龜裂	33	頂針未能回收
4	Missmatch	偏模	14	Surface Roughening		24	混料不良	34	Air 管風量大小
5	Blushing	頂白	15	Warpage	翹曲	25	進膠困難	35	料頭 R 角不良
6	Automatization	霧化	16	Torsion	扭曲	26	料頭易斷	36	成品卡母模
7	Short Shot	短料	17	Galling	毛邊	27	模面粗糙	37	頂破孔溢料
8	Haze&Scar	燒焦	18	Parting Line	模面撞	28	鎖模孔偏斜	38	Splay around gates
9	Deformation	變形	19	Ej. P.stress	頂出偏斜	29	頂出長度不足	39	Welding Lines
10	Overflow	溢料	20	Ejec.Hole	頂孔偏斜	30	中子動作不良	40	Air trapped in plastic

D. Inspection & Improvement Report:

責任承擔:	Approved: Goce Stefanovski
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