

JADE PROCESS SHEET

Customer:	0	Cavities:	1X32	Color:	bule	Date:	27-Sep-23
Mold #:	JG23053	Material:	HDPE	Press:	HAITIANG	Tonnage	160 T
Part#	0	Number of Sample Parts	18 shots	Trial No.	T3		

Overview	Mold Open											
Cycle Time		Mold Open	Slow	Fast	Slow		Clamping force					
18 Sec	Position(in)	10.236	9.449	1.969	0.787		130 T					
Fill Time	Speed(%)	25	25	55	25							
6 Sec												
	Mold Close											
Peak Fill Pressure		fast	Slow		HP Pos.							
1595.42 psi	Position(in)	3.937	0.787									
Melt Temperature	Speed(%)	55	35									
428 °F												
	Injection											
Recover Time		Transfer	V3	V2	V1	Shot Size	Fill Monior	Cushion				
5 Sec	Position(in)	2.165	0.000	2.362	3.937	0	4.5 sec	0.630				
A-Side Mold Temp	Speed(%)	0	30	45	35		Pressure Monitor					
86 F							1595.418 psi					
B-Side Mold Temp												
86 °F												
	Pack											
Dryer Temp		P1	P2	P3						Cooling Time		
32 °F	Pressure (psi)	797.71	0.00	0.00						2 Sec		
Dryer Time	Time (Sec)	1.5	0	0								
0 Hr												
	Recovery											
Nozzle Type	Back Pressure	Recovery	Recovery	Delay	Suck back							
hot runner	72.52 psi	95 %	0 RPM	4.5 sec	0.23622 in							
Nozzle Size												
0 in												
	Eject											
Part Weight	Eject Retract			Eject Forward				Strokes	Delay	Ej Adv Delay		
0.1133 lb	0.984	0.394 in	0.039	0.984	0.000 in	35	0 sec	0 sec				
Runner Weight	33	45 %	20	20	0 %							
0.0265 lb												
	Barrel Temperatures											
	Nozzle	Zone1	Zone2	Zone3	Zone4	Zone5	Feed Throat					
	392	383	383	365	338					°F		
	Hot Tip Temperatures											
	Tips	T1	T2	T3	T4	T5	T6	T7	T8	Sprue	Sprue 2	
		428	428	428	428	428	428	428	428	°F	°F	
		T9	T10	T11	T12	T13	T14	T15	T16	Manifold 1	Manifold 2	Manifold 3
		428	428	428	428					°F	°F	°F

Setup Notes	