ManuMold 77/30 Injection Molding M/c

Asset No: 9700000346
Categorized: Research
In-Charge: Thomas Lew
Remarks: Booking System
PI: Prof Yue Chee Yoon
RA Register: P015

**Standard Operating Procedures**

Specification:

Screw Diameter: 30 mm Maximum Vol. Displacement: 1068 bar Hydraulic Motor Speed: 140 max (For more detailed spec. refer to manual)

Operation:

1. 2. 3. 4. 5. 6. 7. 8. 9.

1. Switch "ON" the main power supply.
2. Press Heater button "ON".
3. Set Temperatures slightly below required molding temperatures.
4. Allow barrel to soak for 20 minutes
5. Wait for Temperatures to stabilize and press "START" button.
7. Load materials into hopper.
8. Turn AUTO/MANUAL switch to "MANUAL" for presetting.
9. Press the "PURGE" button and set parameters (by observing the ejected materials from the nozzle).
10. Set the cycle-time and plasticiser shot-rod. (About 4 to 5 on the scale) for the existing mold.
11. Turn AUTO/MANUAL switch to "AUTO" and the carriage will come in contact with the mold. **Confirm the machine is in "AUTO" mode and safety gate closed.

12. "PURGE" out all materials from the barrel after finishing your job (VERY IMPORTANT).

13. Ensure complete shutdown before leaving.
15. END