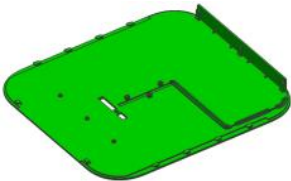


PU RIM 成形参数卡

PU RIM Forming Parameter List

文件编号:

客户名称 Customer Name	illumina	模具编号 Mold No	HSRIM23007A		成型参数表号 Forming Parameter List No.	23007A-1
产品名称 Part Name	ASSY, TOP COVER	产品编号 Part No.	20104756		机器型号 Machine Model No.	HS1002
原材料供应商 Raw Material Supplier	Bayer (Baydur 110 FR-2N)	原材料名称 Name of Raw Material	POL 1498	ISO 44P01	原材料混合比例 Raw Material Mixing Ratio	117:128=1:1.09
阻燃剂供应商 Flame Retardant Supplier	Clariant	阻燃剂名称 Name of Flame Retardant	Exploit AP422		阻燃剂添加比例 Flame Retardant Addition Ratio	17%
产品尺寸 Part Dimension	440.1X392.1X27	产品+流道重量 Part + Runner Weight	950g+50g		产品密度 Part Density	0.9-1.01g/cm³
冷水机设定温度 Chiller Controller Temperature Setting	20℃	前模设定模温 Cavity Temperature Setting	70℃		后模设定模温 Core Temperature Setting	70℃
料灌实际温度 Actual Temperature of Hopper	25℃	前模实测模温 Cavity Actual Temperature Measured	61.5℃		后模实测模温 Core Actual Temperature Measured	61.5℃
灌注程序号 Perfusion Program No.	比例 I/P Ratio I/P	灌注量 g Perfusion Amount g	灌注速度 g/s Perfusion Speed g/s		工作模式 Work Mode	
	1.09±5%	950g	300g/s		1	
主缸下行时间 s Main Cylinder Backwarding Time Secs	主缸保压时间 s Main Cylinder Holding Time Secs	切料进时间 s Material Entry Time Secs	切料退时间 s Material Withdrawal Time Secs		中子进时间 s Sequential Entry Time Secs	中子退时间 s Sequential Withdrawal Time Secs
25s	40s	NA	NA NA		NA	NA
主缸上行时间 s Main Cylinder Forwarding Time Secs	主缸上行限位高度±1cm Upper limit height of main cylinder ±1cm	顶出进时间 s Ejection Time Secs	顶出停顿时间 s Ejection Pause Time Secs		顶出退时间 s Ejection Withdrawal Time Secs	冷却时间 s Cooling Time Secs
25s	120cm	3s	5s		3s	400s
其他时间 s Other Timing Secs	成形周期 s Forming Cycle Secs	合模机垫块高度 Press Machine Padding Block Height		是否使用冷却治具 Whether to Use Cooling Fixture		冷却治具时间 Cooling Fixture holding time
NA	800s	NA		NA		NA
注意事项 Matter ToTake Note						
1.每次改变灌注速度时需重新调整高压循环压力125 KG ±50 KG （调整时先关闭枪头）						
1. The high-pressure circulating pressure of 125 KG (+50 KG) must be readjusted whenever the perfusion rate is changed (the Mix Head should be closed before the adjustment)						
2.模具上好后首先调整主缸上行距离再设置主缸下行时间 （下行时间一般设置在模具合到位高压持续三秒左右）						
2. After the mold is ready, first adjust the distance of the upgoing main cylinder then set the down time of the main cylinder (down time is usually set at the high pressure when the mold in closing position for about three seconds).						
3.顶出时间设置时，先手动调整好顶出行程再设置时间 （手动调整时顶到底后顶针板限位块与B板预留5mm间隙）						
3. When setting the ejection time, first adjust the ejection stroke manually then set the time (when adjusting the ejection time manually, reserve 5 mm gap between the ejector plate limit block and the B board)						
脱模剂喷涂方法 Spraying Method for Mold Release						
1.模具加温，前模70℃ 后模70℃ 加热30分钟测实际模温60℃-65℃						
1. The mold is heated, Cavity is 70℃ , Core is 70℃, heat 30 minutes the actual mold temperature is measured at 60 -65 C.						
2.喷脱模剂，第一模总共喷3次，每次喷涂时需确认模具表面完全干透						
2. Spray Mold Release, sprayed 3 times for the first mold. The surface of the mold must be thoroughly dried before spraying						
产品图片 Parts Picture						
						
确认 Confirmed by	史克		日期 Date	2023.08.06		
审核 Verified By	关智勇		日期 Date	2023.08.06		
批准 Approved By	储国春		日期 Date	2023.08.06		