

Test Video: _____

BCBGH MOLD TEST REPORT

104

Date: 09-12-25

Local Temp: 12.7

Machine Size: 168Ton

872 Knob Mold

For: ABC Co.

72

INJECTION				
	Pressure	Speed	Position	Time
Injection 1 (Start)	125	10	75	
Injection 2	110	14	15	
Injection 3	115	10		
Injection 4	88	8		6
Hold	110	6		3
Suck Back	50	15	77	
Charge	120	40	75	

MOLD OPEN & CLOSE			
	Pressure	Speed	Position
High Speed Close (start)	100	45	120
Low Speed Close	15	25	12
High Pressure Close	140	25	
Low Speed Open (Start)	100	30	50
High Speed Open	100	35	219
Low Speed Open	30	10	300

BARREL TEMPERATURE	
Zone 1 (Nozzle)	200
Zone 2	240
Zone 3	238
Zone 4	220
Zone 5	200
Zone 6 (Hydraulic motor side)	

Mold Base	/50
Core/Cavity Sup	NK80/
Standard Parts	
Core/Cavity Hard	35/36

EJECTION & CORE & Air Blast				Ejection Count:
	Pressure	Speed	Position	Time
Ejector Forward	100	18	55	
Ejector Backward	100	99		
Core A In				
Core A Out				
Core B In				
Core B Out				
Air Blast				

Plastic Material	PM Brand	PM Grade
ABS	LGchem	HE173

HOT RUNNER TEMPERATURE																
Nozzle	Manifold 1	Manifold 2	Manifold 3	Manifold 4	Gate 1	Gate 2	Gate 3	Gate 4	Gate 5	Gate 6	Gate 7	Gate 8	Gate 9	Gate 10	Gate 11	Gate 12

Cooling Time: 14 Cycle Time: 32 Mold Temperature: 18 Cooling Water Temp: 14