

MODULE Cod. MO1913.03	TECHNICAL INFORMATION NECESSARY FOR ASSISTANCE
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THERMOPLAY SYSTEM CODE
DELIVERY NOTE No. DELIVERY of the

Injection type: direct (injection directly of the stamped piece)
 indirect (injection on the sprue)

- injection press: model and tonnes
- screw diameter press mm
- nozzle press injection diameter mm
- press nozzle radius mm

press cylinder temperature:

zone 1 °C	zone 2 °C	Zone 3 °C	Zone 4 °C	zone 5 °C
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Mould plate temperature °C
Manifold temperature °C

Nozzle temperature:

1 °C	2 °C	3 °C	4 °C	5 °C	6 °C	7 °C	8 °C
9 °C	10 °C	11 °C	12 °C	13 °C	14 °C	15 °C	16 °C
17 °C	18 °C	19 °C	20 °C	21 °C	22 °C	23 °C	24 °C
25 °C	26 °C	27 °C	28 °C	29 °C	30 °C	31 °C	32 °C
33 °C	34 °C	35 °C	36 °C	37 °C	38 °C	39 °C	40 °C
41 °C	42 °C	43 °C	44 °C	45 °C	46 °C	47 °C	48 °C

- cooling temperature of the shaping fixed side °C
- cooling temperature of the shaping mobile side °C
- injection pressure Bar
- injection time sec
- injection speed cm3/s
- post – pressure Bar
- time post-pressure sec
- total cycle time sec
- weight of the injected piece g
- diameter injection hole mm
- Controller (producer and zones)
- Producer and abbreviation of the thermoplastic material moulded

Description of the defect found:

Documents to attach to the e mail:

- **technical sheet of the plastic material used**
- **drawing of the mould in .dxf / .stp / .igs format**

(Thermoplay will use the drawings only for wiewing and not will ship the drawings to other competitors)