



MODULE Cod. MO1913.04	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)

- IMM model and tonnes
- IMM screw diameter mm
- IMM nozzle injection diameter mm
- IMM nozzle radius mm

IMM 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
- post-pressure time sec
- total cycle time sec
- weight of the injected piece g
- injection hole diameter mm
- Thermal 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 data sheet of the thermoplastic material moulded**
- **drawing of the mould in .stp format**

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