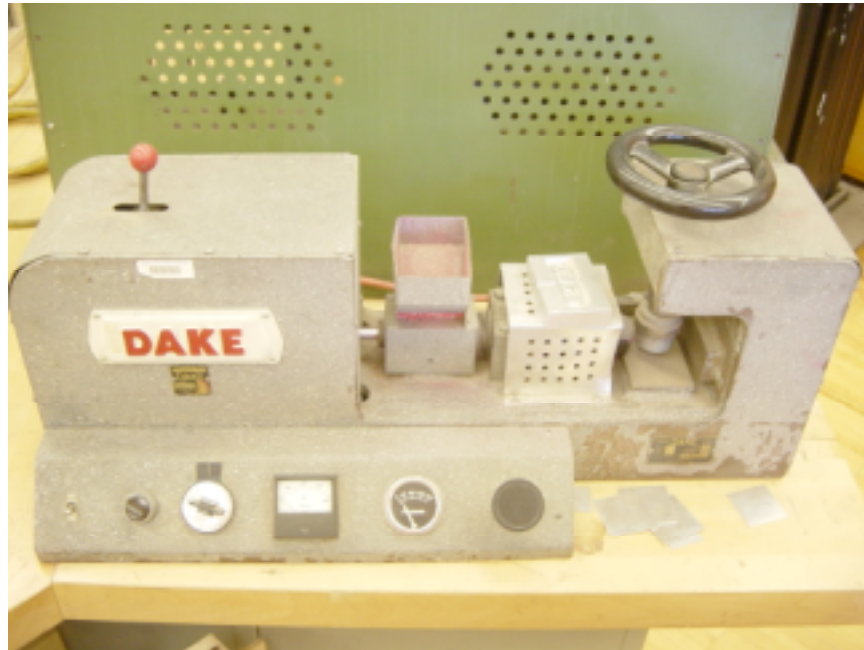


<p align="center">Injection Molding Group Module: 11</p>	<p>TEL 204: Polymer Molding & Forming Department of Technology</p>	<p>Student Names: (PRINT)</p>
---	--	-------------------------------

Overview:

We have several injection molding machines in the Polymer Laboratory. You are to mold a part using three different machines. For each, you will select and prepare a mold. Select and prepare plastic, and then prepare, operate, and finally clean the molding machine.



Module Grade:

	Products (55)	Fit & Finish (15)	Lessons Learned (30)	Total
Instructor Signature:			Date:	Grade:

Molding Procedures:

1. Wear safety glasses.
2. Wear gloves and/or do not touch melted plastic.
3. Preheat the molder. DO NOT ACTIVATE PLUNGER UNTIL OPERATING TEMPERATURE IS REACHED.
4. Select a mold and apply silicone spray mold release. NEVER SCRATCH MOLDS BY CARELESS HANDLING OR IMPROPER STACKING OR CLEANING!
5. Purge old plastic and clean hopper of old plastic.
6. Prepare new plastic with appropriate colorant. Only 1% ! Too much colorant will cause defects and problems with molded parts!
7. Fill barrel and hopper with new plastic.
8. Align mold with nozzle. Use adjustable stops and/or shims as necessary.
9. Clamp mold into molder using minimal pressure. Clamp will be harder to remove once plastic is injected.
10. Set air pressure regulators to 50 psi.
11. Inject plastic by activating plunger.
12. Refill the hopper and barrel with an appropriate shot size while part is cooling in mold. Activate plunger slightly if necessary to fill barrel.
13. Release clamp and de-mold part. NEVER USE SHARP, METAL TOOLS TO REMOVE PART!!!! Use sharpened wood or acrylic de-molding tools.
14. Trim flash and gate/runner/sprue off of part.

Lessons Learned:

List the most important lessons learned from this polymer module.

1. _____

2. _____

3. _____

Notes: