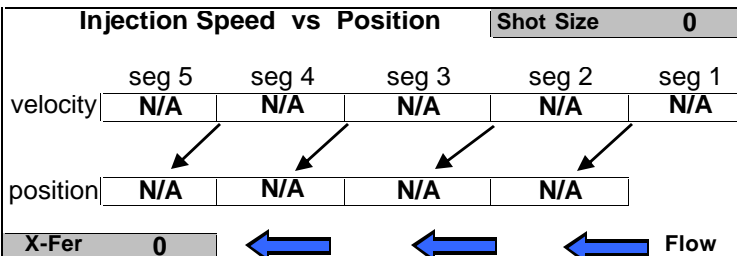


Press # **15** Part # **QL-150** Die # **122** Date

Clamp Setup	MIN	MAX
Clamp Open Stop	-3	+3
Close Slow	-3	+3
Open Slow	-3	+3
Open Fast	-3	+3
Mold Touch	-0.5	+0.5
Open Velocity	N/A	+5
Slow Open Vel.	N/A	+5
Close Velocity	N/A	+5
Slow Close Vel	N/A	+5
Close Slow Press	N/A	+100
Breakaway Vel.	N/A	+5
High Tonnage	250	+100
Low Tonnage	200	+100
Mold Protect PSI	700	+100

Injection	MIN	MAX
Shot Size	-1	+1
Transfer	-1	+1
Available Press.	-150	+100
Decompression	-100	+100
Inj. Pack Press1	-100	+100
Inj. Pack Press2	N/A	+100
Inj. Hold Press 1	N/A	+100
Inj. Hold Press.2	N/A	+100
Extruder Speed	N/A	+100
Back Press.	-100	+100
Final Back.Press.	N/A	+100

Ejector Setup	MIN	MAX
Ejector Start Pos.	-3	+3
Ejector Ret. Pos.	-0.25	+0.15
Ejector Fwd. Pos.	N/A	+0.5
Retract Override Pulses	N/A	+1
	0	5



Cores Setup	MIN	MAX
Set Sequence		
Pull Sequence		
Set Position	-3	+3
Pull Position	-3	+3

Mold Sprayer Control	MIN	MAX	
Down Delay	N/A	-1	+1
Down Time	N/A	-1	+1
Spray 1 Delay	N/A	-1	+1
Spray 1 Time	N/A	-1	+1
Spray 2 Delay	N/A	-1	+1
Spray 2 Time	N/A	-1	+1
Cycles Per Spray	N/A	0	8

Timers	MIN	MAX	
Open Dwell	0	0.5	
Avail. High Time	-3	+3	
Inj.Low	-3	+5	
Inj. Pack	N/A	-3	+5
Cooling	-5	+5	
Extruder Delay	N/A	-0.25	+0.5
Inj. Fwd. Delay	N/A	-0.25	+0.5
Mold Protect	N/A	-3	+3
Eject. Fwd Dwell	N/A	-0.5	+0.5
Flow Mold	N/A	-2	+2

Proc. Monitor	MIN	MAX
Cycle Time		
Fill Time		
Recovery Time		
Transfer		
Cushion		

Features	ON	OFF
Heat	X	
Cores	X	
Ejectors	X	
Inject. Unit	X	
Mold Sprayer	N/A	N/A
Flow Molding	N/A	N/A
Adapt. Shot Con.	N/A	N/A
Position X-Fer	N/A	N/A
Hydraulic X-Fer	N/A	N/A
% Correction	N/A	
Cushion Setpoint	N/A	
Extruder Speed	N/A	
Inject.Speed	N/A	

Mold Storage	Test Run
Mold#	N/A
Slot#	N/A
	YES
	NO
	X

Temperatures	MIN	MAX	
Nozzle	-25	+25	
Front	-25	+25	
Middle	-25	+25	
Mid Rear	N/A	-25	+25
Rear	-25	+25	
ALARM	40		

Cycle Time	STD	MIN	MAX
		-10	+5

Molding Information	
Nozzle Required	
Thermolater	
Temperature	
Location	
NOTES:	

N/A = Does Not Apply On This Machine

Molder Initials