CONSTANT LOW PRESSURE PROCESS SUMMARY

Low Constant Pressure

+ Lower clamp tonnage
+ Less retained stress
+ Uniform stress (less warp)
+ Lower melt temps
+ Less gate blush
+ Less flash
+ Less core shift
+ Improved multi-cavity molds
+ Enable family molds
+ Less material degradation
+ Less mold wear
+ Less press wear

No Hesitation

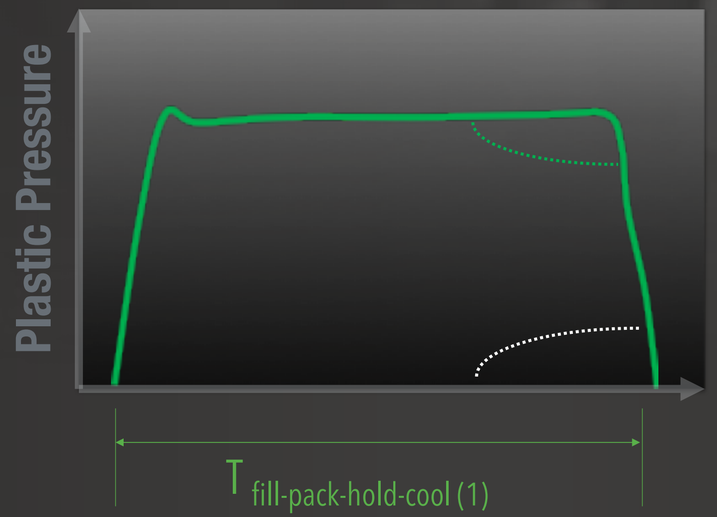
+ Reduced flow lines
+ Reduced tiger striping
+ Improved thin walling
+ Higher L/T
+ Improved optical clarity
+ Smaller cold runners

Pack-as-it-Fills

+ Less sink marks
+ Stronger weld lines
+ Faster cycle times
+ Improved surface finish

Cavity Pressure Response

+ Reduced flash
+ Automatic adjust for viscosity
+ Real time adjust for down cavities
+ Actuate sequential gates
+ Lighter parts (1-3%)
+ Not effected by leaky check ring
+ Not effected by worn barrel



Considerations / Limits

- Recovery Limited Press/Mold Combination
- Velocity Limited Press/Mold Combination
- Poor Mold Design / Condition
- Molds “Tuned” to Poor Process Conditions