

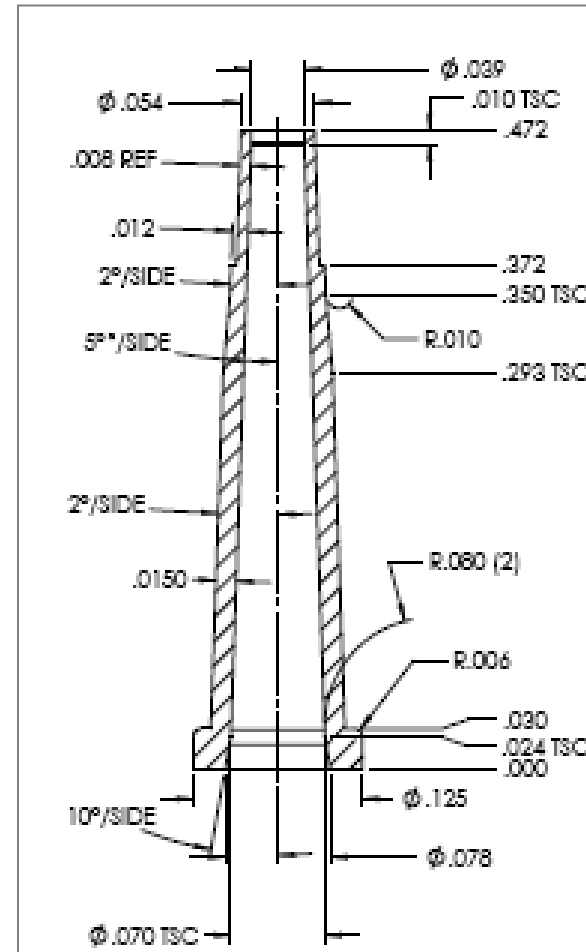
# Micro PEEK

## Using Beaumont's "Melt Flipper" (1/2)

Material	Victrex PEEK 90G
Cavity	4
Part	0.008" Wall Funnel Tip
Machine	LP20EH2(P12S14)
Note	Melt Flipper

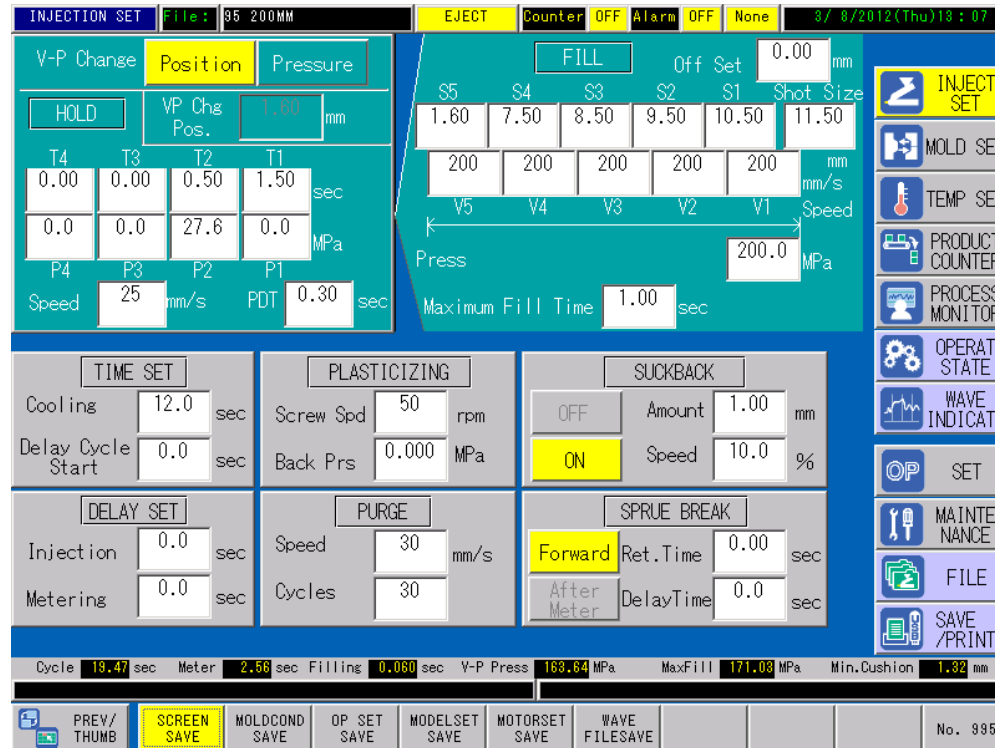
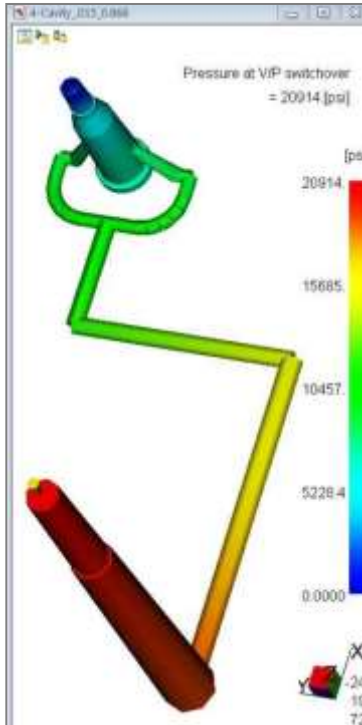


Part Weight: 0.03 g  
Runner Weight: 0.67 g  
Thin Wall: 0.008"



# Micro PEEK

## Using Beaumont's "Melt Flipper" (2/2)



**INJECTION SET** File: 95 200MM EJECT Counter OFF Alarm OFF None 3/ 8/2012(Thu)13:07

V-P Change Position Pressure

HOLD VP Chg Pos. 1.60 mm

T4	T3	T2	T1	Shot Size
0.00	0.00	0.50	1.50	11.50
sec	sec	sec	sec	mm

P4	P3	P2	P1	Speed
0.0	0.0	27.6	0.0	200
MPa	MPa	MPa	MPa	mm/s

Speed 25 mm/s PDT 0.30 sec

FILL Off Set 0.00 mm

S5	S4	S3	S2	S1	Shot Size
1.60	7.50	8.50	9.50	10.50	11.50
mm	mm	mm	mm	mm	mm

V5 V4 V3 V2 V1 Speed

Press 200.0 MPa

Maximum Fill Time 1.00 sec

TIME SET Cooling 12.0 sec Delay Cycle Start 0.0 sec

PLASTICIZING Screw Spd 50 rpm Back Prs 0.000 MPa

SUCKBACK OFF Amount 1.00 mm ON Speed 10.0 %

DELAY SET Injection 0.0 sec Metering 0.0 sec

PURGE Speed 30 mm/s Cycles 30

SPRUE BREAK Forward Ret.Time 0.00 sec After Meter DelayTime 0.0 sec

Cycle 19.47 sec Meter 2.58 sec Filling 0.060 sec Y-P Press 163.64 MPa MaxFill 171.03 MPa Min.Cushion 1.32 mm

PREV/THUMB SCREEN SAVE MOLDCOND SAVE OP SET SAVE MODELSET SAVE MOTORSET SAVE WAVE FILESAVE No. 895

Fill Time: 0.061 sec

Max Injection Pressure: 171 MPa (24,875 psi)

Balanced Runner System by Melt Flipper