

## **Molding Cycle with Ramp:**

The following graph shows the impact of using a heating and cooling ramp on the temperature and force of an ideal molding cycle. Note that the data was created for the purpose of explaining how the heating and cooling ramp works and does not reflect the actual heating, cooling, and force capability of the press.

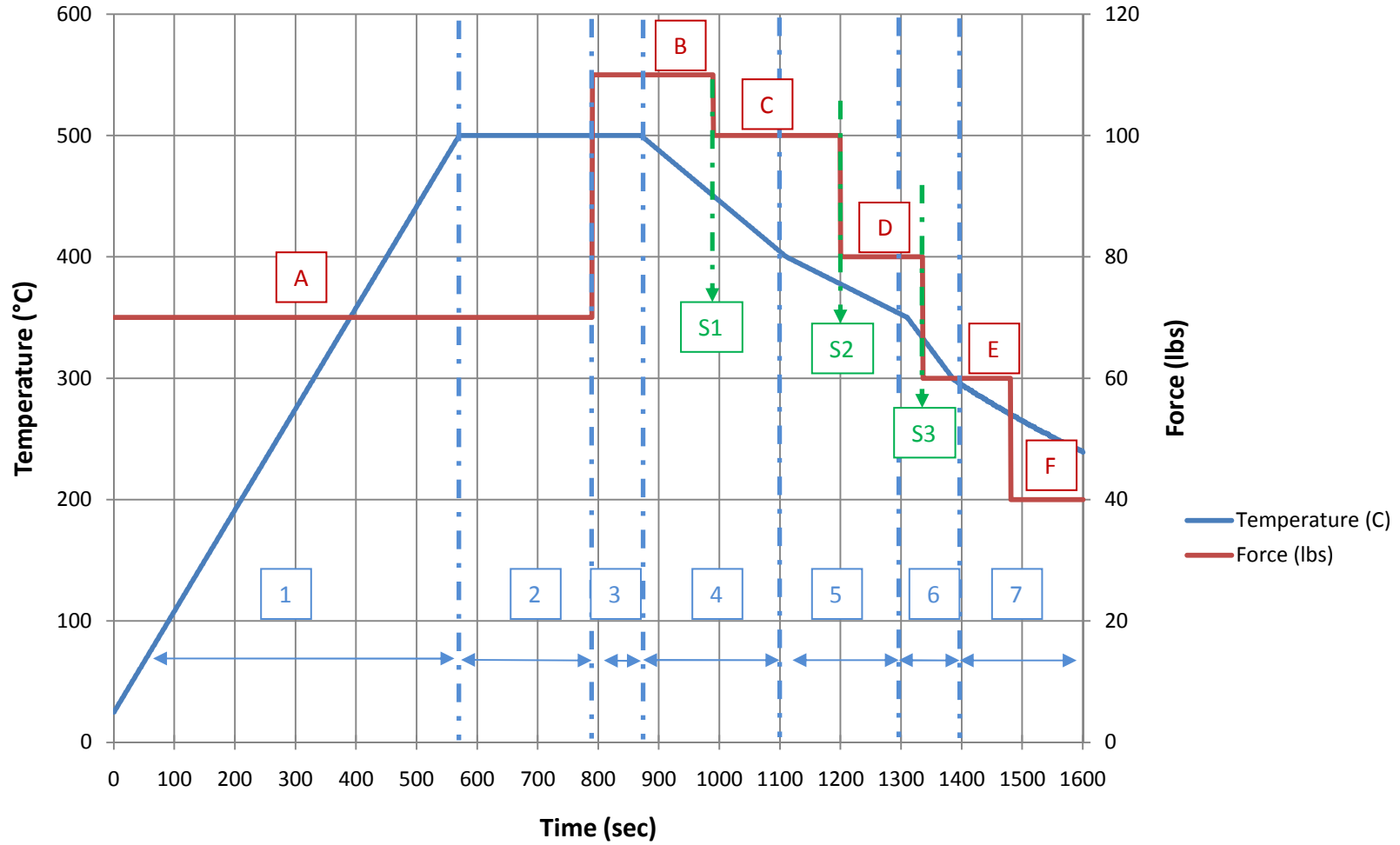
### Graph Key:

1. Heating Ramp
2. Soak
3. Molding
4. Stage 1 Cooling Ramp
5. Stage 2 Cooling Ramp
6. Stage 3 Cooling Ramp
7. Cooling Mode

- A. Soak Force
- B. Molding Force
- C. Stage 1 Force
- D. Stage 2 Force
- E. Stage 3 Force
- F. Cooling Load Force

- S1. Soak Temperature 1
- S2. Soak Temperature 2
- S3. Soak Temperature 3

# Ideal Ramp Data



## 4.6 Cooling Ramp Setup

### Cooling Setup

Cooling Ramp: OFF

OFF

# of Stages: 9

9

Stage #	Temp	@ Time	Force	@ Temp
1	999	99	999.9	999
2	999	99	999.9	999
3	999	99	999.9	999

Save

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