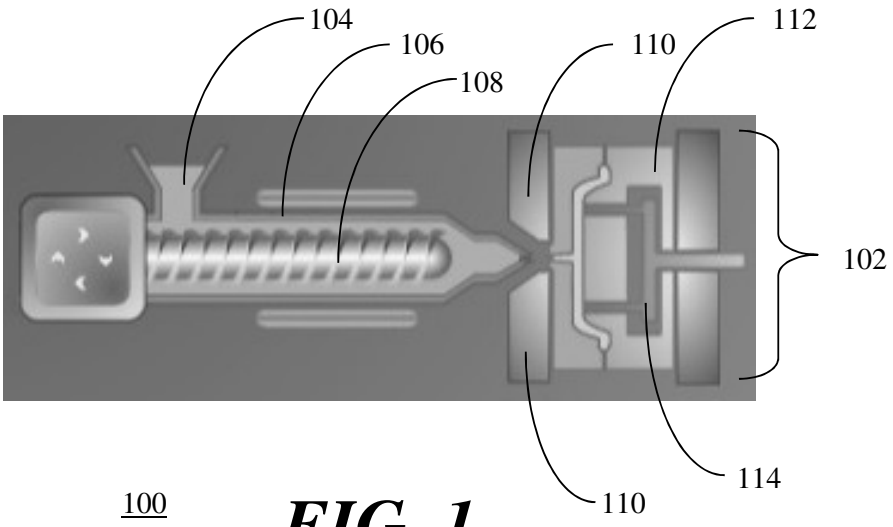
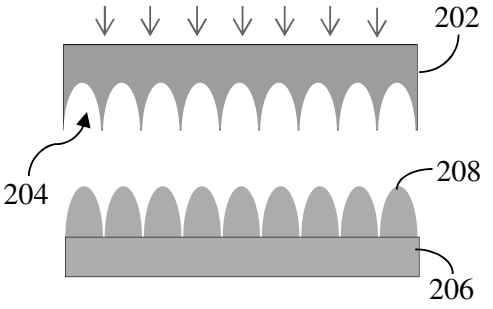


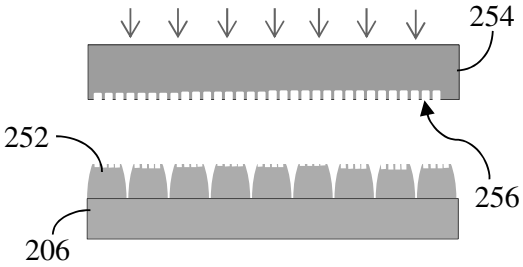
100

FIG. 1
PRIOR ART



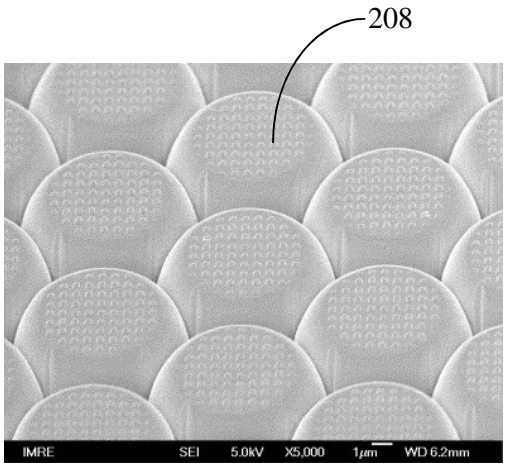
200

FIG. 2A



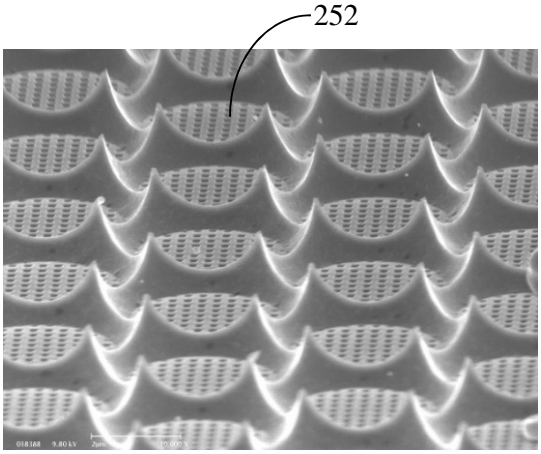
250

FIG. 2B



300

FIG. 3A



350

FIG. 3B



400

FIG. 4A

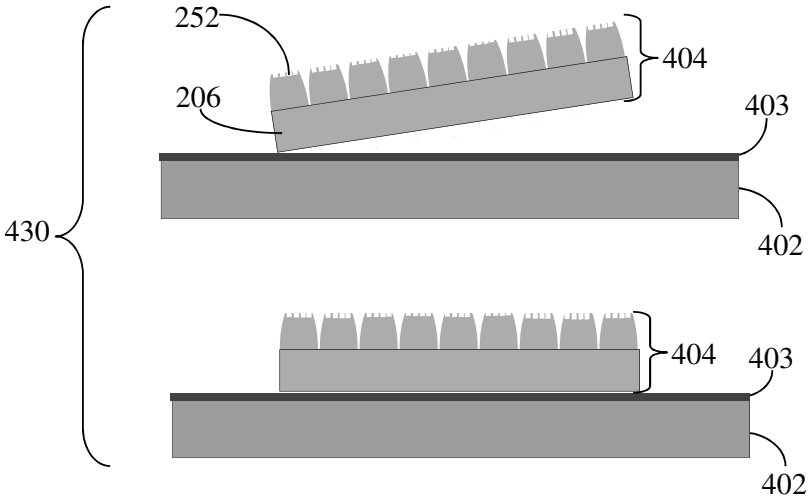


FIG. 4B

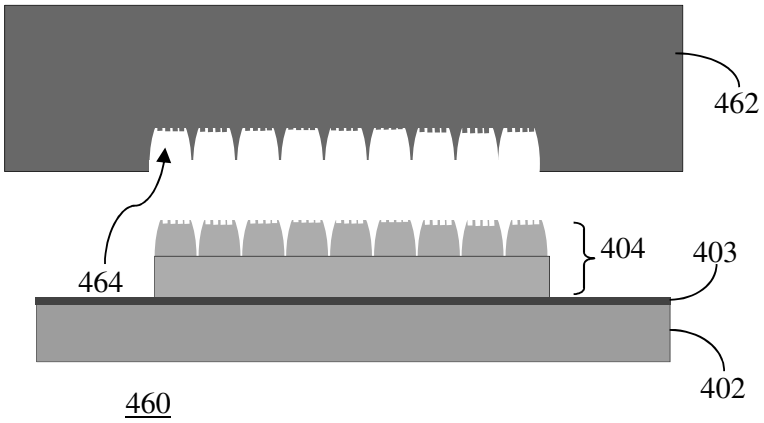


FIG. 4C

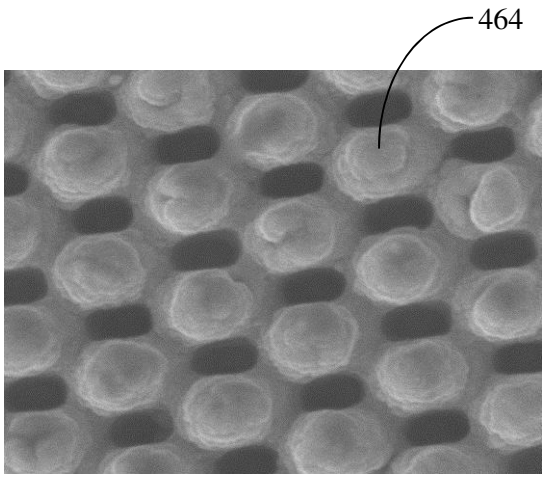


FIG. 5A

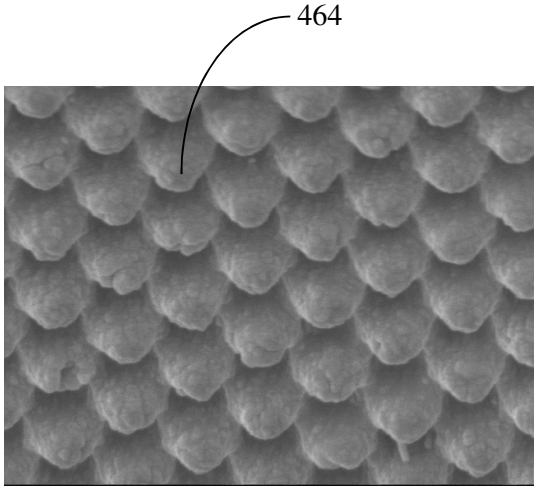


FIG. 5B

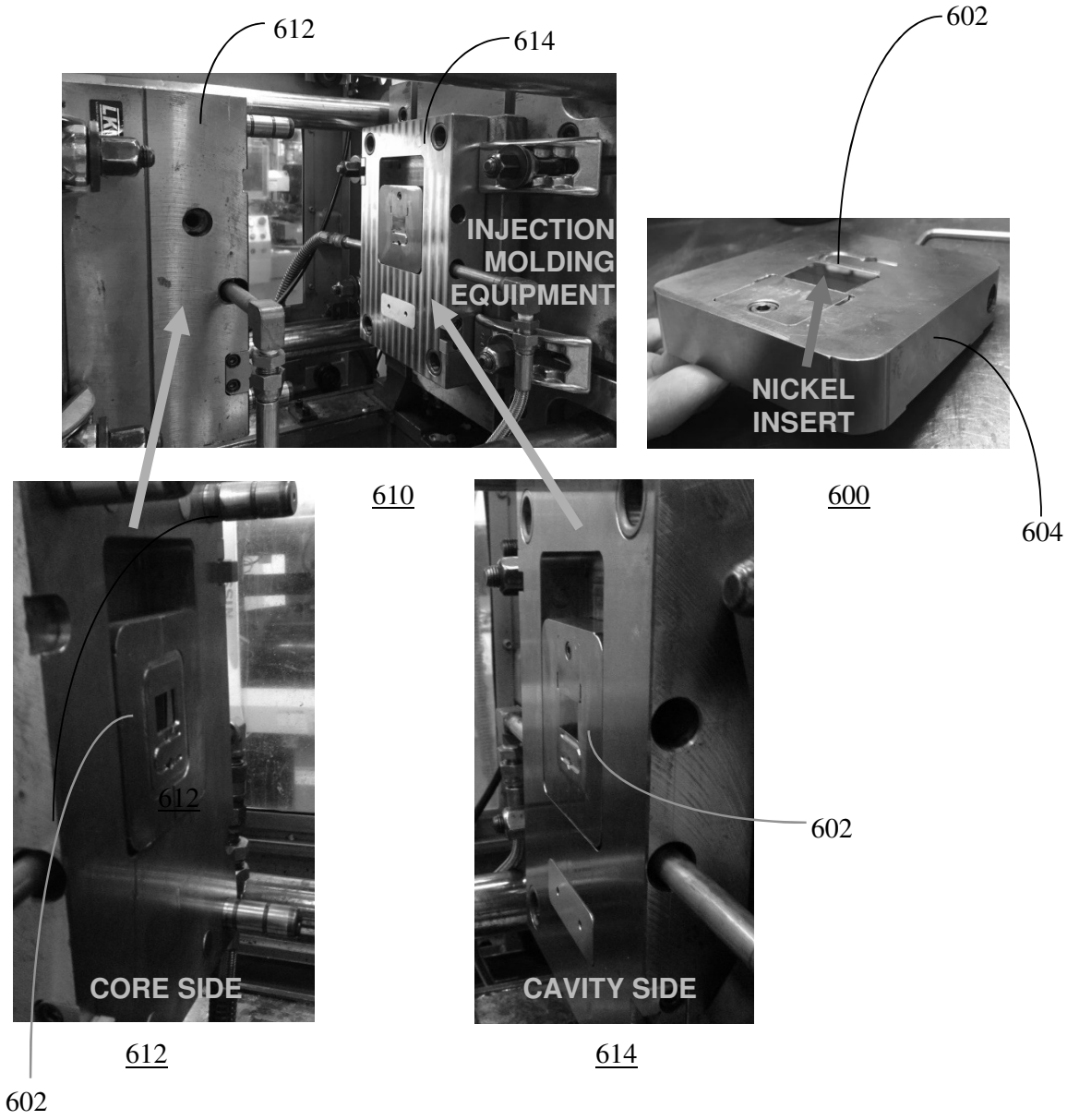
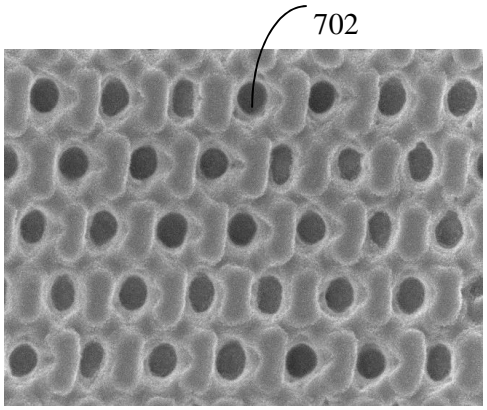
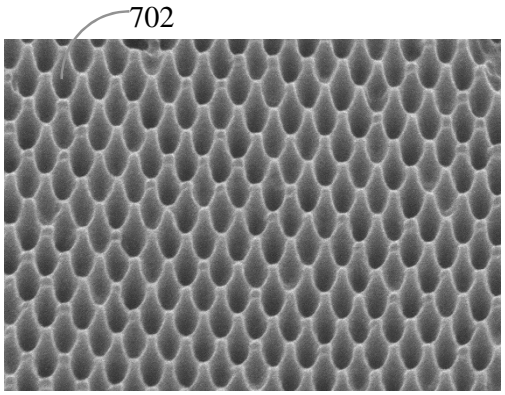

612
614
602
INJECTION MOLDING EQUIPMENT
NICKEL INSERT
610
600
604
612
602
CORE SIDE
CAVITY SIDE
612
614
602

FIG. 6



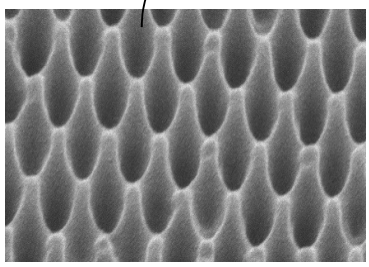
700

FIG. 7A



750

FIG. 7B



770

FIG. 7C

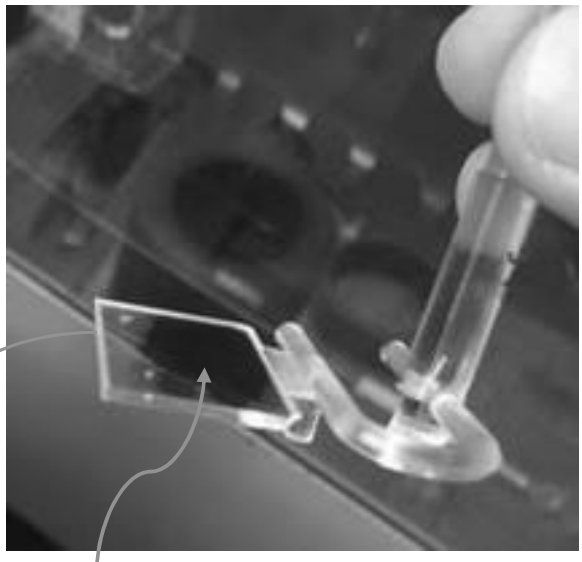


FIG. 8

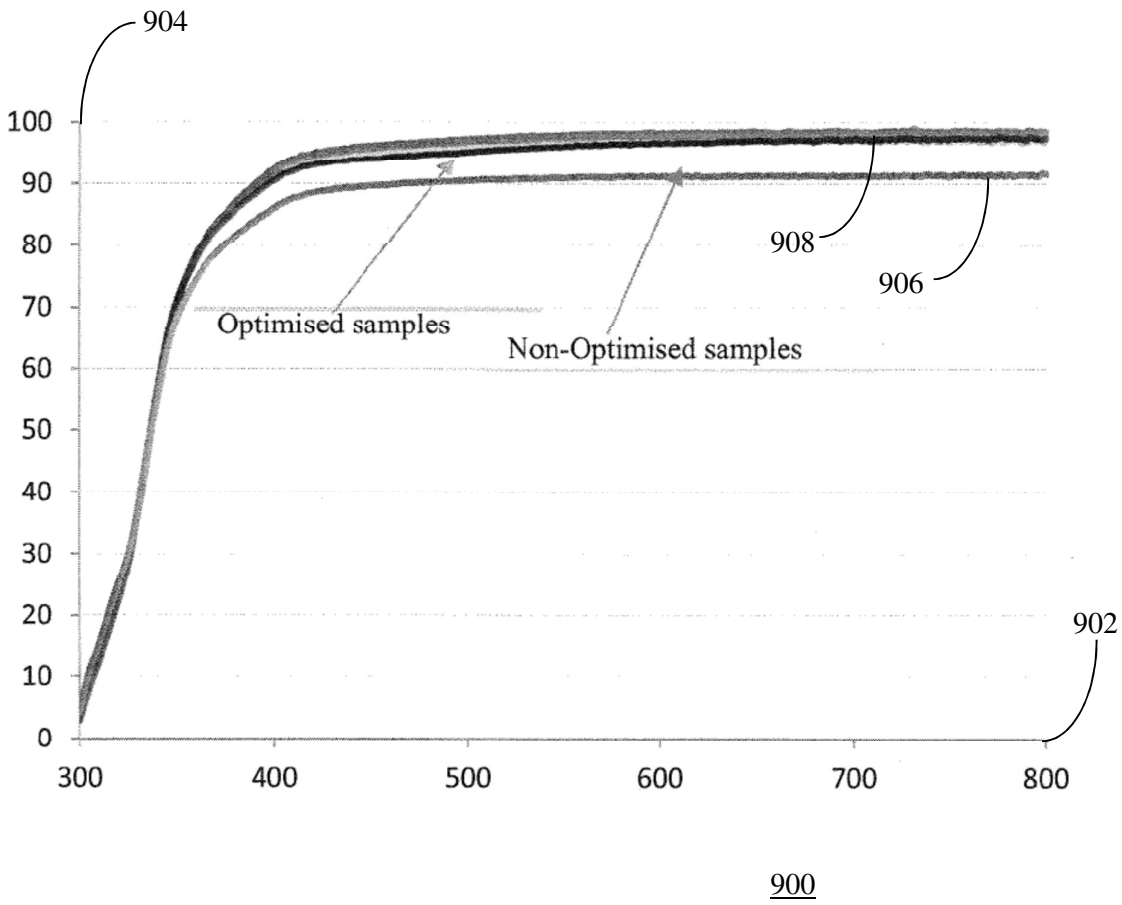

904
100
90
80
70
60
50
40
30
20
10
0
300
400
500
600
700
800
908
906
902
Optimised samples
Non-Optimised samples
900

FIG. 9