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(21) International Application Number: PCT/IB97/01214 (22) International Filing Date: 5 September 1997 (05.09.97) (30) Priority Data: 08/707,618 5 September 1996 (05.09.96) US (71) Applicant: WEA MANUFACTURING, INC. [US/US]; 1444 East Lackawanna Avenue, P.O. Box 321, Olyphant, PA 18447 (US). (72) Inventors: MUELLER, William; 2007 Terra Drive, Clarks Summit, PA 18411 (US). PICKUTOSKI, Edward; 606 Sanderson Avenue, Olyphant, PA 18447 (US). (74) Agent: RUBENSTEIN, Allen, I.; Gottlieb, Rackman & Reisman, P.C., 270 Madison Avenue, New York, NY 10016-0601 (US).		(81) Designated States: AU, JP, SG, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>
(54) Title: INJECTION MOLDING OF COMPACT DISCS (57) Abstract A method for the injection of molding of compact discs at the very small thickness of 0.6 mm employing a critical sequence of steps during and after the injection of molten plastic into the mold cavity, including allowing the injected plastic to force the mold cavity to partly reopen for a predetermined time (or distance) before closing the mold to its final dimensions.		