1

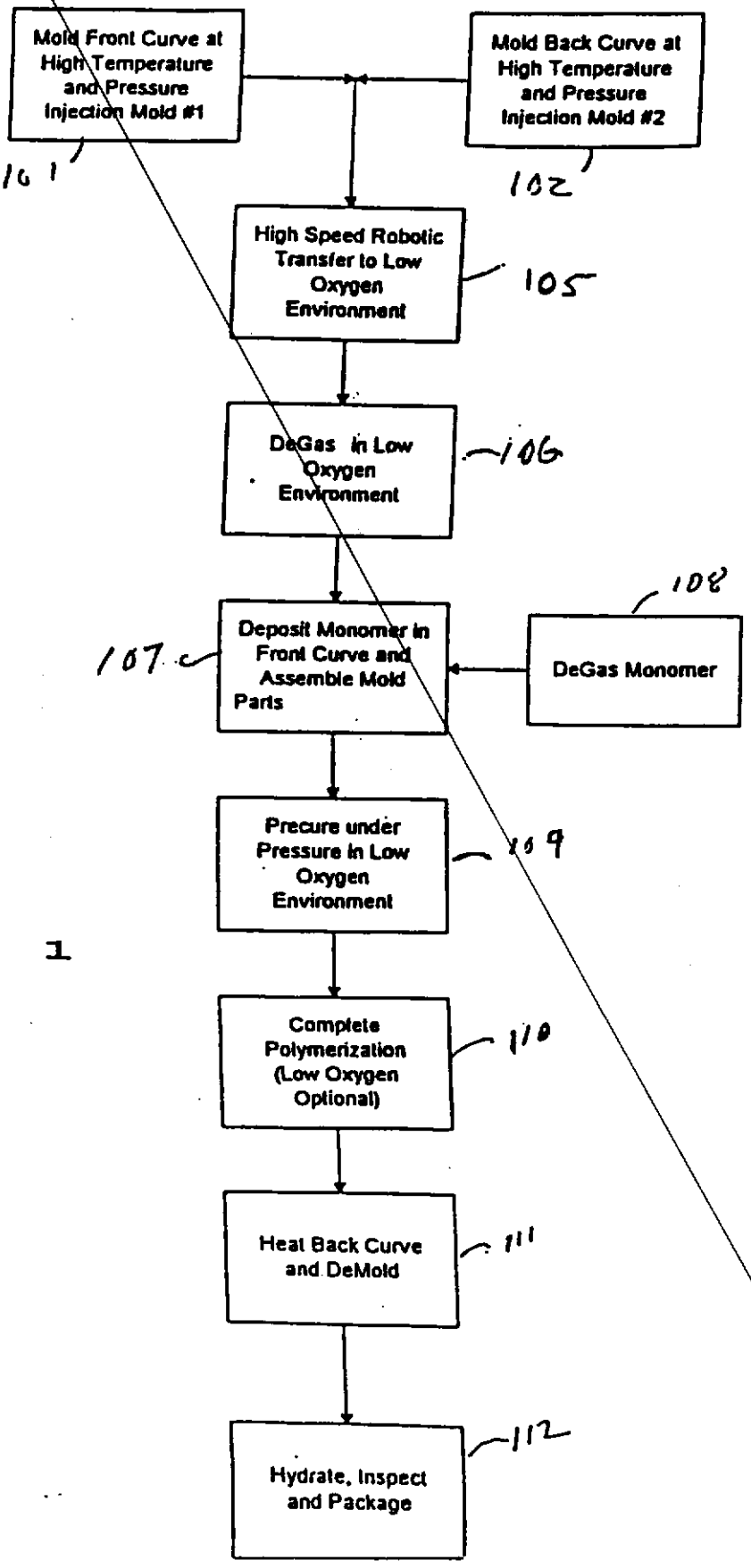

Mold Front Curve at High Temperature and Pressure Injection Mold #1
101
Mold Back Curve at High Temperature and Pressure Injection Mold #2
102
High Speed Robotic Transfer to Low Oxygen Environment
105
DeGas in Low Oxygen Environment
106
Deposit Monomer in Front Curve and Assemble Mold Parts
107
DeGas Monomer
108
Precure under Pressure in Low Oxygen Environment
109
Complete Polymerization (Low Oxygen Optional)
110
Heat Back Curve and DeMold
111
Hydrate, Inspect and Package
112

FIG. 1

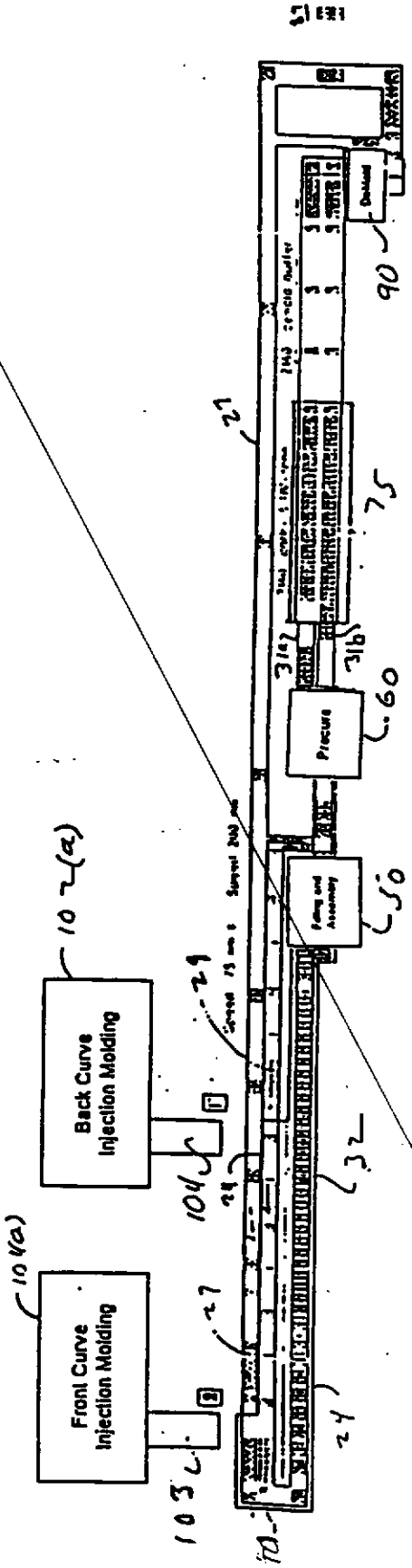
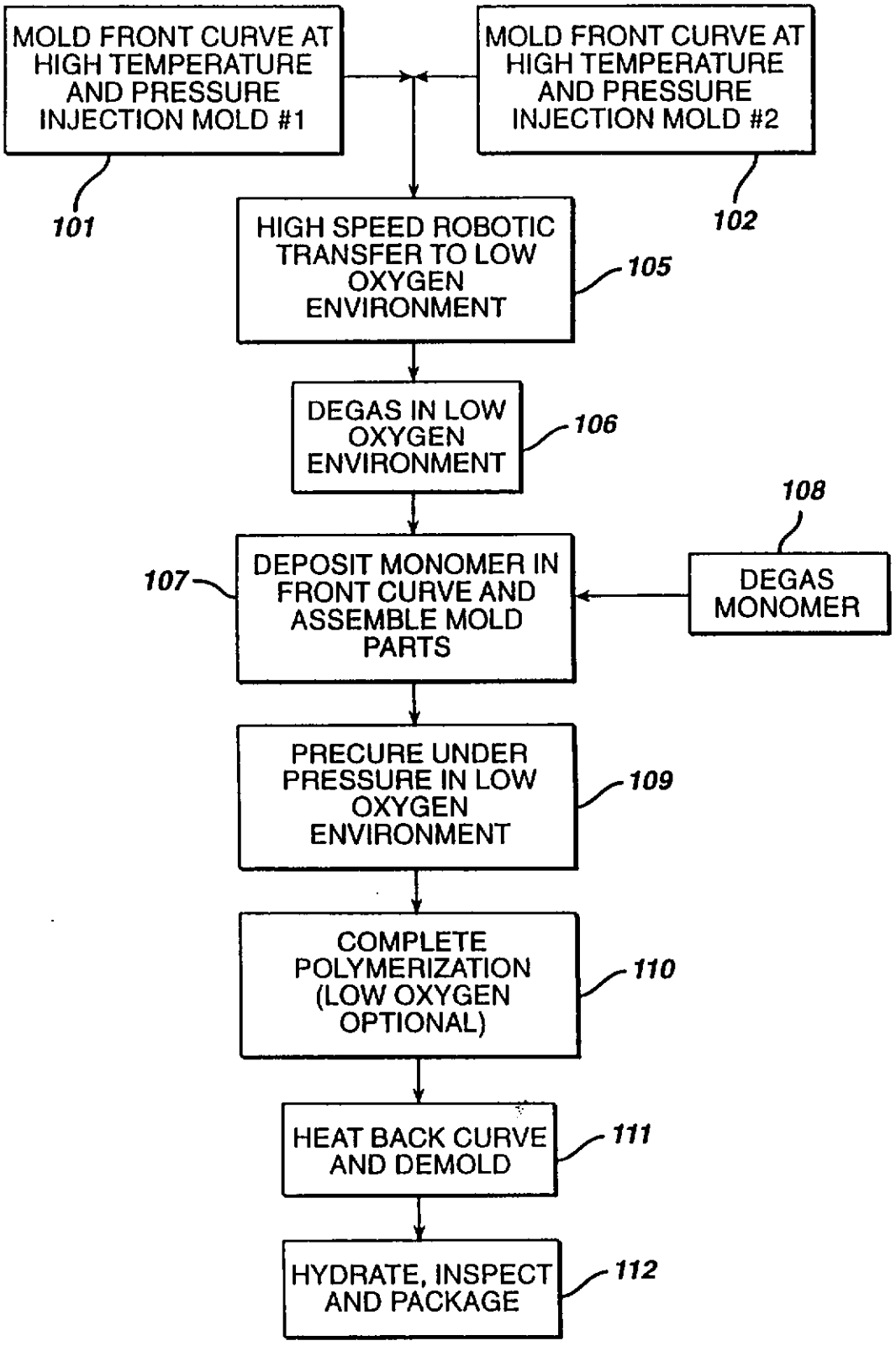

Back Curve Injection Molding
Front Curve Injection Molding
Packout
Assy and Assembly
90
75
60
50
32
24
27
29
104
103
10(a)
10(a)
31a
31b

FIG. 2

FIG. 1


MOLD FRONT CURVE AT HIGH TEMPERATURE AND PRESSURE INJECTION MOLD #1
101
MOLD FRONT CURVE AT HIGH TEMPERATURE AND PRESSURE INJECTION MOLD #2
102
HIGH SPEED ROBOTIC TRANSFER TO LOW OXYGEN ENVIRONMENT
105
DEGAS IN LOW OXYGEN ENVIRONMENT
106
108
DEPOSIT MONOMER IN FRONT CURVE AND ASSEMBLE MOLD PARTS
107
DEGAS MONOMER
PRECURE UNDER PRESSURE IN LOW OXYGEN ENVIRONMENT
109
COMPLETE POLYMERIZATION (LOW OXYGEN OPTIONAL)
110
HEAT BACK CURVE AND DEMOLD
111
HYDRATE, INSPECT AND PACKAGE
112

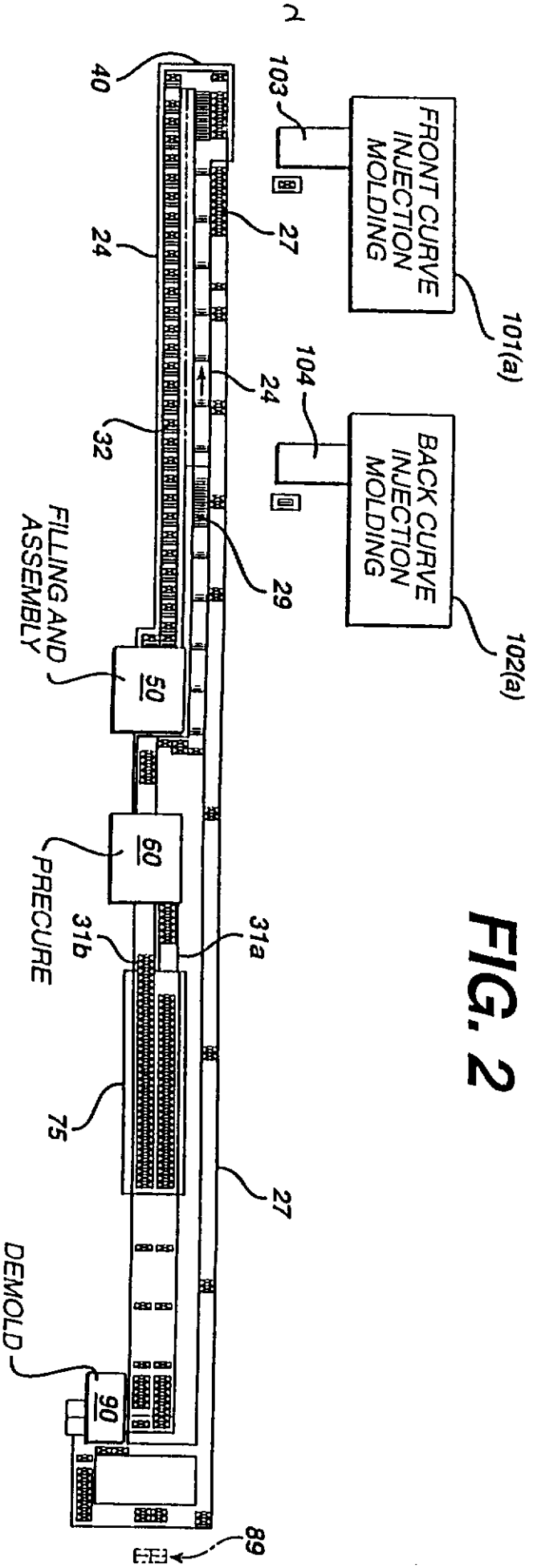

FRONT CURVE INJECTION MOLDING
BACK CURVE INJECTION MOLDING
FILLING AND ASSEMBLY
PRECURE
DEMOLD
40
103
27
24
101(a)
104
24
32
29
102(a)
50
60
31b
31a
75
27
90
89

FIG. 2