

ABSTRACT**INJECTION CONTROLLING METHOD FOR AN INJECTION MOLDING MACHINE**

A method and apparatus for controlling injection in an injection molding machine meters and controls injection shot. Injection shot is metered into a heating cylinder of the injection molding machine, and the injection shot is  
5 then injected into a mold by advancing an injection screw in an injection direction within the heating cylinder. The injection screw is then retracted within the heating cylinder.

(Fig 3A)