



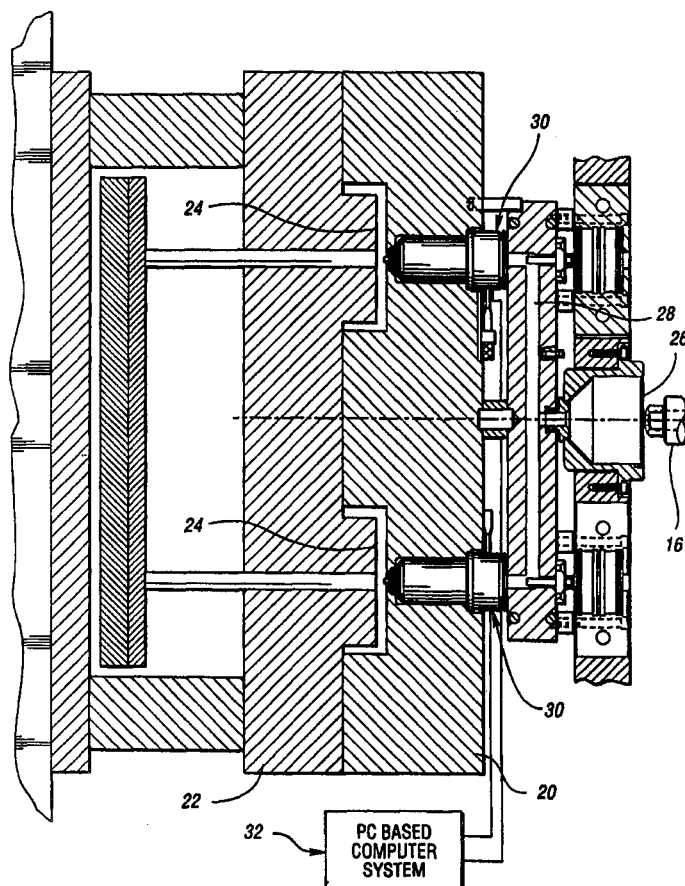
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(54) Title: INJECTION MOLDING SYSTEM WITH SEQUENTIAL GATE CONTROL

(57) Abstract

An injection molding machine (10) for molding plastic parts by injecting a molten plastic through a plurality of valve gates (31) into a mold cavity by reciprocation of a helical screw (16). A linear position sensor (34) positioned on the machine to detect the position of the helical screw (16) and control the opening and closing of the gates (31) based on the detected position of the screw (16). A computer is in communication with the valve gates and the position sensor to monitor the position and activate the opening and closing of the valve gates (31). A pressure transducer is associated with the mold cavity and in communication with the computer (32) as an alternate or additional method for controlling the opening and closing of the valve gates (31).



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