

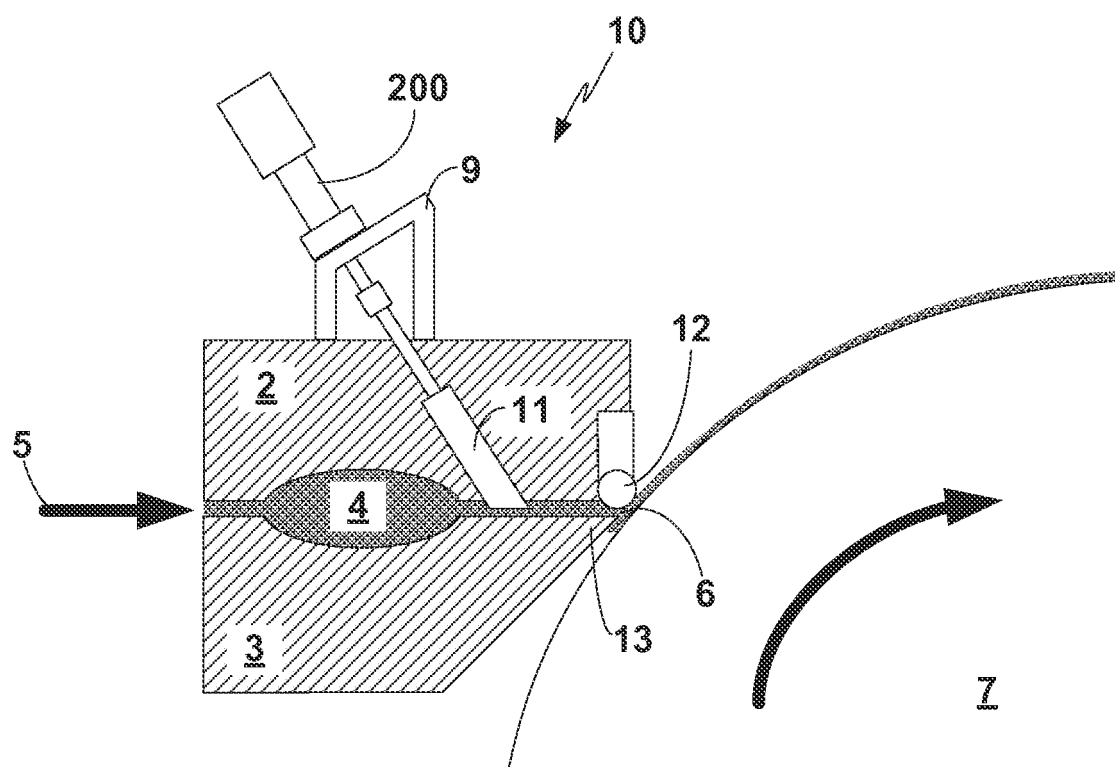


FIG. 1A

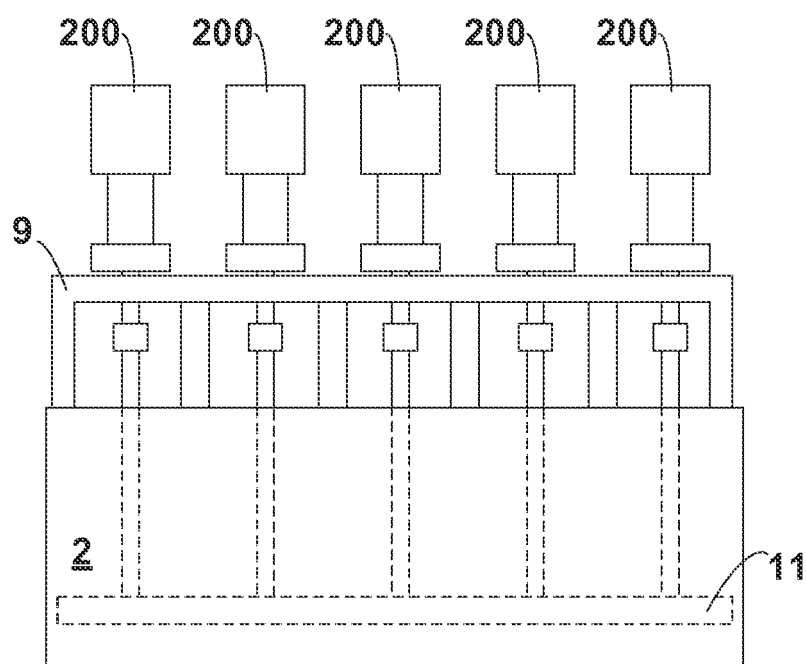


FIG. 1B

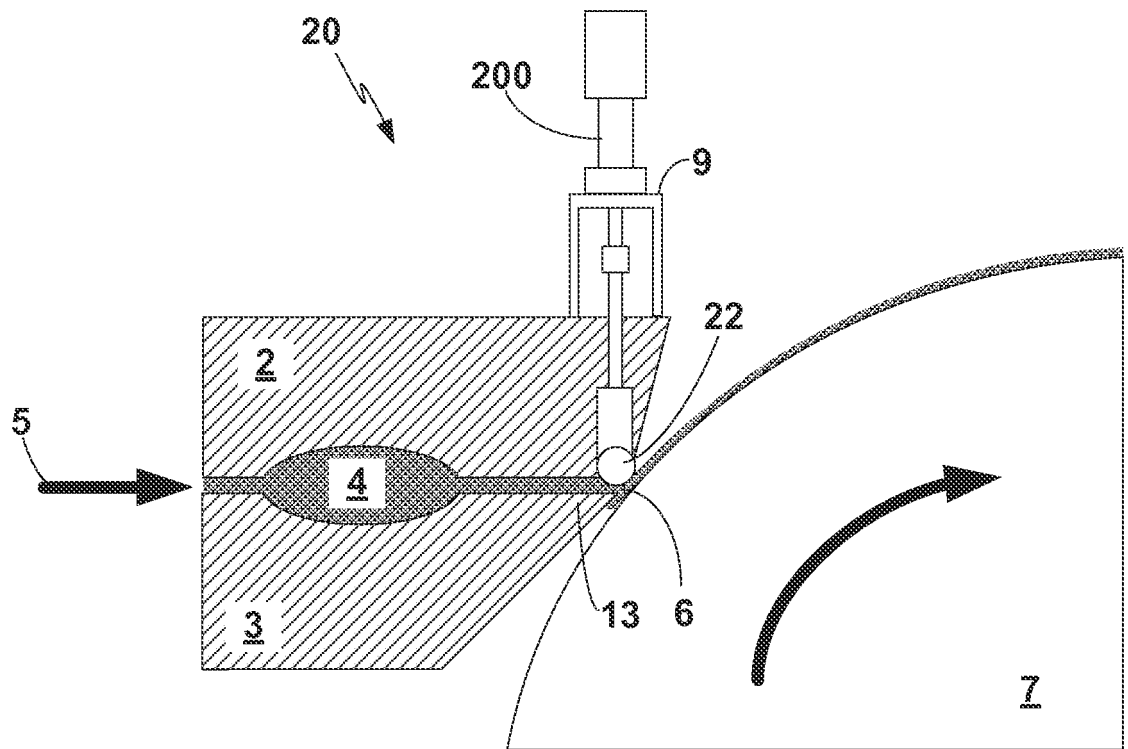


FIG. 2

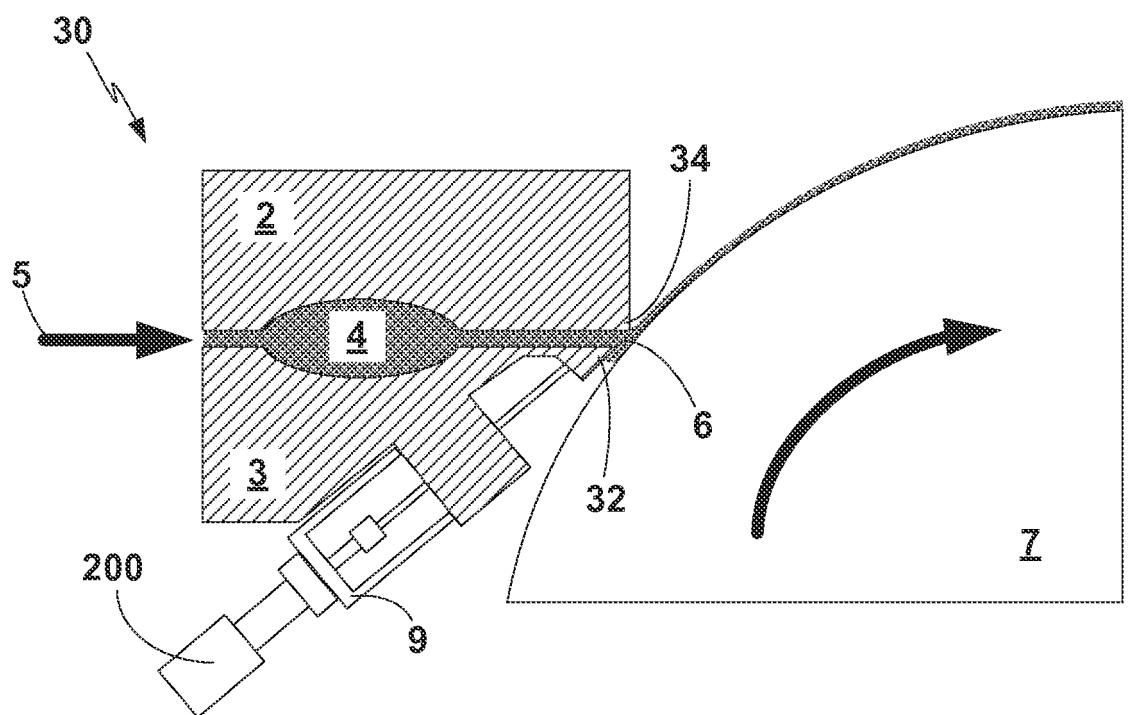
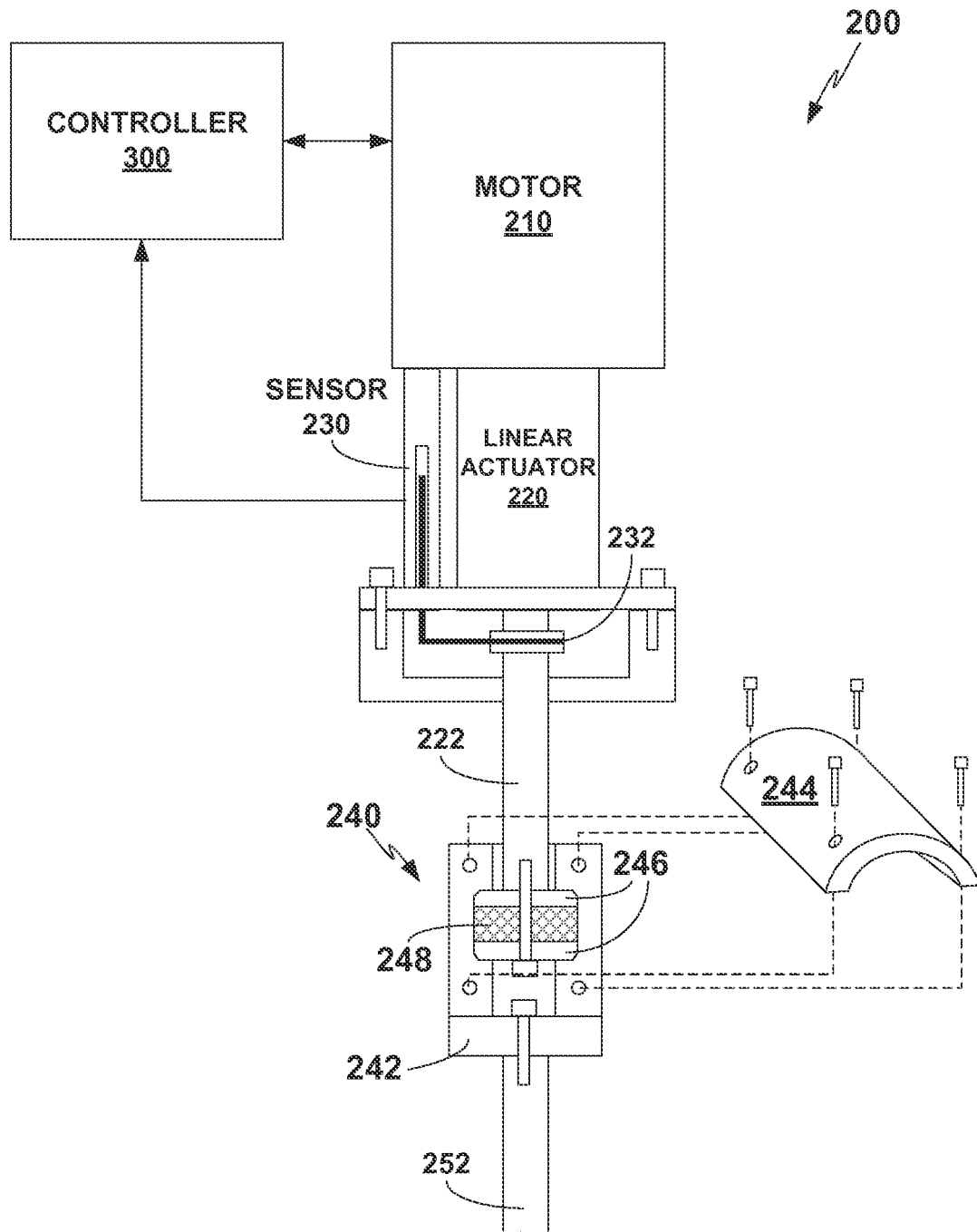


FIG. 3

**FIG. 4**

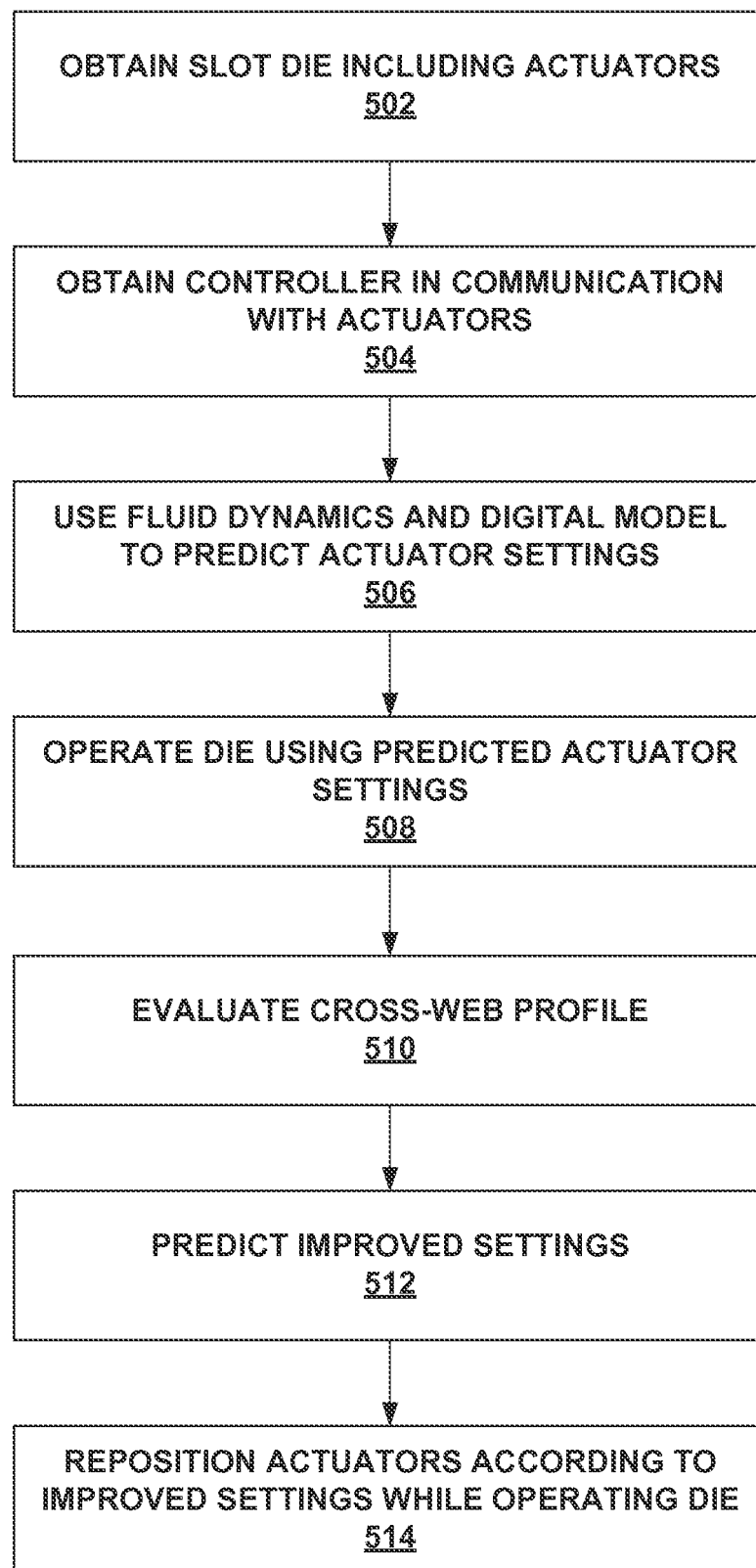


FIG. 5

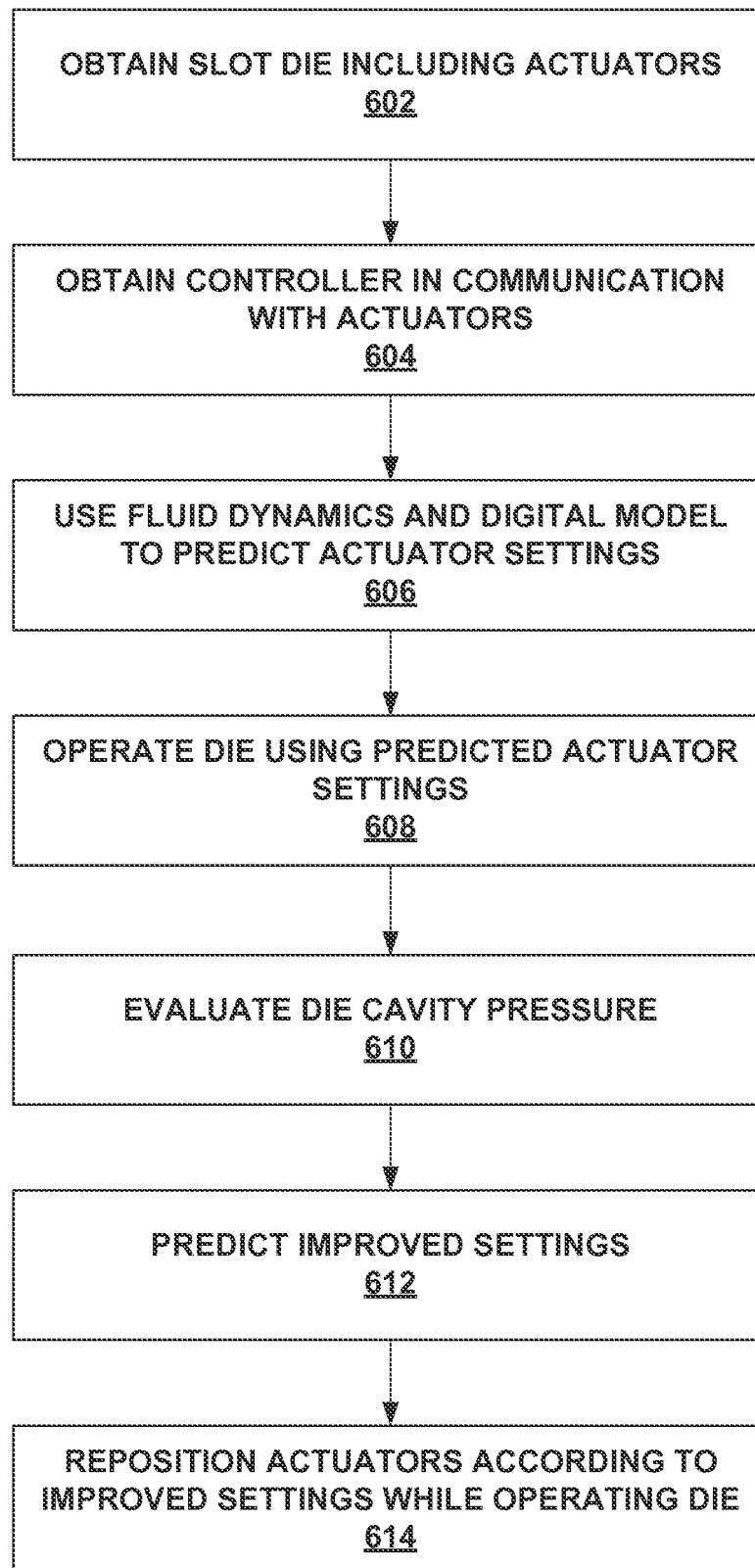


FIG. 6

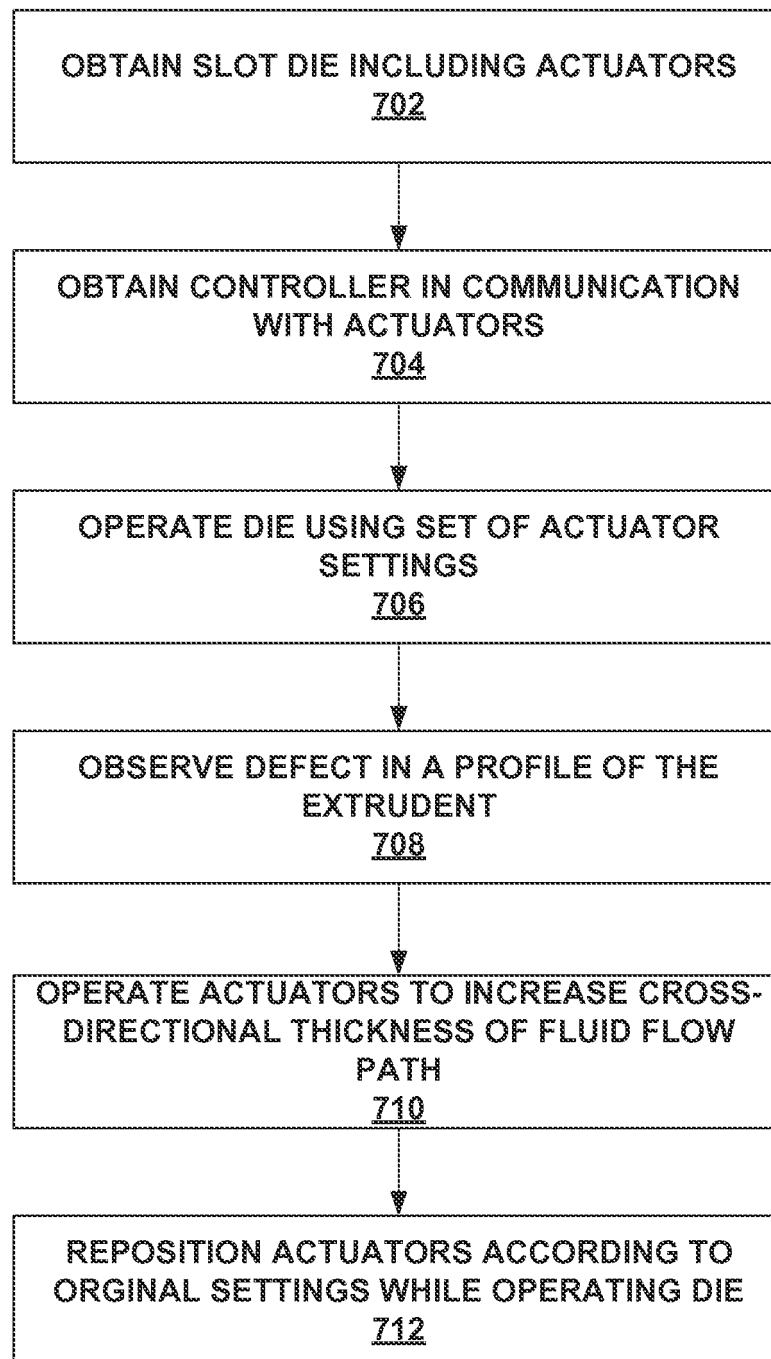


FIG. 7

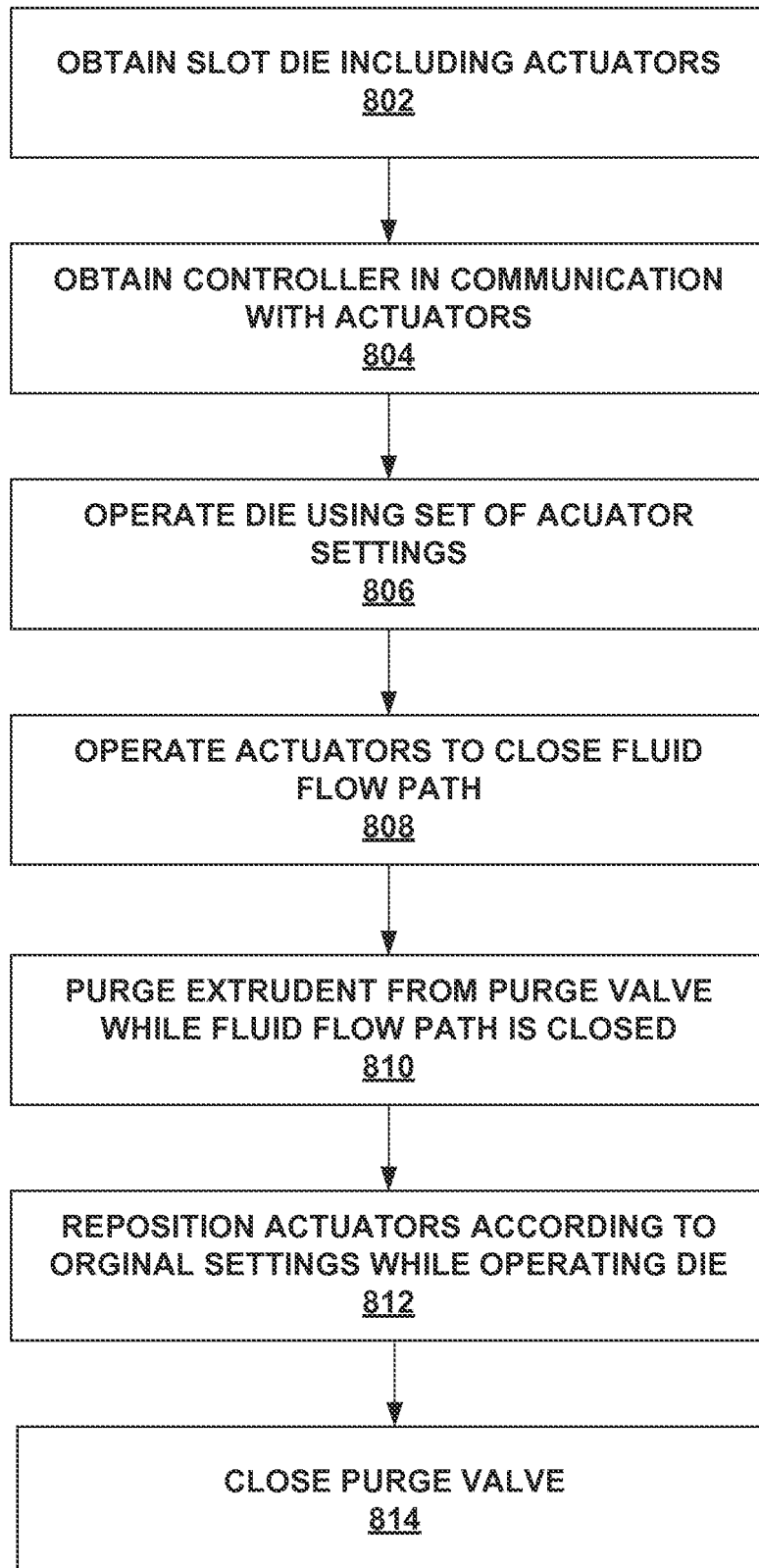


FIG. 8

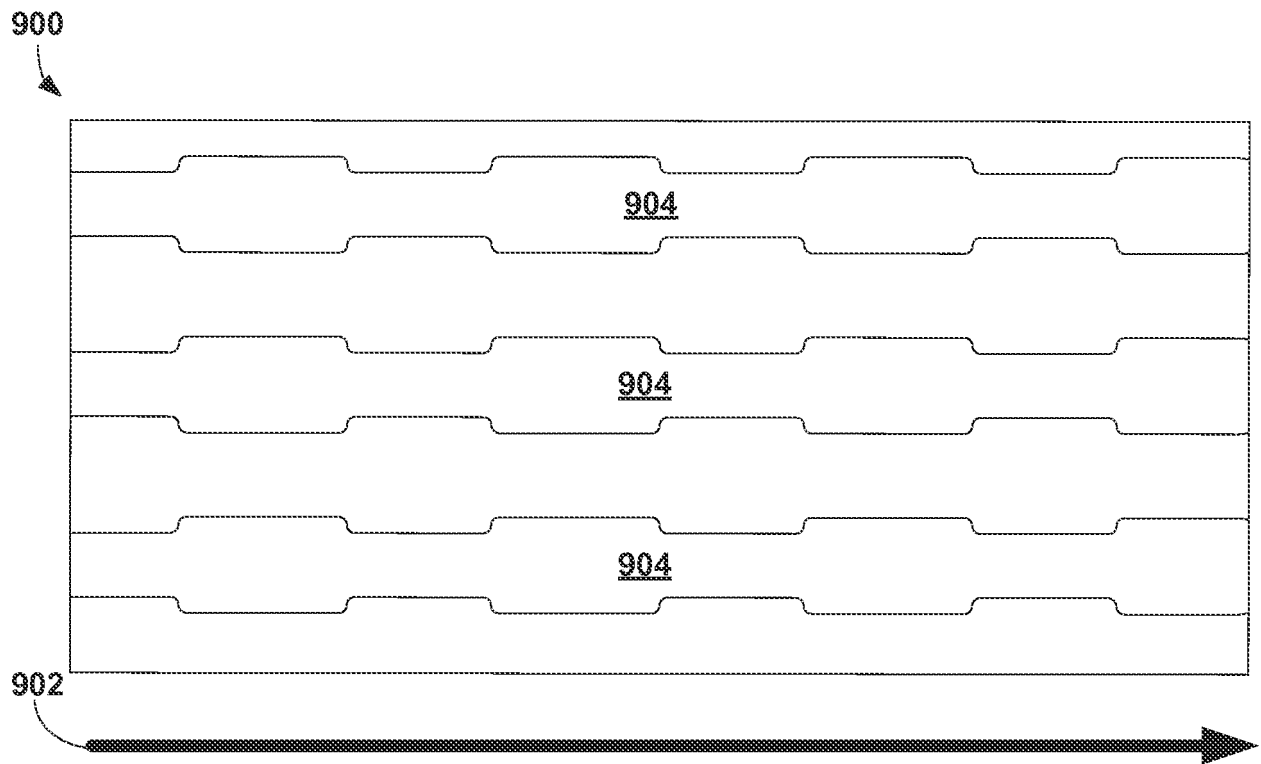


FIG. 9

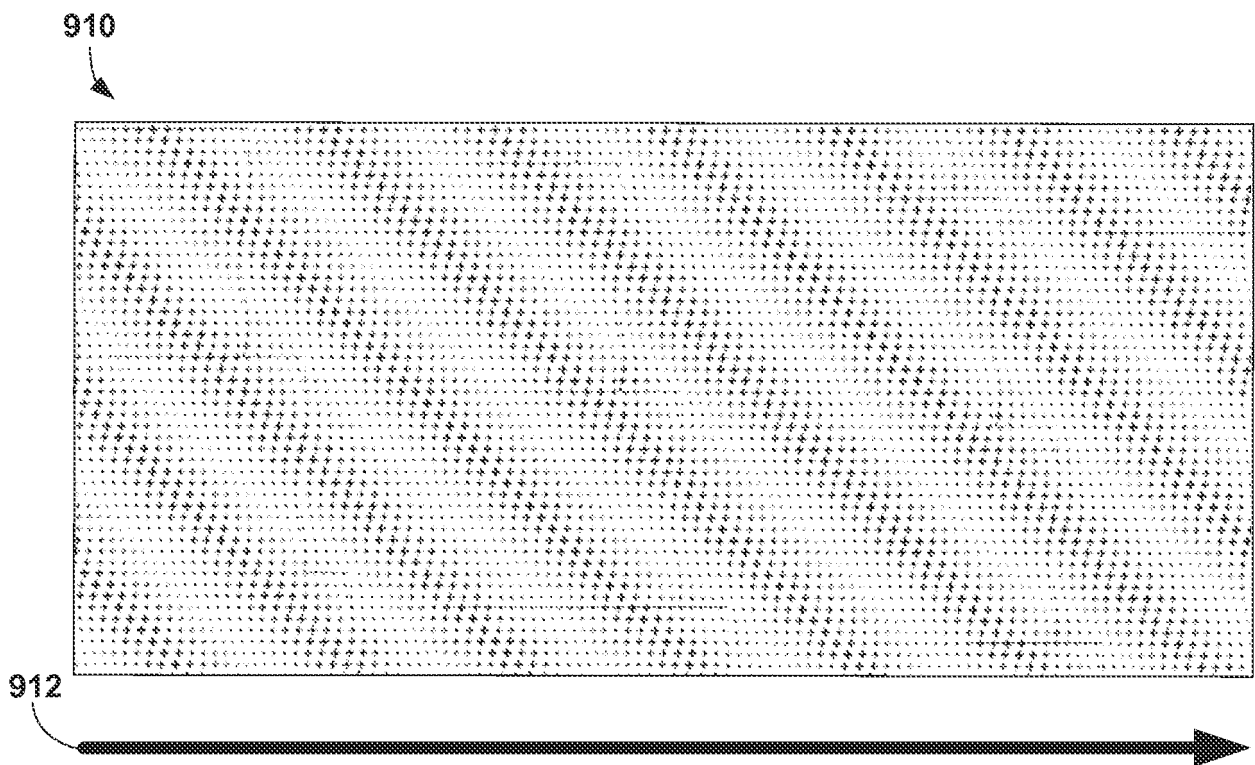


FIG. 10

REPLACEMENT SHEET

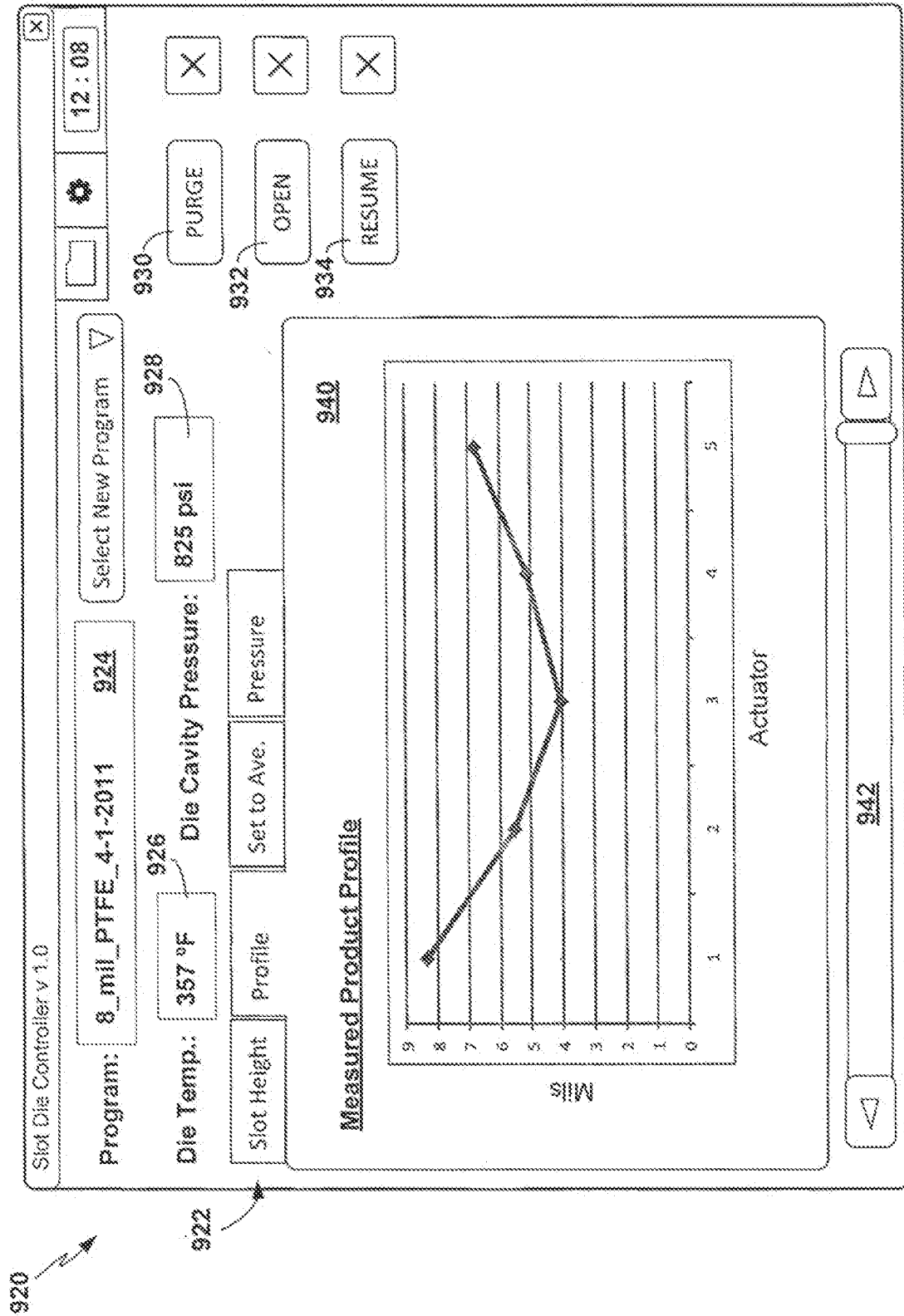


FIG. 11A

REPLACEMENT SHEET

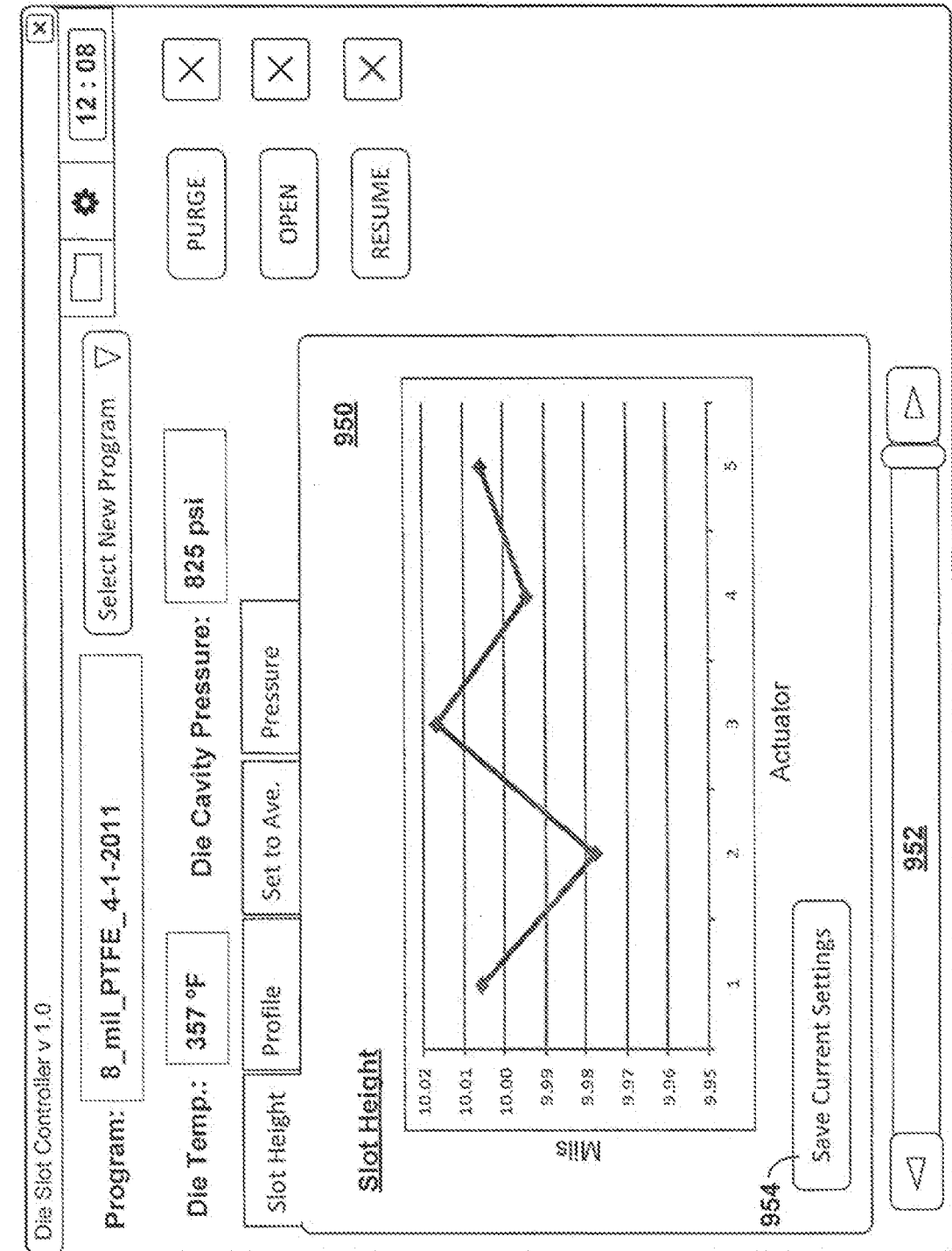


FIG. 11B

920

REPLACEMENT SHEET

Die Slot Controller v 1.0

8_mil_PTFE_4-1-2011

Select New Program

12:08

Die Temp.: 357 °F

Die Cavity Pressure: 825 psi

Slot Height

Profile

Set to Ave.

Pressure

PURGE

OPEN

RESUME

960

Auto-select Setpoints According to Average Profile Thickness

Actuator Current Position (Units)	-1799	-1804	-1797	-1801	-1799
Actual Current Height (mils)	10.01	9.98	10.02	9.99	10.01
Grains/4x6 from Gauge (NDC)	8.36	5.53	4.04	5.15	6.77
Avg. Grains/4x6 from Gauge (NDC)	5.97	5.97	5.97	5.97	5.97
Calculated Height (mils)	8.94	10.24	11.41	10.50	9.59
New Set Point (Units)	-1991	-1758	-1547	-1711	-1873

964

Update New Setpoints

966

Initiate Set to Average

FIG. 11C

REPLACEMENT SHEET

Die Slot Controller v 1.0

Program: 8_mil_PTFE_4-1-2011

Select New Program ▾

12:08

⚙

📁

Die Temp.: 357 °F

Die Cavity Pressure: 825 psi

Slot Height

Profile

Set to Ave.

Pressure

PURGE

OPEN

RESUME

✕

✕

✕

970

Auto-select Setpoints According to Selected Die Cavity Pressure

Actuator	1	2	3	4	5
Initial Slot Height (mils)	20	20	20	20	20
Initial Set Point (Units)	0	0	0	0	0
Actual Current Position (Units)	-1799	-1804	-1797	-1801	-1799
Actual Current Height (mils)	10.01	9.96	10.02	9.99	10.01
Calculated Height (mils)	10.27	10.24	10.28	10.25	10.27
New Set Point (Units)	-1751	-1756	-1749	-1753	-1751

Die Cavity Pressure: 825 psi

Set New Pressure: 800 psi

Update New Setpoints

Initiate Set to Pressure

FIG. 11D

920

REPLACEMENT SHEET

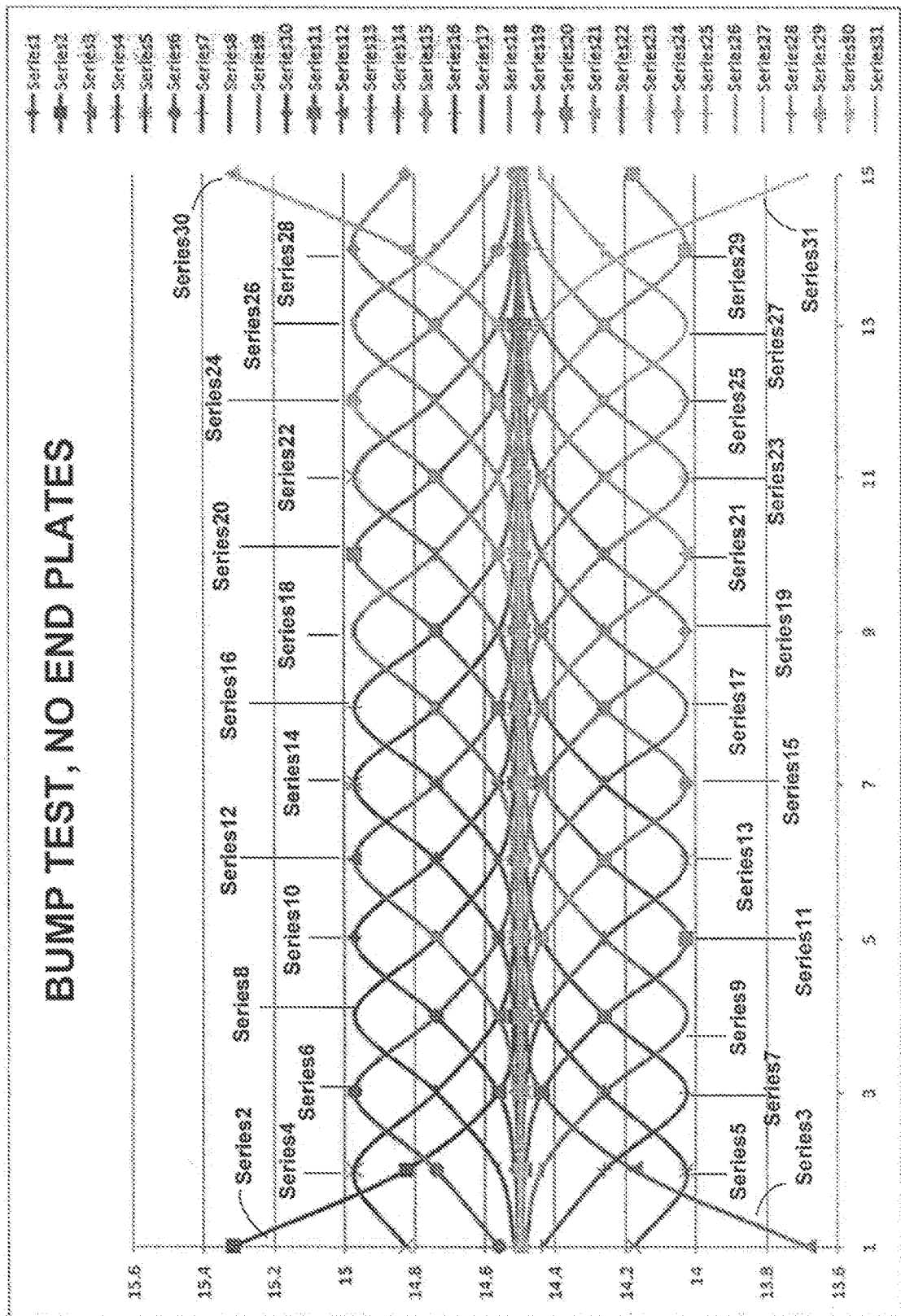


FIG. 12

REPLACEMENT SHEET

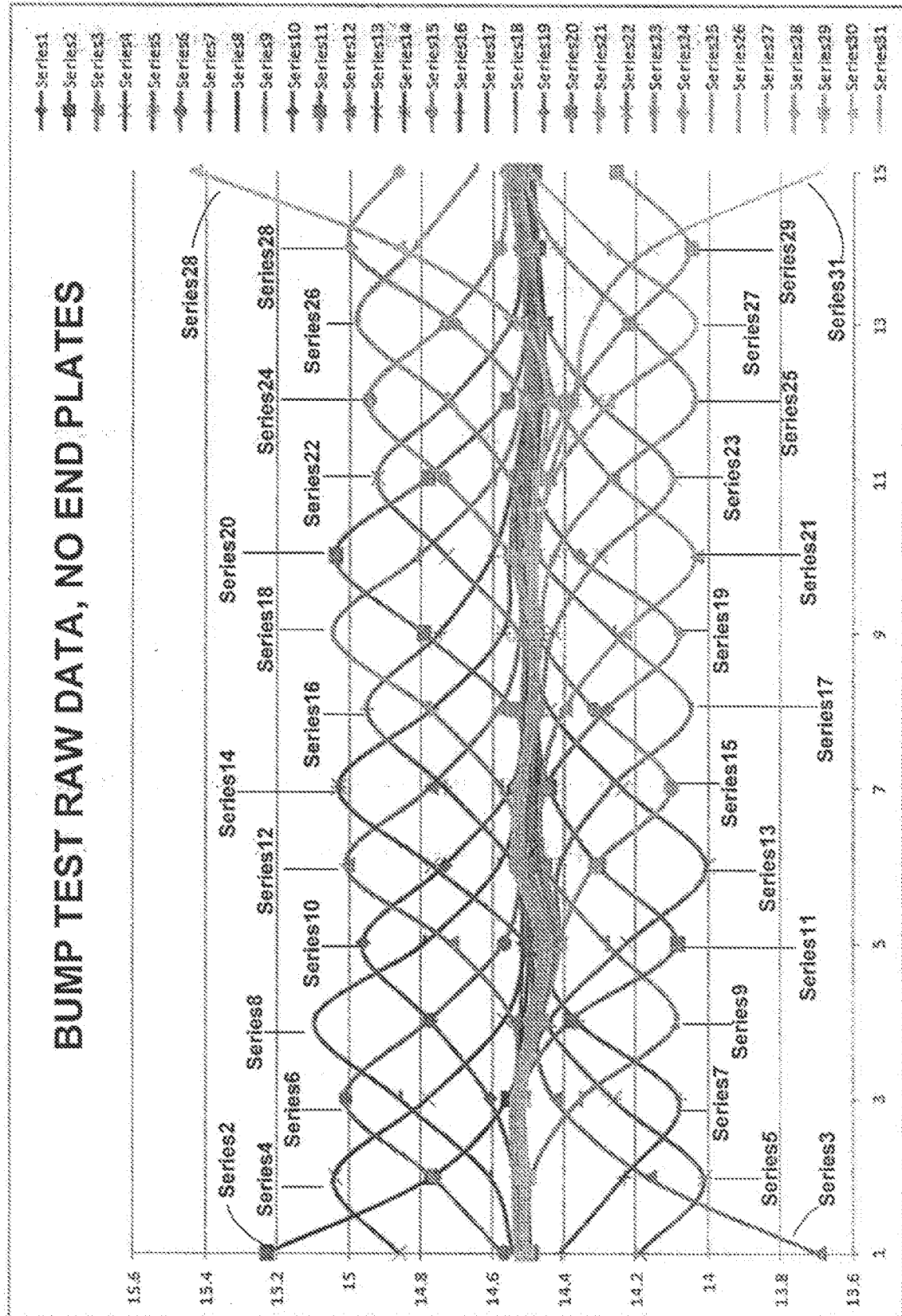


FIG. 13

REPLACEMENT SHEET

Positive Bump:

	1+	2+	3+	4+	5+	6+	7+
a	b	b	b	b	b	b	b
1	2	4	6	8	10	12	14
Gap1	0	0.703	0.042	0.013	-0.014	-0.011	-0.021
Gap2	0	0.526	0.25	0.091	0.010	0.002	-0.014
Gap3	0	0.037	0.26	0.49	0.337	0.014	0
Gap4	0	-0.007	0.049	0.719	0.577	0.253	-0.025
Gap5	0	-0.018	-0.01	0.054	0.275	0.448	-0.005
Gap6	0	-0.021	-0.023	-0.002	0.066	0.218	-0.264
Gap7	0	-0.018	-0.026	-0.011	0.02	0.046	0.272
Gap8	0	-0.023	-0.033	-0.022	0.002	-0.004	0.257
Gap9	0	-0.023	-0.038	-0.032	-0.009	-0.013	0.063
Gap10	0	-0.024	-0.041	-0.028	-0.007	-0.015	0.026
Gap11	0	-0.024	-0.033	-0.023	0.004	-0.013	0.008
Gap12	0	-0.025	-0.032	-0.018	0.011	-0.01	-0.003
Gap13	0	-0.023	-0.03	-0.011	0.018	0.006	-0.004
Gap14	0	-0.023	-0.021	-0.01	0.02	0.004	0.001
Gap15	0	-0.022	0	0.012	0.04	0.02	0.017

FIG. 14 - 1

REPLACEMENT SHEET

Positive Bump (cont'd):

9*	10*	11*	12*	13*	14*	15*
b	b	b	b	b	b	b
16	18	20	22	24	26	28
30						
-0.009	-0.02	-0.008	-0.024	-0.005	0.005	-0.018
0.009	-0.008	0.009	-0.013	0.002	0.023	-0.005
0.008	0.002	0.006	-0.008	0.011	0.02	0.003
-0.038	-0.038	-0.045	-0.047	-0.021	-0.025	-0.031
-0.07	-0.077	-0.089	-0.091	-0.045	-0.051	-0.054
0.018	-0.019	-0.043	-0.044	0.021	0.017	0.012
0.232	0.075	0.004	-0.01	0.032	0.027	0.021
0.437	0.264	0.027	-0.034	-0.021	-0.026	-0.03
0.239	0.537	0.285	0.017	-0.017	-0.02	-0.032
0.076	0.279	0.513	0.203	0.026	-0.025	-0.045
0.022	0.077	0.263	0.404	0.22	0.032	-0.039
0.007	0.02	0.065	0.222	0.451	0.232	0.011
0.008	0.011	0.015	0.063	0.244	0.489	0.219
0.026	0.011	0.006	0.018	0.078	0.31	0.496
0.023	0.026	0.023	0.025	0.045	0.131	0.468
						0.915

FIG. 14 - 2

REPLACEMENT SHEET

Negative Bump:

1.	2.	3.	4.	5.	6.	7.
c	c	c	c	c	c	c
	3	5	7	9	11	13
Gap1	-0.831	-0.337	-0.116	-0.009	-0.034	-0.019
Gap2	-0.731	-0.505	-0.281	-0.021	-0.008	-0.006
Gap3	-0.095	-0.259	-0.443	-0.167	0.008	-0.004
Gap4	-0.04	-0.069	-0.156	-0.433	-0.134	-0.077
Gap5	-0.028	-0.018	-0.03	-0.236	-0.429	-0.288
Gap6	-0.023	-0.008	-0.031	-0.061	-0.212	-0.513
Gap7	-0.02	-0.001	-0.034	-0.01	-0.059	-0.263
Gap8	-0.03	-0.009	-0.036	-0.004	-0.033	-0.073
Gap9	-0.032	-0.011	-0.034	-0.001	-0.029	-0.013
Gap10	-0.031	-0.011	-0.037	-0.004	-0.023	0.008
Gap11	-0.025	-0.004	-0.039	0.003	-0.021	0.004
Gap12	-0.029	0.002	-0.034	0.007	-0.014	0.001
Gap13	-0.031	0.011	-0.028	0.016	-0.004	0.007
Gap14	-0.03	0.014	-0.023	0.017	-0.005	0.005
Gap15	-0.031	0.033	-0.006	0.035	0.012	0.023

FIG. 14 - 3

REPLACEMENT SHEET

Negative Bump (cont'd):

8-	9-	10-	11-	12-	13-	14-	15-
c	c	c	c	c	c	c	c
17	19	21	23	25	27	29	31
-0.021	-0.023	-0.02	-0.02	-0.005	-0.014	-0.008	-0.023
-0.014	-0.014	-0.004	-0.015	-0.001	-0.006	0.002	0.002
-0.005	-0.006	-0.006	-0.006	0.005	0.006	0.008	-0.005
-0.047	-0.046	-0.055	-0.037	-0.025	-0.027	-0.028	-0.046
-0.102	-0.091	-0.103	-0.064	-0.062	-0.061	-0.05	-0.074
-0.104	-0.053	-0.061	0.002	0.015	0.02	0.017	-0.003
-0.231	-0.052	-0.038	0.012	0.023	0.026	0.024	0.009
-0.465	-0.232	-0.114	-0.049	-0.032	-0.025	-0.026	-0.032
-0.247	-0.427	-0.275	-0.079	-0.043	-0.029	-0.023	-0.035
-0.065	-0.166	-0.492	-0.226	-0.097	-0.046	-0.027	-0.049
-0.011	-0.028	-0.251	-0.423	-0.252	-0.09	-0.046	-0.078
-0.005	-0.007	-0.073	-0.186	-0.46	-0.227	-0.113	-0.122
0.003	-0.001	-0.018	-0.035	-0.28	-0.451	-0.265	-0.157
0.005	0.004	-0.009	-0.006	-0.061	-0.224	-0.154	-0.145
0.022	0.021	0.011	0.018	0.008	-0.018	-0.25	-0.827

FIG. 14 -- 4

REPLACEMENT SHEET

	A	B	C	D	E	F	G	H	I	J
1										
2										
3										
4	Actuator	1	2	3	4	5	6	7	8	9
5	Initial Slot Height (mils)	14.351	14.46	14.699	14.678	14.622	14.541	14.414	14.287	14.258
6	To Lip Stiffness Calculator									
7	Initial Set Point (Units)	.981	.859	.685	.510	.757	.840	.756	.796	.1001
8	To Lip Stiffness Calculator									
9	Actuator Current Pos (inches)	.981	.859	.685	.510	.757	.840	.756	.796	.1001
10	To Lip Stiffness Calculator									
11	Actual Current Height (mils)	14.351	14.460	14.699	14.678	14.622	14.541	14.414	14.287	14.268
12	From Lip Stiffness Calculator									
13	Entered Desired Slot, mil	14.50	14.50	14.50	14.50	14.50	14.50	14.50	14.50	14.50
14	Usually a Flat Uniform Slot									
15	New Set Point (Units)	.960	.801	.791	.524	.787	.853	.745	.739	.952
16	From Lip Stiffness Calculator									
17	Actuator Change - Units	21	58	-106	-14	-30	-13	11	57	49
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FIG. 15 - 1

REPLACEMENT SHEET**Pdsa Posaition Calculator (cont'd)**

K	L	M	N	O	P	Q	R
10	11	12	13	14	15		
14.29	14.259	14.339	14.371	14.255	14.116	From Die Slot Measurements (Capacitec)	
-648	-743	-694	-840	-944	-1130	From PDSA Actuator Positions	
-648	-743	-694	-840	-944	-1130		
14.290	14.269	14.339	14.371	14.255	14.116	14.40	Average
14.50	14.50	14.50	14.50	14.50	14.50		
-629	-676	-673	-840	-897	-1056	To PDSA Actuator Positions	
19	67	21	0	47	74		

FIG. 15 - 2

REPLACEMENT SHEET

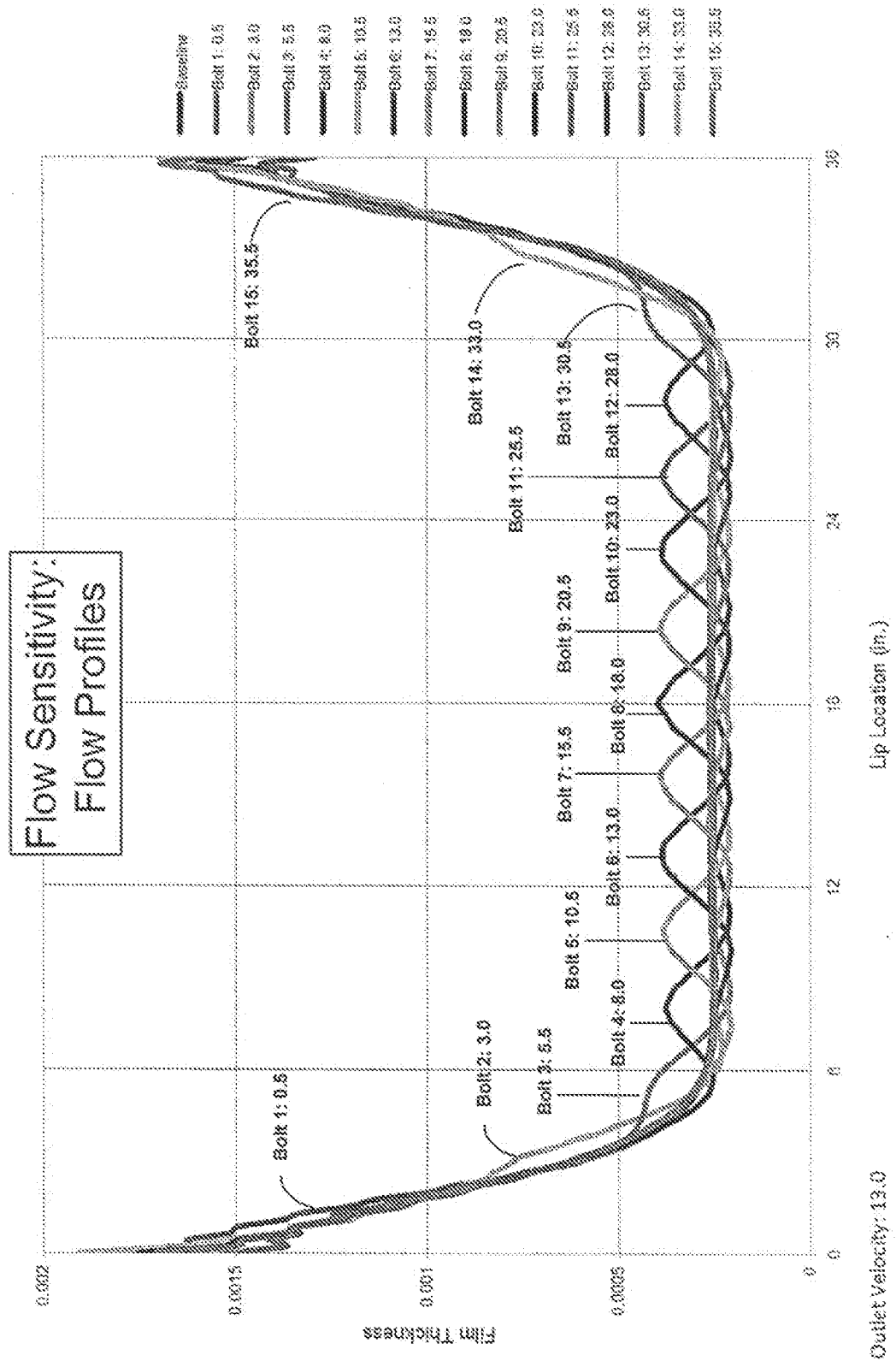


FIG. 16

REPLACEMENT SHEET

**Flow sensitivity measurement is normalized to the central thickness

Flow Sensitivity: Bolt 4
Location: 8.0

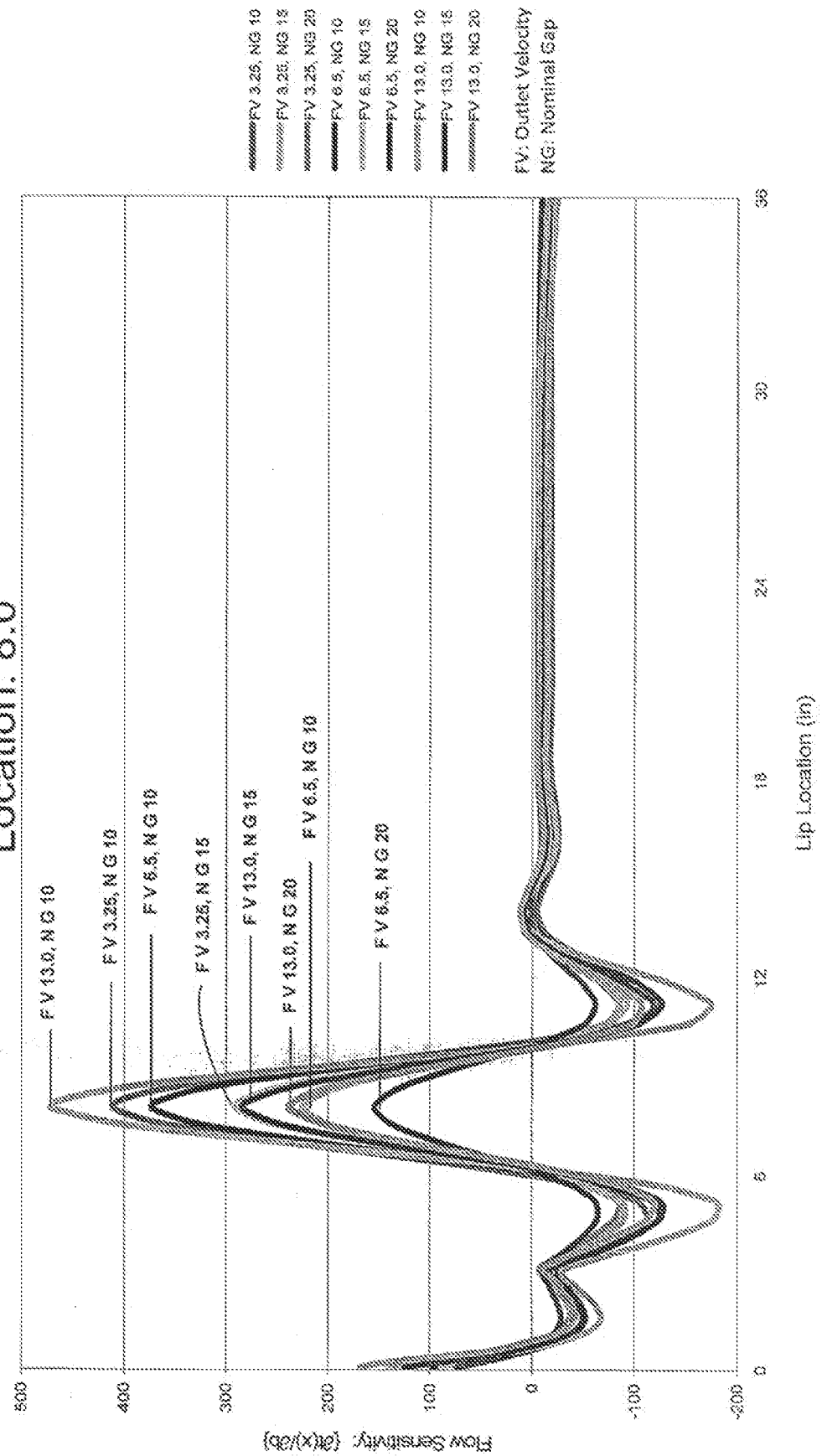


FIG. 17

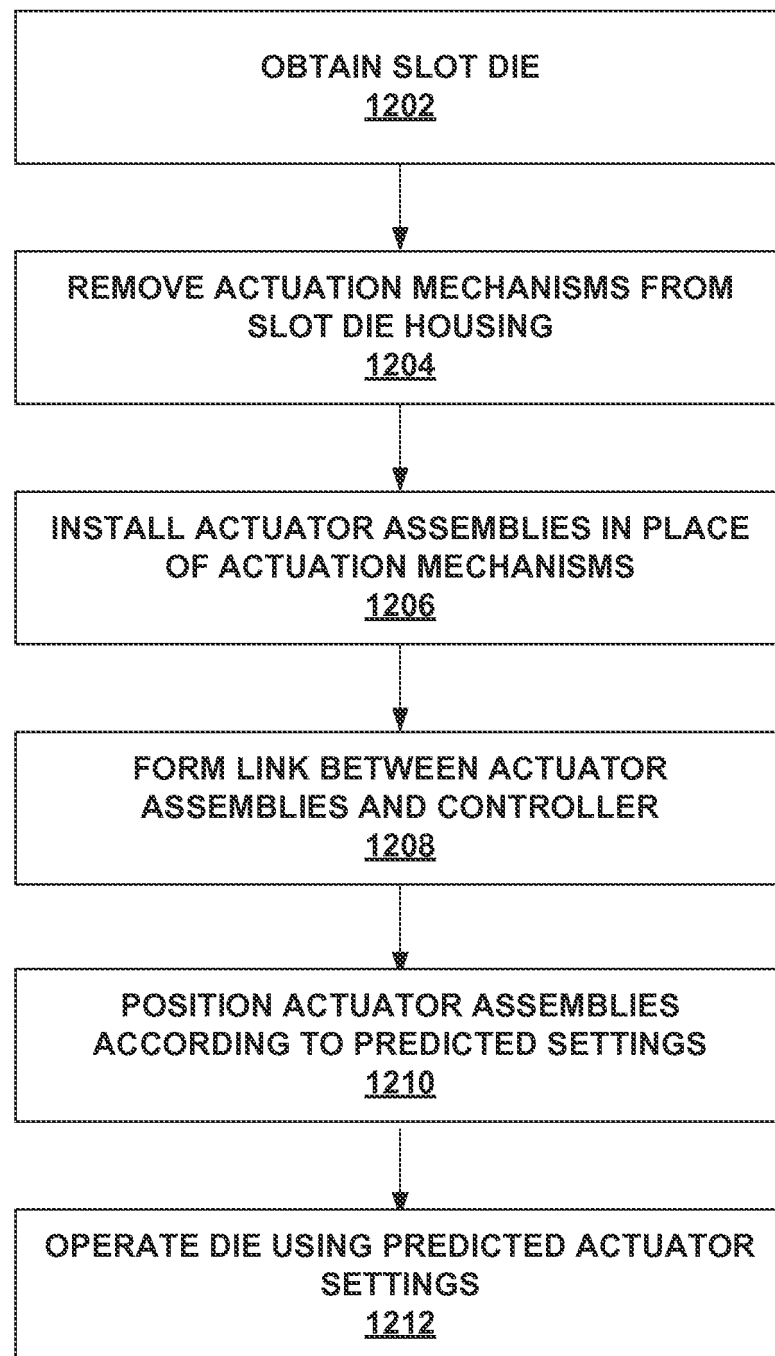


FIG. 18