FIG.1

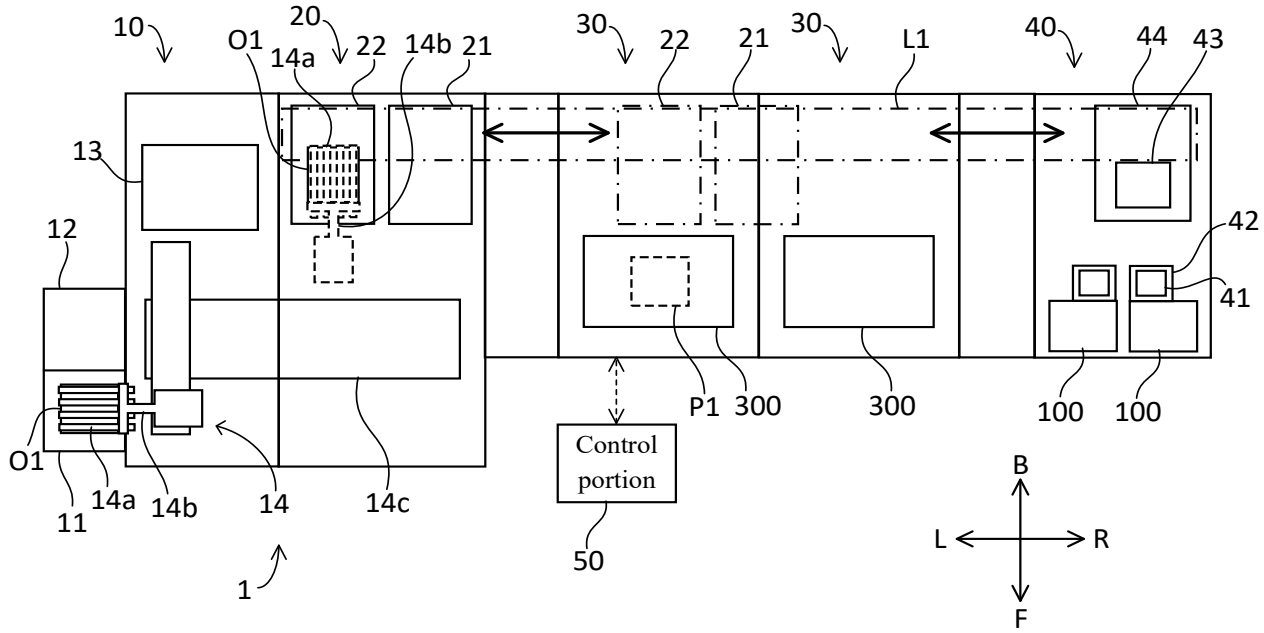

10
O1
20
14a
22
14b
21
30
22
21
30
L1
40
44
43
13
12
42
41
O1
11
14a
14b
14
14c
1
P1
300
300
100
100
Control portion
50
B
L
R
F

FIG.2

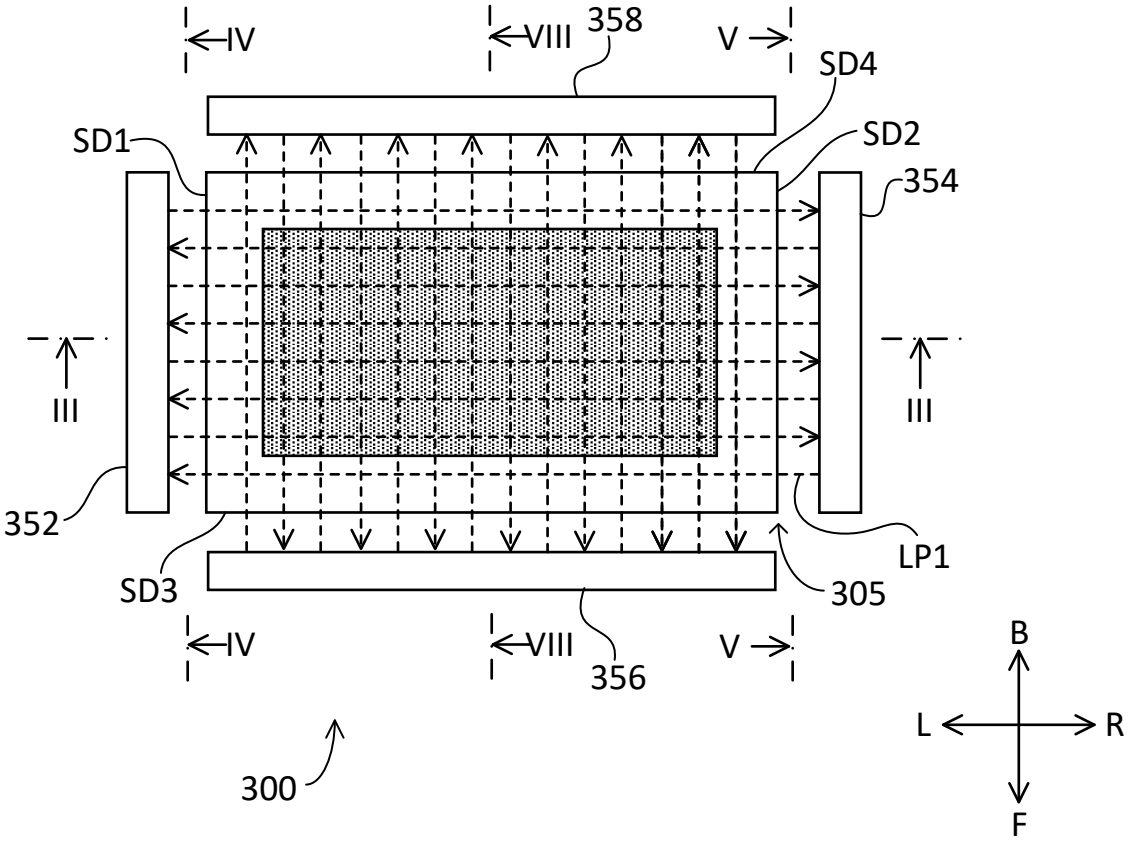

IV
VIII
358
V
SD4
SD1
SD2
354
III
III
352
LP1
SD3
305
IV
VIII
356
V
300
B
L
R
F

FIG.3

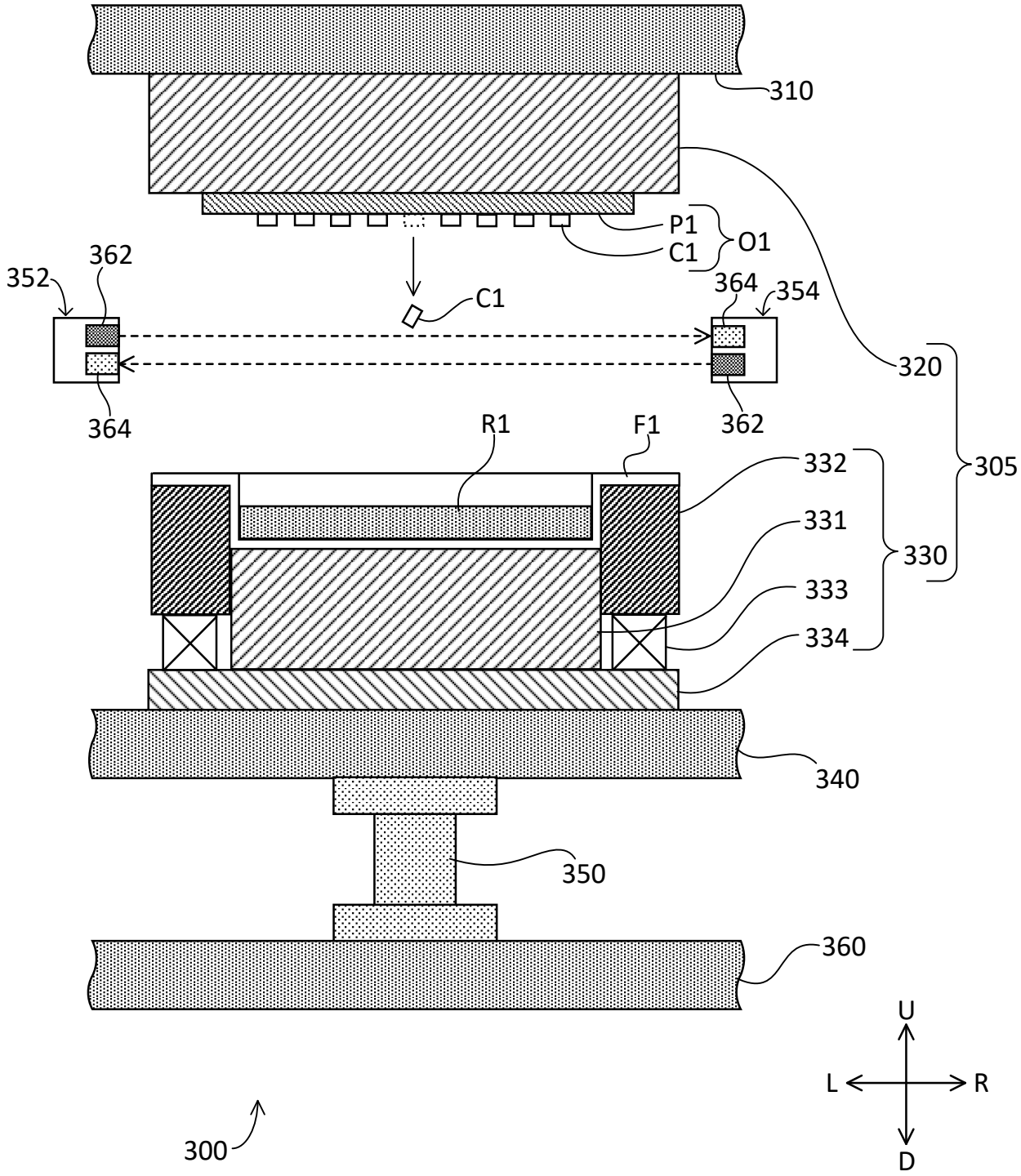

310
P1
C1
O1
362
352
C1
364
354
320
364
362
R1
F1
332
305
331
330
333
334
340
350
360
U
L
R
D
300

FIG.4

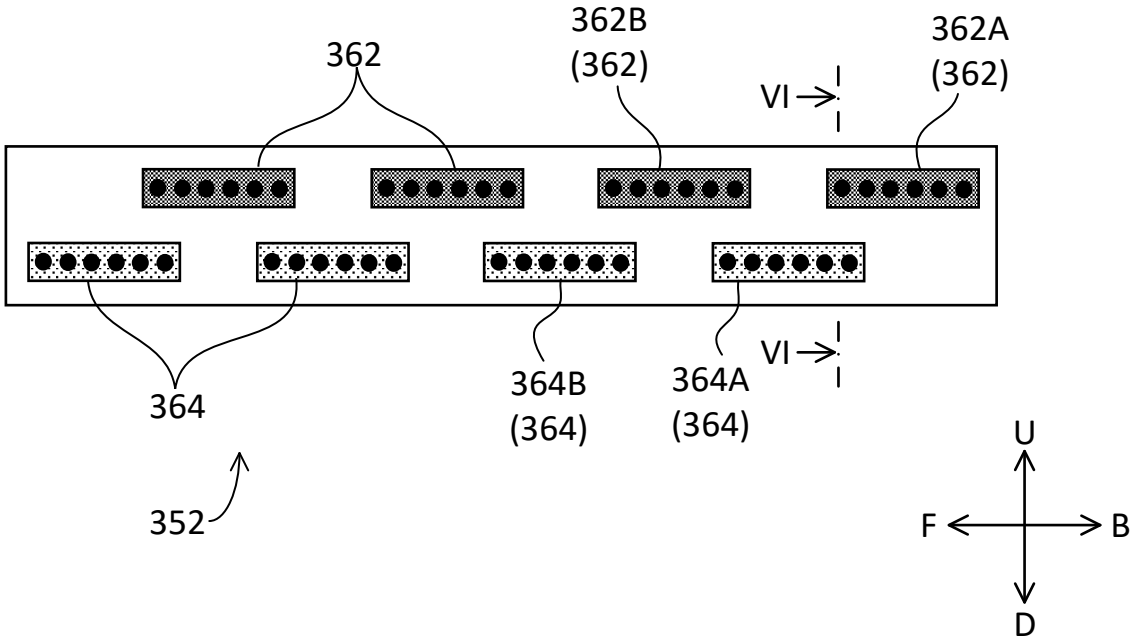


FIG.5

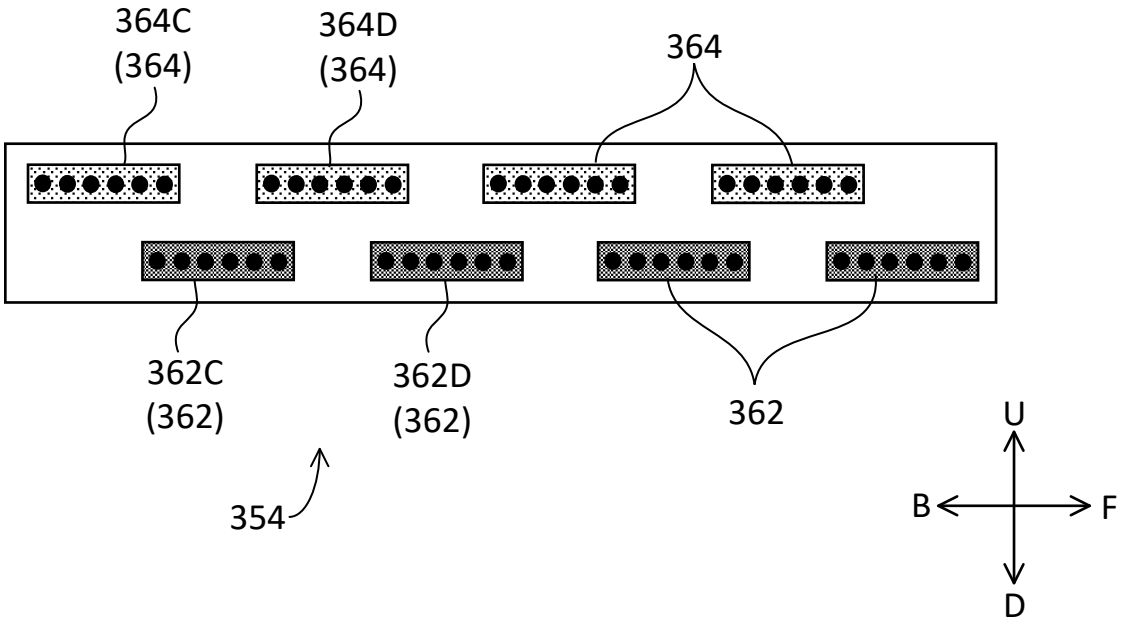


FIG.6

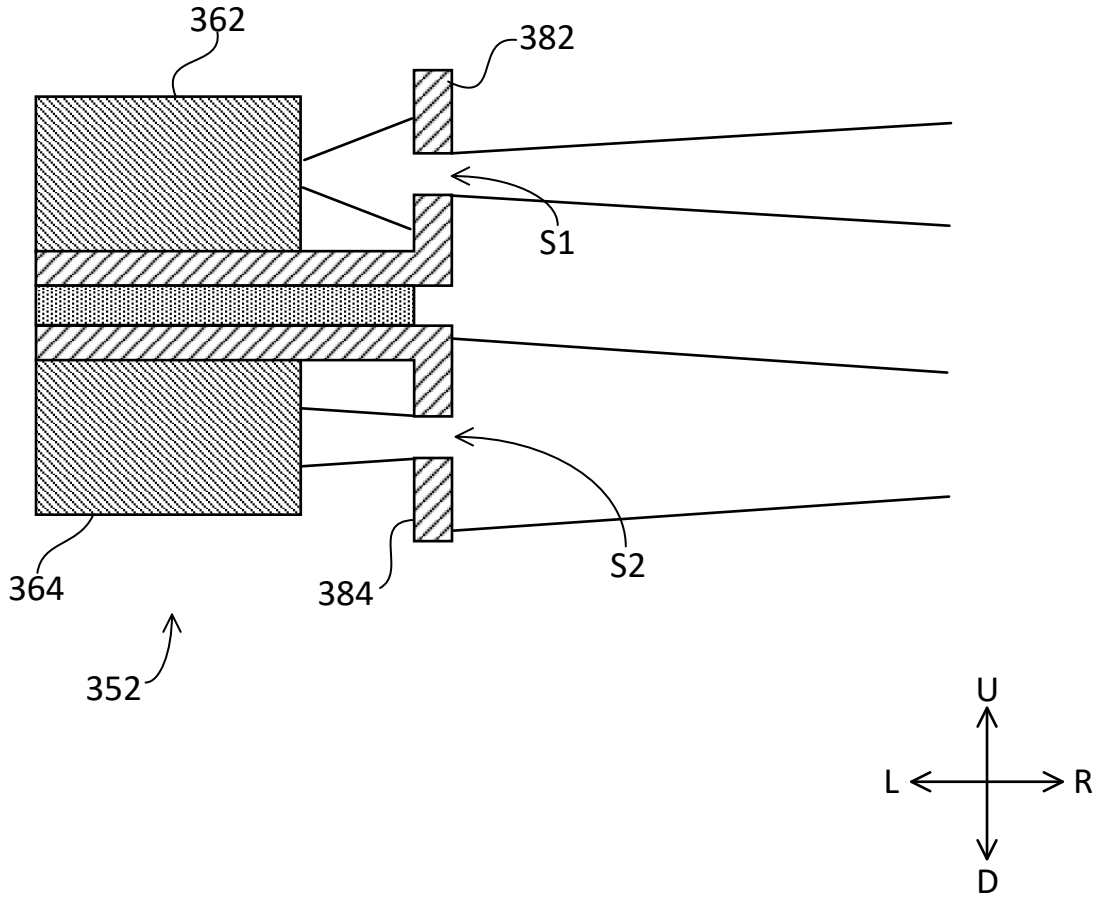


FIG.7

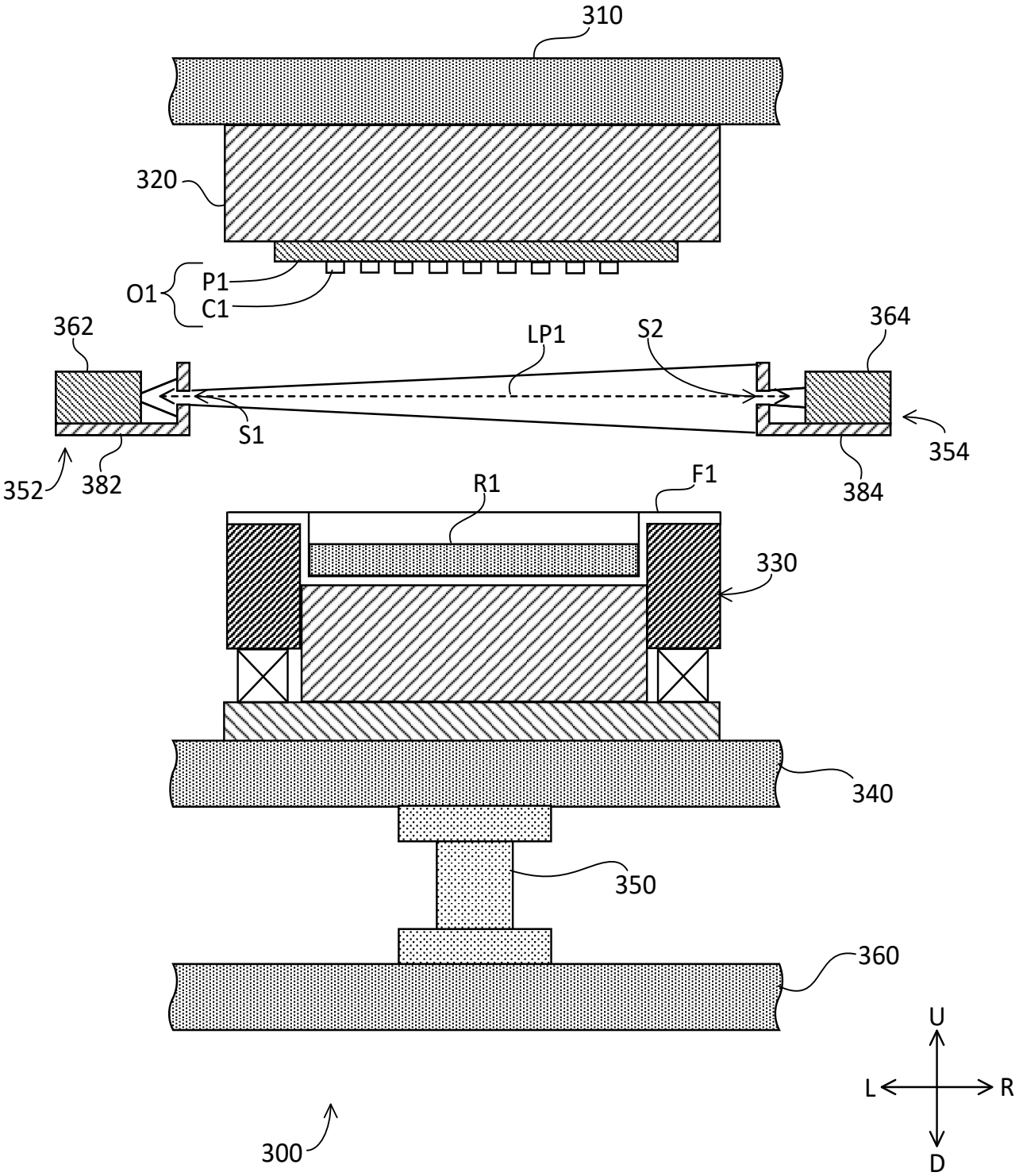

310
320
O1
P1
C1
362
LP1
S2
364
S1
352
382
354
384
R1
F1
330
340
350
360
300
U
L
R
D

FIG.8

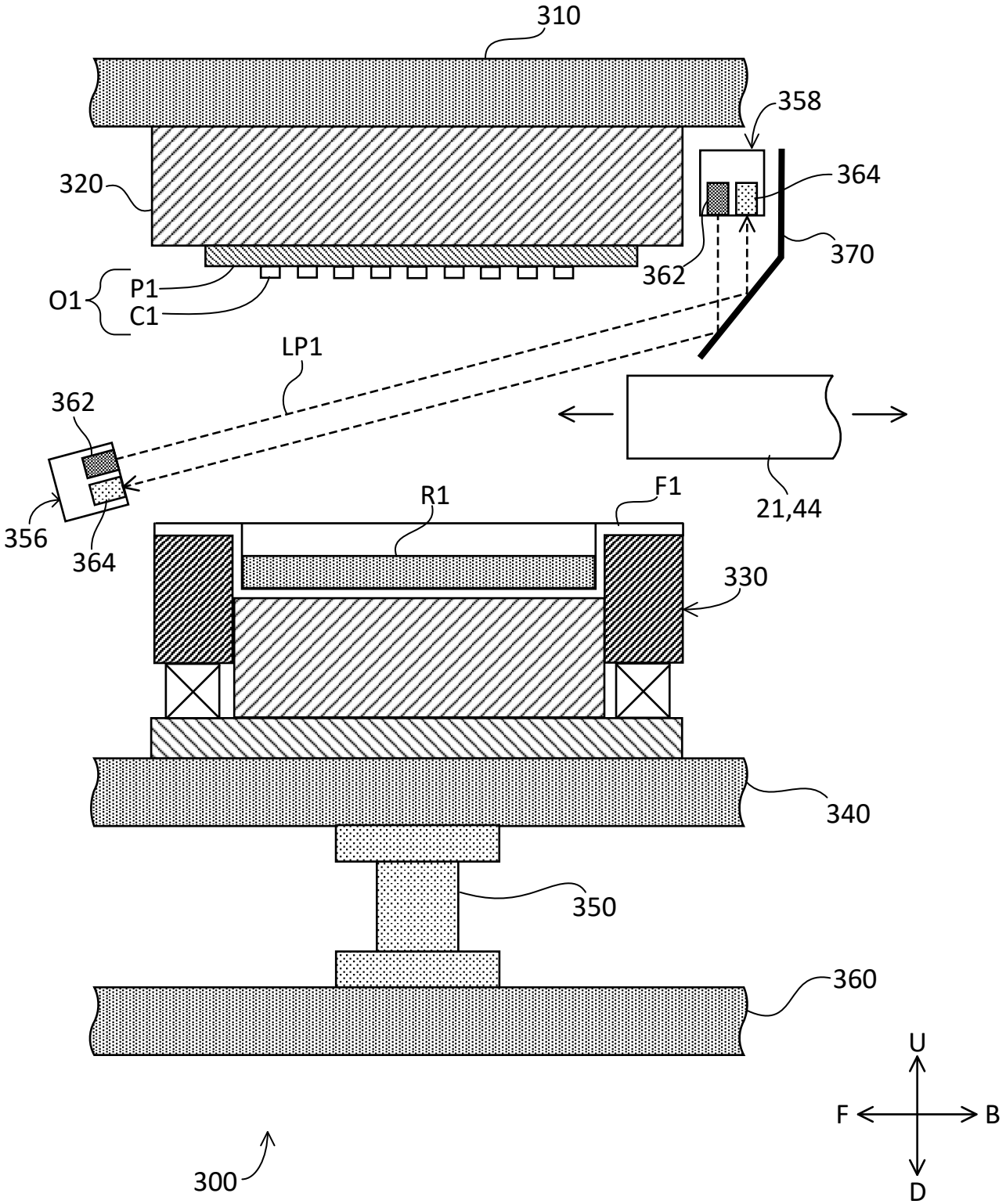

310
358
320
364
370
362
O1
P1
C1
LP1
362
356
364
R1
F1
21,44
330
340
350
360
300
U
F
B
D

FIG.9

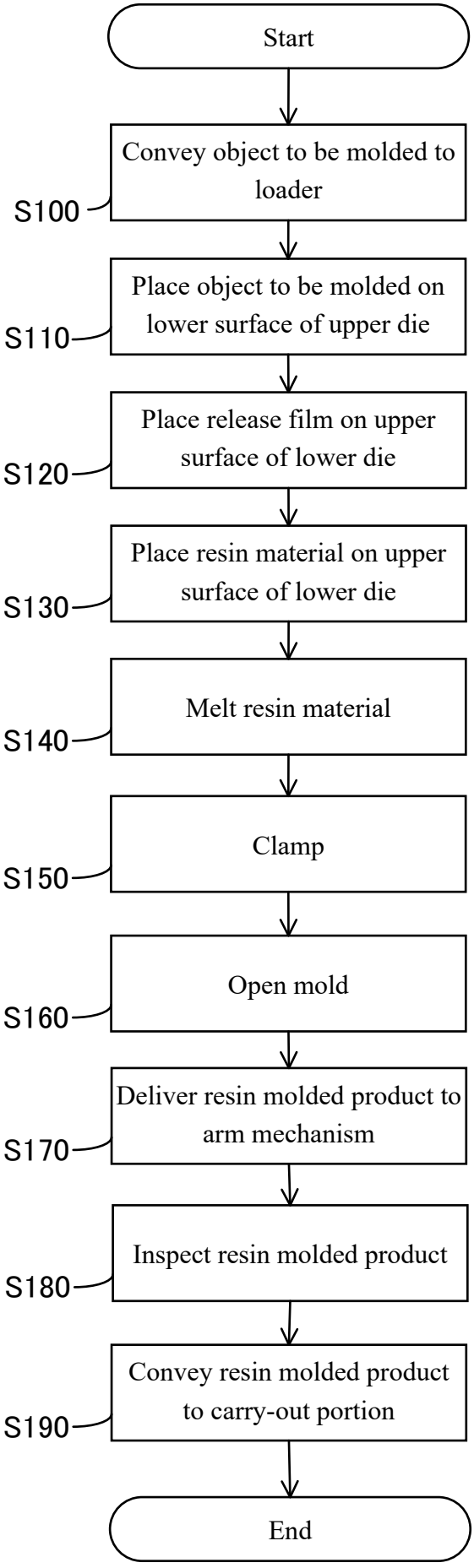

Start
Convey object to be molded to loader
S100
Place object to be molded on lower surface of upper die
S110
Place release film on upper surface of lower die
S120
Place resin material on upper surface of lower die
S130
Melt resin material
S140
Clamp
S150
Open mold
S160
Deliver resin molded product to arm mechanism
S170
Inspect resin molded product
S180
Convey resin molded product to carry-out portion
S190
End

FIG.10

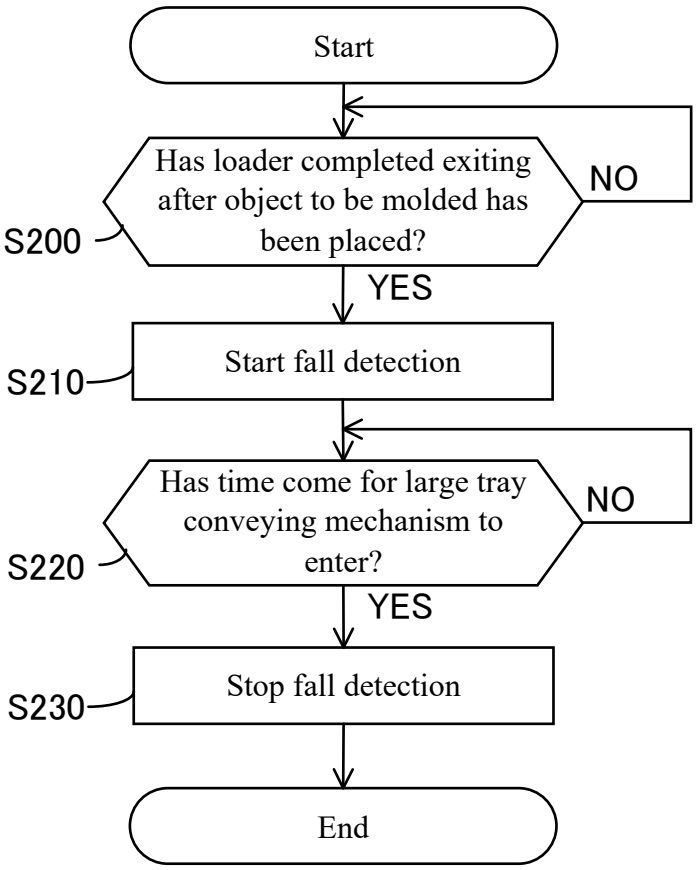
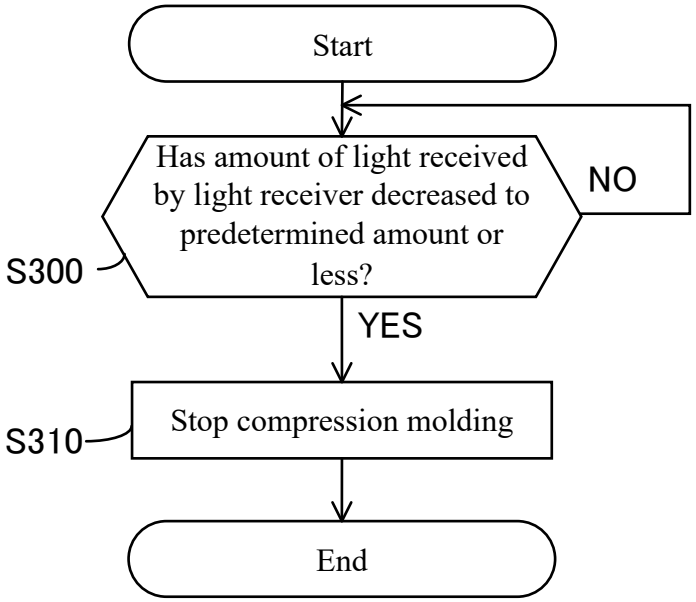

Start
Has loader completed exiting after object to be molded has been placed?
NO
S200
YES
Start fall detection
S210
Has time come for large tray conveying mechanism to enter?
NO
S220
YES
Stop fall detection
S230
End

FIG.11


Start
Has amount of light received by light receiver decreased to predetermined amount or less?
NO
S300
YES
Stop compression molding
S310
End