FIG. 1

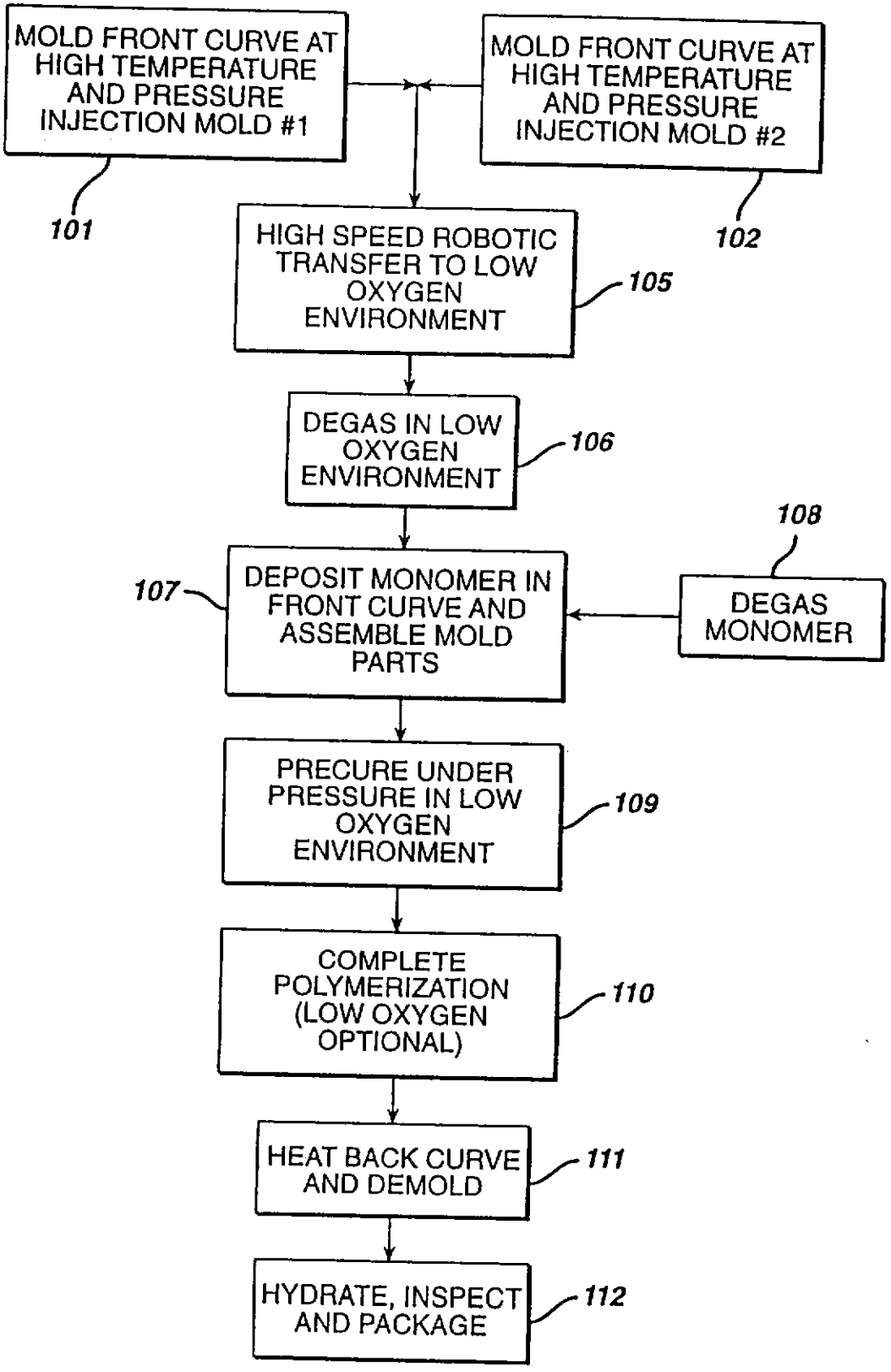
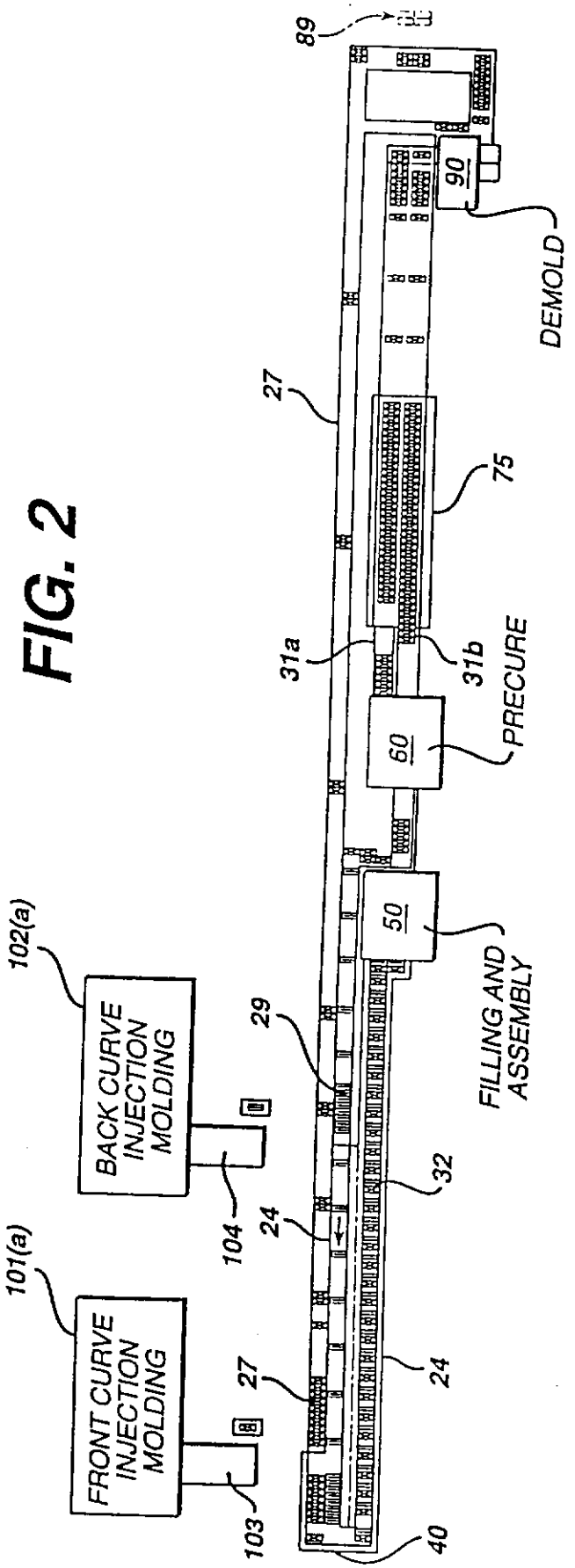

MOLD FRONT CURVE AT HIGH TEMPERATURE AND PRESSURE INJECTION MOLD #1
101
MOLD FRONT CURVE AT HIGH TEMPERATURE AND PRESSURE INJECTION MOLD #2
102
HIGH SPEED ROBOTIC TRANSFER TO LOW OXYGEN ENVIRONMENT
105
DEGAS IN LOW OXYGEN ENVIRONMENT
106
108
DEPOSIT MONOMER IN FRONT CURVE AND ASSEMBLE MOLD PARTS
107
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

FIG. 2


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

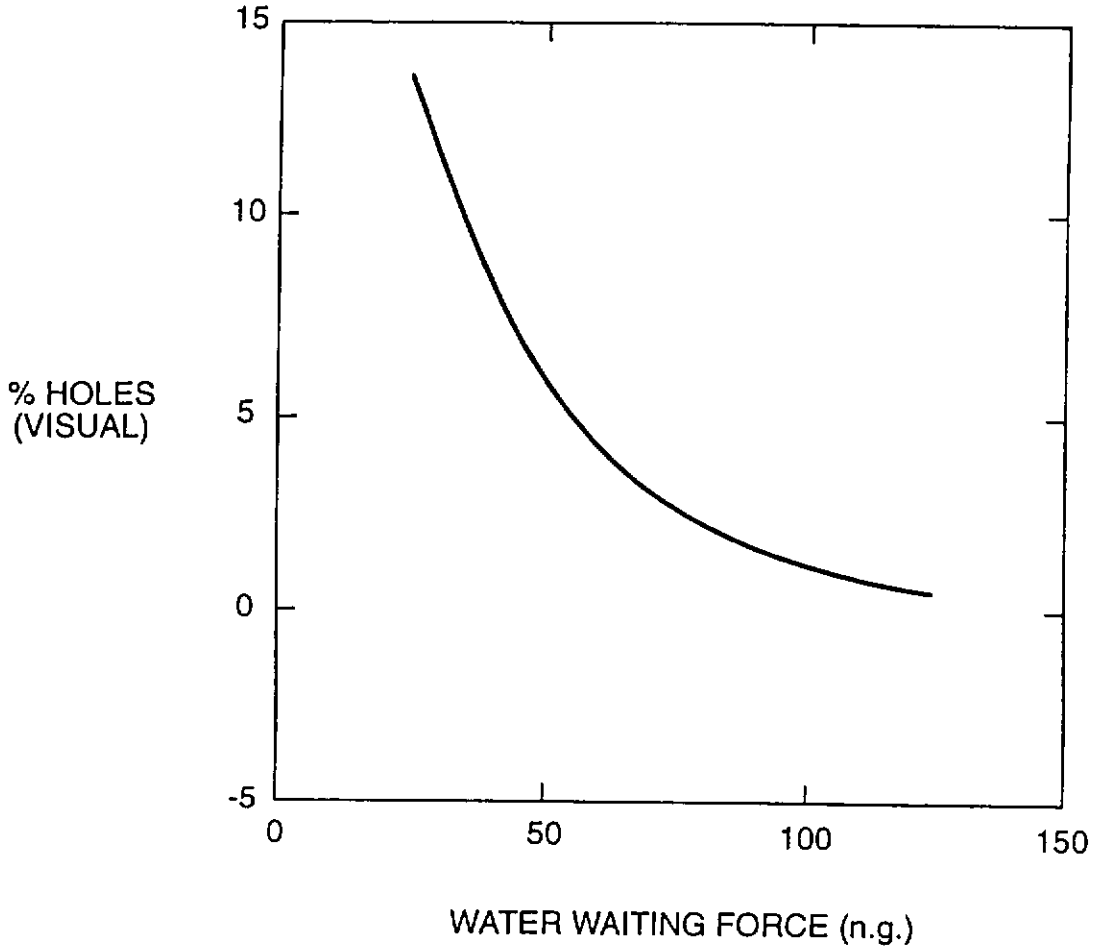



FIG. 3