

Attribute	Recommendation
Wall Thickness	0.040" (1 mm) Minimum 0.500" (127 mm) Allowable
Draft Angle	1 Degree
Undercuts	Not Recommended
Shrinkage	0.002 to 0.006 IN/IN (mm/mm) 0.004 is Typical Value
Gate Size	0.045"(1.1 mm) Minimum Diameter
Vent Size	0.001" (0.025 mm) Deep 0.0015" (0.040 mm) Allowable Before Flash
Runner Sizing	0.312" (8 mm) Diameter for Primary Runner; Reduce by 0.063" (1.5 mm) for Each Additional Leg
Cycle Time	35 Seconds per 1/8" (3 mm) of Thickness
Clamp Tonnage	2.5 Tons per Square Inch of Projected Area