


Date	1 st of March 2010
Written by	NIHAL KOÇAK [TR]
Place / Time	Activities / Results / Points of importance
Thursday 21st of January 2010	Arrival day
Friday 22nd of January 2010 Cenfim (9:00 to 12:45)	<p>Greeting of the 6 participating schools from</p> <ul style="list-style-type: none"> * Germany * Austria [FUL] * Austria [STP] * Portugal * Spain * Turkey <p>held by FERNANDO BRANCO RODRIGUES and announcement of the first day's schedule.</p> <p>Project Coordinator HEINZ WILDGRUBE gave his best wishes to everybody&proposed to prepare a board & write down all the tasks on it. The working subjects were written then divided into three working days.</p> <p>The tasks; testing inserts, continuing work on dictionary, comparison of final exam, cooling system , design technology for logos, grinding of inserts, eroding the cavities, how to produce the electrodes, production of runners, procedure of further steps of work, chain+ring for key fob, cost of POM.</p>  <p>All the partners decided to control&finish the work on the dictionary. The school of Aut-FU will produce all the runners for all the schools. The cooling system is inside the insert-holding-plates and is done by HTL FULPMES.</p> <p>Each school has to prepare the inserts of mould (2 inserts; injection side&ejection side) with the logo of country&school.</p> <p>Each school has to make own electrodes.</p>

A visit to facilities of CENFIM Trofa by the means of laboratories,workshops&classes.



After CENFIM visiting ,CELOPLAS was visited by all the partners.



**Saturday
23 rd of
January
2010
CENFIM
9:00 to
12:30
COVELAS
&
JULINHA**

After a hot greeting the meeting was started.

Heinz encouraged again everybody to register and participate in the forum (<http://mould.cnc-network.eu>). To prevent spam,the user name must be in the following way: [CountryID] 1st name 2nd name.

As long as the inserts are manufactured within the tolerances given in the drawing,there should no more grinding be necessary, except the front sides (after mounting all inserts) together.

Testing the inserts has been done by the students&teachers. While testing, some minor problems occured but they were overcome by the skillful students&teachers.



There could be inserting problems in FULPMES. Because of this reason every partner has to send them to FULPMES until 31st of March.

The eroding of the cavities has to be done by each partner.

If venting of cavities is necessary, it can be done.

For producing electrodes; EDM process will be used. Jaume [ES]&[AU-FUL] group had prepared before a script&distributed &showed to everybody.

The running system will be done by HTL-FUL after accepting all inserts in the ejection side.

The PORTUGAL group will produce all the holes in the ejector device, as they have got a drawing from FULPMES in the meantime and will bring it or send it to FULPMES ready done.

The distance between the holes is 18*18mm (as for all the other measurements take a look at the drawing of the inserts in the forum).



Every school is free to do logos but in general;

The logos of the landscape+letters of each country have to be done at the injection side ,

The logos of each school at the ejection side, within a deepness of 0,3 to 0,5mm.

Voting for colour of key fob & the multicolour is the winner.
Every school decided to have 200 pieces. Totally 1200 pieces.

At the end of the working JOSE MAGALHAES MOREIRA (Vereador da camara municipal da Trofa=Alderman of the municipal council of the Trofa) visited the CENFIM workshop with two beautiful translators VERA & PAULAC. After making a speech all the partners went to lunch at a typical place in Trofa: COVELAS.



The dinner was at a typical restaurant in Trofa: JULINHA.
The Mayor of Trofa Mrs. LIMA joined to the dinner. Some interviews were done by local TV & The Mayor & Alderman of Trofa gave very special gift to everybody. The gift has the flags of six countries! It has published since 25th of January on: www.trofa.tv.



**Sunday
24th Of
January
2010**

Cultural day

Travelling on the coast side up to "CAMINHA" city



**Monday
25 th of
January
CENFIM
9:00 to
12:00**

This meeting was for summing up all results achieved.

*Every school should finish the dictionary studies with the names&discriptions .

*Every school has to prepare 10 questions with multiple choices&then send to JAUME[ESP]up to 19th of February for putting them into the forum.Comparing the final exam should be done.

*All the schools shoul send the pictures on a CD-ROM/DVD to Heinz up to 15 thof February.

*The correcting of the drawings will be done by AXEL&JANA[DE].It will be ready on 29th of January.

The

partners can discuss from Saturday 30thof January , 12 am up to 1st of February ,8pm.

*The deadline of sending of inserts to FULPMES is 31st of March.

*Producing with POM,all the measurements of the cavity have to Be calculated with the shrinkage of 2% after a hot discussion:

$$L_p=24.8 \quad l_c=2 \quad s=2\% \quad 24,8 \times 1,02 = 25,296 \text{ mm (not exact calculated!!!)}$$

$$24,8 \times 100\% \div 100\% - 2\% = 25,306 \text{ mm (correct)}$$



The accepted sensitivity is 2 units after comma.

*Type of POM:5-11.

The cost of material POM is about 50 €/partner.

*The last meeting in Austria (FUL) was arranged before; between 5th-10th of May 2010.

The meeting finished with all the best wishes.

It was very hard to say: GOODBYE after unforgettable 5 days, but...