



Injection Molding Production Reference

Shots per Hour by Cycle Time • Grams → Pounds Conversion

Injection Machine Shots per Hour

1-30 sec		31-60 sec		61-90 sec		91-120 sec		121-150 sec		151-180 sec	
Sec	Shots/hr	Sec	Shots/hr	Sec	Shots/hr	Sec	Shots/hr	Sec	Shots/hr	Sec	Shots/hr
1	3600.0	31	116.1	61	59.0	91	39.6	121	29.8	151	23.8
2	1800.0	32	112.5	62	58.1	92	39.1	122	29.5	152	23.7
3	1200.0	33	109.1	63	57.1	93	38.7	123	29.3	153	23.5
4	900.0	34	105.9	64	56.2	94	38.3	124	29.0	154	23.4
5	720.0	35	102.9	65	55.4	95	37.9	125	28.8	155	23.2
6	600.0	36	100.0	66	54.5	96	37.5	126	28.6	156	23.1
7	514.3	37	97.3	67	53.7	97	37.1	127	28.3	157	22.9
8	450.0	38	94.7	68	52.9	98	36.7	128	28.1	158	22.8
9	400.0	39	92.3	69	52.2	99	36.4	129	27.9	159	22.6
10	360.0	40	90.0	70	51.4	100	36.0	130	27.7	160	22.5
11	327.3	41	87.8	71	50.7	101	35.6	131	27.5	161	22.4
12	300.0	42	85.7	72	50.0	102	35.3	132	27.3	162	22.2
13	276.9	43	83.7	73	49.3	103	35.0	133	27.1	163	22.1
14	257.1	44	81.8	74	48.6	104	34.6	134	26.9	164	22.0
15	240.0	45	80.0	75	48.0	105	34.3	135	26.7	165	21.8
16	225.0	46	78.3	76	47.4	106	34.0	136	26.5	166	21.7
17	211.8	47	76.6	77	46.8	107	33.6	137	26.3	167	21.6
18	200.0	48	75.0	78	46.2	108	33.3	138	26.1	168	21.4
19	189.5	49	73.5	79	45.6	109	33.0	139	25.9	169	21.3
20	180.0	50	72.0	80	45.0	110	32.7	140	25.7	170	21.2
21	171.4	51	70.6	81	44.4	111	32.4	141	25.5	171	21.1
22	163.6	52	69.2	82	43.9	112	32.1	142	25.4	172	20.9
23	156.5	53	67.9	83	43.4	113	31.9	143	25.2	173	20.8
24	150.0	54	66.7	84	42.9	114	31.6	144	25.0	174	20.7
25	144.0	55	65.5	85	42.4	115	31.3	145	24.8	175	20.6
26	138.5	56	64.3	86	41.9	116	31.0	146	24.7	176	20.5
27	133.3	57	63.2	87	41.4	117	30.8	147	24.5	177	20.3
28	128.6	58	62.1	88	40.9	118	30.5	148	24.3	178	20.2
29	124.1	59	61.0	89	40.4	119	30.3	149	24.2	179	20.1
30	120.0	60	60.0	90	40.0	120	30.0	150	24.0	180	20.0

Grams to Pounds Conversion (1-40 g)

1-10 g		11-20 g		21-30 g		31-40 g	
g	lb	g	lb	g	lb	g	lb
1	0.0022	11	0.02425	21	0.0463	31	0.06834
2	0.00441	12	0.02646	22	0.0485	32	0.07055
3	0.00661	13	0.02866	23	0.05071	33	0.07275
4	0.00882	14	0.03086	24	0.05291	34	0.07496
5	0.01102	15	0.03307	25	0.05512	35	0.07716
6	0.01323	16	0.03527	26	0.05732	36	0.07937
7	0.01543	17	0.03748	27	0.05952	37	0.08157
8	0.01764	18	0.03968	28	0.06173	38	0.08378
9	0.01984	19	0.04189	29	0.06393	39	0.08598
10	0.02205	20	0.04409	30	0.06614	40	0.08818

453.5924 grams = 1 pound