

Version No.

HUSKY BLANK FORM

| | | | |
|-----------------------------|-------------|-------------|-------------|
| Product Name | | | |
| Material Number | | | |
| Material Description | | | |
| Technician Name : | | | |
| Date Created | | | |
| Cert. Part(s) Weight (gm) : | | | |
| Standardization Info | Min. | Mid. | Max. |
| Certifield Cycle Time : | | | |
| Final Part(s) Weight (g | | | |

| | | |
|------------------------|-------------|--------------|
| Tool Number | | |
| Resin/Additive Number | | |
| Resin/Additive Descrip | | |
| Tool Cavities | | |
| | Std. | Cert. |
| Cycle Time (sec) : | | |
| Shot Weight (gm) : | | |

| | |
|--------------------|--|
| Machine Number | |
| Colorant Number | |
| Colorant Descrip | |
| Color Percentage | |
| MacGuire Setting | |
| Runner Weight (gm) | |

ALL DATA BELOW IS REFERENCE ONLY AND SETTINGS CAN BE ADJUSTED IF REQUIRED IN ORDER TO MEET PRODUCT STANDARDS

| Barrel Temperatures | Set | Mold Cooling Temps | Set | Reference Data | | | | | | |
|---------------------------|------------|-------------------------------------|-----|---|--------------|--------------|--------------|--------------|--------------|--------------|
| Nozzle Tip % | | Mold Gate Temp °F | | Fill Only Time | | | | | | |
| Nozzle Body % | | Mold Fixed ½ °F | | Fill Only Weight | | | | | | |
| Adapter 1 (EX) | | Mold Moving ½ °F | | Steel Temp. "A" Side °F | | | | | | |
| S/H Heat (EX) | | Stripper or other °F | | Steel Temp. "B" Side °F | | | | | | |
| Barrel Head (EX) | | Nozzle Tip Information | | Melt Temp. °F | | | | | | |
| Barrel Front (EX7) | | Type GP, FT, NYL | | Valve Gate | VG1 | VG2 | VG3 | VG4 | | |
| Barrel Center (EX6) | | Length OAL (in.) | | Open | | | | | | |
| Barrel Center (EX5) | | Orifice Size (in.) | | Close | | | | | | |
| Barrel Center (EX4) | | Nozzle Body Information | | PSI | | | | | | |
| Barrel Center (EX3) | | Length OAL (in.) | | Delay | | | | | | |
| Barrel Center (EX2) | | | | | | | | | | |
| Barrel Rear (EX1) | | | | | | | | | | |
| Injection Profile | Set | Recovery & Clamp Profile | | Gas Assist | C1 | C2 | C3 | C4 | | |
| Shot size in. | | Pre-Pullback mm/s | | Delay (Sec) | | | | | | |
| Injection Velocity mm/s | | Pre-Pullback Stroke m | | Hold (Sec) | | | | | | |
| Injection Velocity mm/s | | Screw Start Delay | | Exhaust (Sec) | | | | | | |
| Injection Velocity mm/s | | Screw Chg Position | | Pressure 1 (PSI) | | | | | | |
| Injection Velocity mm/s | | Screw Recovery RPM | | Time (Sec) | | | | | | |
| Injection Velocity mm/s | | Screw Recovery RPM | | Pessure 2 (PSI) | | | | | | |
| Injection Change Pos 1 | | Back Pressure 1 | | Time (Sec) | | | | | | |
| Injection Change Pos 2 | | Back Pressure 2 | | Hot Tip Controller | Box 1 | Box 2 | Box 3 | Box 4 | Box 5 | Box 6 |
| Injection Change Pos 3 | | Post Pullback mm/s | | Position 1 Gate/HB/Man | | | | | | |
| Injection Change Pos 4 | | Post Pullback Stroke | | Position 2 Gate/HB/Man | | | | | | |
| Trans Pos. mm | | Screw positon after SB | | Position 3 Gate/HB/Man | | | | | | |
| Injection Press Limit | | Screw recovery time | | Position 4 Gate/HB/Man | | | | | | |
| Inj PSI at transfer | | Cooling time secs | | Position 5 Gate/HB/Man | | | | | | |
| Injection time act. secs. | | Mold protect press | | Position 6 Gate/HB/Man | | | | | | |
| Hold Press 1 PSI | | Mold protect time | | Start-Up Instructions / Comments | | | | | | |
| Hold Press 2 PSI | | Clamp tonnage | | | | | | | | |
| Hold Press 1 secs | | Injection pressure gauge | | | | | | | | |
| Hold Press 2 secs | | Holding 1 gauge psi | | | | | | | | |
| Final Cushion mm | | Holding 2 gauge psi | | | | | | | | |
| | | Back pressure gauge psi | | | | | | | | |
| | | Back pressure gauge psi | | | | | | | | |
| | | | | | | | | | | |
| | | | | Validated by: | | | | | | |