

VALIDATING FORM

Product Name	30CWCH135
Material Number	11100
Material Description	CLEAR POLYCARB
Date Created	09/27/2018

Tool Number	GN30HCOVER#2	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :			
Final Part(s) Weight (gm)	380.090	382.0	383.910

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		Machine Number: HT45					
Nozzle Tip %		2	Mold Gate Temp °F	10	Fill Only Time						4.70	
Nozzle Body %		2	Mold Fixed ½ °F	180	Fill Only Weight						377.0	
Adapter 1 (HT1)		495	Mold Moving ½ °F	165	Steel Temp. "A" Side °F						184	
Barrel Front (HT2)		600	Stripper or other °F		Steel Temp. "B" Side °F						169	
Barrel Center (HT3)		600	Nozzle Tip Information		Melt Temp. °F						592	
Barrel Center (HT4)		600	Type GP, FT, NYL	gp	Valve Gate		VG1	VG2	VG3	VG4		
Barrel Center (HT5)		580	Length OAL (in.)	2 3/4	Open	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos			
Barrel Center (HT6)			Orifice Size (in.)	7/32	Time							
Barrel Center (HT7)			Nozzle Body Information		Pos							
Barrel Rear (HT8)			Length OAL (in.)	6.0	Close	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos			
					Time							
					Pos							
					Injection Profile		Set	Recovery & Clamp Profile		Hold	On/Off	On/Off
Shot size in.		3.80	Suckback Before Pos		Delay							
Injection Change Pos 1		3.65	Screw Start Delay		Active							
Injection Change Pos 2		2.00	Charge Position 1		0.50	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Injection Change Pos 3		1.40	Charge Position 2			Position 1 Gate/HB/Man	550					
Injection Change Pos 4			Charge Pressure 1		950	Position 2 Gate/HB/Man	510					
Injection Press 1		600	Charge Pressure 2			Position 3 Gate/HB/Man	550					
Injection Press 2		1500	Charge Flow 1		65	Position 4 Gate/HB/Man	550					
Injection Press 3		1555	Charge Flow 2		65	Position 5 Gate/HB/Man	550					
Injection Press 4		1755	Back Pressure 1		175.0	Position 6 Gate/HB/Man						
Injection Press 5			Back Pressure 2		150.0	Start-Up Instructions / Comments						
Injection Flow 1		10	Suckback After Pos		0.10							
Injection Flow 2		32	Screw Positon After SB		3.99							
Injection Flow 3		32	Screw charge Time		14.0							
Injection Flow 4		30	Cooling time secs		15.5							
Injection Flow 5			Mold protect press		700							
Inj Position threshold		0.60	Mold Protect Flow		75							
Inj Pressure threshold			Mold protect time									
InjectionTime threshold			Clamp High Press PSI		1900							
Inj PSI at transfer			Clamp High Press Flow		29							
Injection time act. secs.		4.70	Injection pressure gauge		1600							
Hold Press 1 PSI		450	Holding 1 gauge psi		750							
Hold Press 2 PSI		550	Holding 2 gauge psi		650							
Hold Flow 1		45	Back pressure gauge psi									
Hold Flow 2		45	Back pressure gauge psi									
Hold Time 1		3.00										
Hold Time 2		2.00										
Final Cushion mm		0.00										