

Version No.

CERTIFIED FORM

Product Name	25E2151
Material Number	11252
Material Description	RSN PFSG722 PP COPOLYME
Date Created	09/19/2017

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	47.50	49.0	49.00
Final Part(s) Weight (g)	772.120	776.0	779.880

Tool Number	25E2	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	20519A
Colorant Descrip	CLR CC00015250WE SFT I
Color Percentage	2.00
MacGuire Setting	2.00

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	5.90
Nozzle Body %		Mold Fixed ½ °F	90	Fill Only Weight	766.0
Adapter 1 (EX)	450	Mold Moving ½ °F	65	Steel Temp. "A" Side °F	98
S/H Heat (EX)	480	Stripper or other °F		Steel Temp. "B" Side °F	100
Barrel Head (EX)	500	Nozzle Tip Information		Melt Temp. °F	489
Barrel Front (EX7)		Type GP, FT, NYL		Valve Gate	VG1 VG2 VG3 VG4
Barrel Center (EX6)	460	Length OAL (in.)	0.00	Open	
Barrel Center (EX5)	460	Orifice Size (in.)	0.00	Close	
Barrel Center (EX4)	460	Nozzle Body Information		PSI	
Barrel Center (EX3)	460	Length OAL (in.)	0.00	Delay	
Barrel Center (EX2)	420				
Barrel Rear (EX1)	410				

Machine Number: **H604**

Injection Profile	Set	Recovery & Clamp Profile	Gas Assist	C1	C2	C3	C4			
Shot size in.	133.0	Pre-Pullback mm/s	Delay (Sec)							
Injection Velocity mm/s	25	Pre-Pullback Stroke m	Hold (Sec)							
Injection Velocity mm/s	32	Screw Start Delay	Exhaust (Sec)							
Injection Velocity mm/s	10	Screw Chg Position	50.0	Pressure 1 (PSI)						
Injection Velocity mm/s		Screw Recovery RPM	85	Time (Sec)						
Injection Velocity mm/s		Screw Recovery RPM	85	Pessure 2 (PSI)						
Injection Change Pos 1	130.0	Back Pressure 1	150.0	Time (Sec)						
Injection Change Pos 2	35.0	Back Pressure 2	150.0	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	380	450				
Injection Change Pos 4		Post Pullback Stroke	20.00	Position 2 Gate/HB/Man	380					
Trans Pos. mm	12.00	Screw positon after SB	153.00	Position 3 Gate/HB/Man	380					
Injection Press Limit	1000	Screw recovery time	18.15	Position 4 Gate/HB/Man	380					
Inj PSI at transfer	619	Cooling time secs	26.0	Position 5 Gate/HB/Man	450					
Injection time act. secs.	5.93	Mold protect press	500	Position 6 Gate/HB/Man	450					
Hold Press 1 PSI	500	Mold protect time		Start-Up Instructions / Comments						
Hold Press 2 PSI		Clamp tonnage	500							
Hold Press 1 secs	7.00	Injection pressure gauge	674							
Hold Press 2 secs		Holding 1 gauge psi	499							
Final Cushion mm	5.4	Holding 2 gauge psi								
		Back pressure gauge psi	150							
		Back pressure gauge psi	149							
				Validated by:						