

**QUALIFY FORM**

Product Name	30HPDCFA150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	06/06/2019

Tool Number	30DRAIN	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	29.10	30.6	30.60
Final Part(s) Weight (g)	177.110	178.0	178.890

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	Set	Machine Number: 41					
Nozzle Tip %	100V	Mold Gate Temp °F	260	Fill Only Time	2.95						
Nozzle Body %	100V	Mold Fixed ½ °F	260	Fill Only Weight	176.6						
Adapter (NH)	650	Mold Moving ½ °F	250	Steel Temp. "A" Side °F	293						
Barrel Front (H4)	690	Stripper or other °F		Steel Temp. "B" Side °F	267						
Barrel Center (H3)	690	Nozzle Tip Information		Melt Temp. °F	714						
Barrel Center (H2)	690	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	680	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	1/4	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	7 1/4	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	2.40	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	40.00	PrePullbck before stro		Transfer							
Injection Press 2	90.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3		Screw Chg Position 1	2.00	Position 1 Gate/HB/Man	670						
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man	670						
Injection Press 5		Screw recovery % 1	25.00	Position 3 Gate/HB/Man	690						
Injection Velocity 1	5.00	Screw recovery % 2	20.00	Position 4 Gate/HB/Man							
Injection Velocity 2	55.00	Back Pressure 1	65.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	20.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	10.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.20								
Injection Change Pos 1	2.40	Screw positon after SB	2.59	Using 100% regrind							
Injection Change Pos 2		Screw recovery time	13.98								
Injection Change Pos 3		Cooling time secs	18.00								
Injection Change Pos 4		Mold protect press	55.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	0.10	Clamp tonnage	260								
lps PSI		Injection pressure gauge	2000								
Inj PSI at transfer	2000	Holding 1 gauge psi	425								
Injection time act. secs.	2.95	Holding 2 gauge psi									
Hold Press 1 %	15	Back pressure gauge psi	320								
Hold Press 2 %		Back pressure gauge psi	200								
Hold Time 1		Final Cushion	0.09								
Hold Time 2											
Injection Hold Time	6.00										