

**VALIDATING FORM**

Product Name	NT9CP148
Material Number	11269
Material Description	RSN EXXON MOBIL 7032E2 C
Date Created	06/05/2019

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	27.60	29.1	29.10
Final Part(s) Weight (g)	160.200	161.0	161.810

Tool Number	90ZNPTTUMBLER	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

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: 314					
Nozzle Tip %	4	Mold Gate Temp °F		Fill Only Time	2.52						
Nozzle Body %	4	Mold Fixed ½ °F	80	Fill Only Weight	150.0						
Adapter (NH)	410	Mold Moving ½ °F	80	Steel Temp. "A" Side °F	80						
Barrel Front (H4)	420	Stripper or other °F		Steel Temp. "B" Side °F	80						
Barrel Center (H3)	420	Nozzle Tip Information		Melt Temp. °F	435						
Barrel Center (H2)	420	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	410	Length OAL (in.)	2-3/4	Open Delay							
		Orifice Size (in.)	1/4	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	2.90	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	50.00	PrePullbk before stro		Transfer							
Injection Press 2	60.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	40.00	Screw Chg Position 1	1.50	Position 1 Gate/HB/Man	610	580	570	580	550		
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	45.00	Position 3 Gate/HB/Man							
Injection Velocity 1	45.00	Screw recovery % 2	45.00	Position 4 Gate/HB/Man							
Injection Velocity 2	60.00	Back Pressure 1	40.00	Position 5 Gate/HB/Man							
Injection Velocity 3	35.00	Back Pressure 2	10.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	99.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.20								
Injection Change Pos 1	2.90	Screw positon after SB	3.12								
Injection Change Pos 2	0.80	Screw recovery time	8.65								
Injection Change Pos 3		Cooling time secs	16.00								
Injection Change Pos 4		Mold protect press	80.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	0.45	Clamp tonnage	300								
lps PSI		Injection pressure gauge	1200								
Inj PSI at transfer	1200	Holding 1 gauge psi	380								
Injection time act. secs.	2.52	Holding 2 gauge psi	400								
Hold Press 1 %	13	Back pressure gauge psi	160								
Hold Press 2 %	17	Back pressure gauge psi	140								
Hold Time 1	1.00	Final Cushion	0.44								
Hold Time 2											
Injection Hold Time	6.00										