

VALIDATING FORM

Product Name	1200P152
Material Number	11114K
Material Description	RSN SAN 3301 KUMHO
Date Created	07/25/2018

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	20.70	22.2	22.20
Final Part(s) Weight (g)	516.410	519.0	521.600

Tool Number	1200P#2	
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		Machine Number: H404				
Nozzle Tip %		Mold Gate Temp °F		Fill Only Time	2.37					
Nozzle Body %	20	Mold Fixed ½ °F	150	Fill Only Weight	516.0					
Adapter 1 (EX)	20	Mold Moving ½ °F	100	Steel Temp. "A" Side °F	125					
S/H Heat (EX)		Stripper or other °F		Steel Temp. "B" Side °F	110					
Barrel Head (EX)	470	Nozzle Tip Information		Melt Temp. °F	450					
Barrel Front (EX7)		Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4		
Barrel Center (EX6)		Length OAL (in.)	2 3/4	Open						
Barrel Center (EX5)	470	Orifice Size (in.)	7/32	Close						
Barrel Center (EX4)	460	Nozzle Body Information		PSI						
Barrel Center (EX3)	460	Length OAL (in.)	6.0	Delay						
Barrel Center (EX2)	450									
Barrel Rear (EX1)	440									
Injection Profile	Set	Recovery & Clamp Profile		Gas Assist	C1	C2	C3	C4		
Shot size in.	130.0	Pre-Pullback mm/s		Delay (Sec)						
Injection Velocity mm/s	35	Pre-Pullback Stroke m		Hold (Sec)						
Injection Velocity mm/s	65	Screw Start Delay		Exhaust (Sec)						
Injection Velocity mm/s	40	Screw Chg Position		Pressure 1 (PSI)						
Injection Velocity mm/s		Screw Recovery RPM	130	Time (Sec)						
Injection Velocity mm/s		Screw Recovery RPM	120	Pessure 2 (PSI)						
Injection Change Pos 1	120.0	Back Pressure 1	230.0	Time (Sec)						
Injection Change Pos 2	60.0	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	99.00	Position 1 Gate/HB/Man	520		520			
Injection Change Pos 4		Post Pullback Stroke	5.00	Position 2 Gate/HB/Man	520		520			
Trans Pos. mm		Screw positon after SB	137.20	Position 3 Gate/HB/Man	520		520			
Injection Press Limit	2000	Screw recovery time	6.20	Position 4 Gate/HB/Man	520		520			
Inj PSI at transfer	1293	Cooling time secs	9.0	Position 5 Gate/HB/Man	520		520			
Injection time act. secs.	2.37	Mold protect press	920	Position 6 Gate/HB/Man	520		520			
Hold Press 1 PSI	650	Mold protect time		Start-Up Instructions / Comments						
Hold Press 2 PSI	630	Clamp tonnage	441							
Hold Press 1 secs	2.50	Injection pressure gauge	1400							
Hold Press 2 secs	1.00	Holding 1 gauge psi	650							
Final Cushion mm	20.7	Holding 2 gauge psi	630							
		Back pressure gauge psi								
		Back pressure gauge psi								