

Version No.

VALIDATING FORM

Product Name	20E2WIP151
Material Number	11252
Material Description	RSN PFSG722 PP COPOLYME
Date Created	12/14/2017

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	49.60	51.1	51.10
Final Part(s) Weight (g)	730.330	734.0	737.670

Tool Number	20E2	
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	9.20
Nozzle Body %		Mold Fixed ½ °F	90	Fill Only Weight	699.0
Adapter 1 (EX)	440	Mold Moving ½ °F	65	Steel Temp. "A" Side °F	100
S/H Heat (EX)		Stripper or other °F		Steel Temp. "B" Side °F	90
Barrel Head (EX)	440	Nozzle Tip Information		Melt Temp. °F	468
Barrel Front (EX7)	450	Type GP, FT, NYL		Valve Gate	VG1 VG2 VG3 VG4
Barrel Center (EX6)	450	Length OAL (in.)	0.00	Open	
Barrel Center (EX5)	450	Orifice Size (in.)	0.00	Close	
Barrel Center (EX4)	440	Nozzle Body Information		PSI	
Barrel Center (EX3)	440	Length OAL (in.)	0.00	Delay	
Barrel Center (EX2)	430				
Barrel Rear (EX1)	410				

Machine Number: **H503**

Injection Profile	Set	Recovery & Clamp Profile	Gas Assist	C1	C2	C3	C4
Shot size in.	95.0	Pre-Pullback mm/s	20.00	Delay (Sec)			
Injection Velocity mm/s	15	Pre-Pullback Stroke m		Hold (Sec)			
Injection Velocity mm/s	5	Screw Start Delay		Exhaust (Sec)			
Injection Velocity mm/s		Screw Chg Position	50.0	Pressure 1 (PSI)			
Injection Velocity mm/s		Screw Recovery RPM	30	Time (Sec)			
Injection Velocity mm/s		Screw Recovery RPM	30	Pessure 2 (PSI)			
Injection Change Pos 1	25.0	Back Pressure 1	100.0	Time (Sec)			
Injection Change Pos 2		Back Pressure 2	100.0	Hot Tip Controller	Box 1	Box 2	Box 3
Injection Change Pos 3		Post Pullback mm/s	20.00	Position 1 Gate/HB/Man	360	35	
Injection Change Pos 4		Post Pullback Stroke	25.00	Position 2 Gate/HB/Man	360		
Trans Pos. mm	10.00	Screw positon after SB	118.70	Position 3 Gate/HB/Man	360		
Injection Press Limit	1000	Screw recovery time	17.35	Position 4 Gate/HB/Man	360		
Inj PSI at transfer	529	Cooling time secs	25.0	Position 5 Gate/HB/Man	450		
Injection time act. secs.	9.20	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	250				
Hold Press 1 secs	5.00	Injection pressure gauge	652				
Hold Press 2 secs		Holding 1 gauge psi	501				
Final Cushion mm	4.0	Holding 2 gauge psi					
		Back pressure gauge psi	100				
		Back pressure gauge psi	99				
				Validated by:			