

Version No.

QUALIFY FORM

Product Name	RFS2SCPP190
Material Number	11160
Material Description	RSN R12C-01 CLARFD PP
Date Created	10/23/2018

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :			
Final Part(s) Weight (g)	52.740	53.0	53.270

Tool Number	RFS2SEALCOVER	
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							
Nozzle Tip %		Mold Gate Temp °F	72	Fill Only Time	2.00	Machine Number: H301					
Nozzle Body %	10	Mold Fixed ½ °F	120	Fill Only Weight	46.7						
Adapter 1 (EX)	10	Mold Moving ½ °F	140	Steel Temp. "A" Side °F	80						
S/H Heat (EX)		Stripper or other °F		Steel Temp. "B" Side °F	100						
Barrel Head (EX)		Nozzle Tip Information		Melt Temp. °F	385						
Barrel Front (EX7)		Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4			
Barrel Center (EX6)		Length OAL (in.)	0.00	Open							
Barrel Center (EX5)		Orifice Size (in.)	0.00	Close							
Barrel Center (EX4)	380	Nozzle Body Information		PSI							
Barrel Center (EX3)	400	Length OAL (in.)	0.00	Delay							
Barrel Center (EX2)	400										
Barrel Rear (EX1)	400										
Injection Profile	Set	Recovery & Clamp Profile		Gas Assist	C1	C2	C3	C4			
Shot size in.	50.0	Pre-Pullback mm/s		Delay (Sec)							
Injection Velocity mm/s	30	Pre-Pullback Stroke m		Hold (Sec)							
Injection Velocity mm/s	30	Screw Start Delay		Exhaust (Sec)							
Injection Velocity mm/s		Screw Chg Position		Pressure 1 (PSI)							
Injection Velocity mm/s		Screw Recovery RPM	160	Time (Sec)							
Injection Velocity mm/s		Screw Recovery RPM		Pessure 2 (PSI)							
Injection Change Pos 1	48.0	Back Pressure 1	140.0	Time (Sec)							
Injection Change Pos 2	35.0	Back Pressure 2	140.0	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Change Pos 3		Post Pullback mm/s	100.00	Position 1 Gate/HB/Man	480						
Injection Change Pos 4		Post Pullback Stroke	20.00	Position 2 Gate/HB/Man							
Trans Pos. mm		Screw positon after SB	71.00	Position 3 Gate/HB/Man							
Injection Press Limit	2000	Screw recovery time	2.50	Position 4 Gate/HB/Man							
Inj PSI at transfer	1351	Cooling time secs		Position 5 Gate/HB/Man							
Injection time act. secs.	10.00	Mold protect press	200	Position 6 Gate/HB/Man							
Hold Press 1 PSI	560	Mold protect time		Start-Up Instructions / Comments							
Hold Press 2 PSI	450	Clamp tonnage	300								
Hold Press 1 secs	3.00	Injection pressure gauge	1396								
Hold Press 2 secs	3.00	Holding 1 gauge psi	560								
Final Cushion mm	24.0	Holding 2 gauge psi	450								
		Back pressure gauge psi									
		Back pressure gauge psi									
Validated by:											