

Version No.

**QUALIFY FORM**

Product Name	IBS20FRAMEWIP
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	08/11/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	60.00	61.5	61.50
Final Part(s) Weight (g)	443.770	446.0	448.230

Tool Number	IBS20/27LIDFRM	
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: 715					
Nozzle Tip %	10	Mold Gate Temp °F		Fill Only Time	3.30						
Nozzle Body %	10	Mold Fixed ½ °F	180	Fill Only Weight	439.0						
Adapter (NH)	480	Mold Moving ½ °F	160	Steel Temp. "A" Side °F	189						
Barrel Front (H4)	630	Stripper or other °F		Steel Temp. "B" Side °F	166						
Barrel Center (H3)	630	Nozzle Tip Information		Melt Temp. °F	620						
Barrel Center (H2)	630	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	600	Length OAL (in.)	3 3/4	Open Delay							
		Orifice Size (in.)	3/16	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6.0	Close Delay							
		Injection Profile		Set	Recovery & Clamp Profile		Close Time				
Shot size in.	3.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	50.00	PrePullbk before stro		Transfer							
Injection Press 2	70.00	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							
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	35.00	Position 3 Gate/HB/Man							
Injection Velocity 1	2.00	Screw recovery % 2		Position 4 Gate/HB/Man							
Injection Velocity 2	50.00	Back Pressure 1	50.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2		Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	70.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.28								
Injection Change Pos 1	3.00	Screw positon after SB	3.34								
Injection Change Pos 2		Screw recovery time	14.00								
Injection Change Pos 3		Cooling time secs	40.00								
Injection Change Pos 4		Mold protect press	85.00								
Trans mode lvsh/lps	IVSH	Mold protect time	6.00								
Trans pos in.	0.35	Clamp tonnage	700								
lps PSI		Injection pressure gauge	1650								
Inj PSI at transfer	1600	Holding 1 gauge psi	450								
Injection time act. secs.	3.33	Holding 2 gauge psi	400								
Hold Press 1 %	15	Back pressure gauge psi	300								
Hold Press 2 %	30	Back pressure gauge psi	300								
Hold Time 1	1.00	Final Cushion	0.01								
Hold Time 2											
Injection Hold Time	10.00										
											Validated by:

Validated by: