

Version No.

VALIDATING FORM

Product Name	1007CW152
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	11/08/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	32.50	34.0	34.00
Final Part(s) Weight (g)	275.520	276.9	278.290

Tool Number	1007CC	
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: 46					
Nozzle Tip %	10	Mold Gate Temp °F		Fill Only Time	2.83						
Nozzle Body %	10	Mold Fixed ½ °F	180	Fill Only Weight	270.0						
Adapter (NH)	600	Mold Moving ½ °F	170	Steel Temp. "A" Side °F	184						
Barrel Front (H4)	620	Stripper or other °F		Steel Temp. "B" Side °F	178						
Barrel Center (H3)	620	Nozzle Tip Information		Melt Temp. °F	653	VG2	VG3	VG4			
Barrel Center (H2)	620	Type GP, FT, NYL	GP	Valve Gate	VG1						
Barrel Rear (H1)	600	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	3/16	Open Time							
		Nozzle Body Information		Adv Cls Tm		Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
		Length OAL (in.)	6.00	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	3.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	60.00	PrePullbk before stro		Transfer							
Injection Press 2	80.00	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	2.50	Position 1 Gate/HB/Man							
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	15.00	Screw recovery % 2	40.00	Position 4 Gate/HB/Man							
Injection Velocity 2	45.00	Back Pressure 1	70.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	36.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	45.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.22								
Injection Change Pos 1	2.90	Screw positon after SB	3.22								
Injection Change Pos 2		Screw recovery time	8.57								
Injection Change Pos 3		Cooling time secs	20.00								
Injection Change Pos 4		Mold protect press	20.00								
Trans mode lvsh/lps	IVSH	Mold protect time	3.00								
Trans pos in.	0.30	Clamp tonnage	380								
lps PSI		Injection pressure gauge									
Inj PSI at transfer	1200	Holding 1 gauge psi									
Injection time act. secs.	2.83	Holding 2 gauge psi									
Hold Press 1 %	35	Back pressure gauge psi	280								
Hold Press 2 %	30	Back pressure gauge psi	190								
Hold Time 1	1.00	Final Cushion	0.15								
Hold Time 2											
Injection Hold Time	10.00										

Validated by: