

Version No.

**VALIDATING FORM**

Product Name	42HP150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	09/11/2017

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (g)	222.380	223.5	224.620

Tool Number	GN42PAN	
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: 314					
Nozzle Tip %	20	Mold Gate Temp °F	220	Fill Only Time	3.29						
Nozzle Body %	30	Mold Fixed ½ °F	310	Fill Only Weight	223.5						
Adapter (NH)	680	Mold Moving ½ °F	260	Steel Temp. "A" Side °F	163						
Barrel Front (H4)	710	Stripper or other °F		Steel Temp. "B" Side °F	148	VG2	VG3	VG4			
Barrel Center (H3)	730	Nozzle Tip Information		Melt Temp. °F	660						
Barrel Center (H2)	730	Type GP, FT, NYL	gp	Valve Gate	VG1						
Barrel Rear (H1)	710	Length OAL (in.)	2 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.	2.80	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	30.00	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	2.00	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	10.00	Screw recovery % 2	35.00	Position 4 Gate/HB/Man							
Injection Velocity 2	60.00	Back Pressure 1	40.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	15.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	20.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.16	MILL PRESS NEEDED							
Injection Change Pos 1	2.70	Screw positon after SB	2.97								
Injection Change Pos 2		Screw recovery time	8.88								
Injection Change Pos 3		Cooling time secs	18.00								
Injection Change Pos 4		Mold protect press	40.00								
Trans mode lvsh/lps		Mold protect time	6.00								
Trans pos in.	0.27	Clamp tonnage	300								
lps PSI		Injection pressure gauge	1864								
Inj PSI at transfer		Holding 1 gauge psi	200								
Injection time act. secs.	3.29	Holding 2 gauge psi	150								
Hold Press 1 %	10	Back pressure gauge psi	150	Validated by:							
Hold Press 2 %	5	Back pressure gauge psi	120								
Hold Time 1	1.00	Final Cushion	0.27								
Hold Time 2											
Injection Hold Time	7.00										