

VALIDATING FORM

Product Name	30HPD150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	05/22/2019

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	23.00	24.5	24.50
Final Part(s) Weight (g)	190.050	191.0	191.960

Tool Number	30DRAIN	
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: 48					
Nozzle Tip %	45	Mold Gate Temp °F	300	Fill Only Time	3.10						
Nozzle Body %	90	Mold Fixed ½ °F	300	Fill Only Weight	188.0						
Adapter (NH)	650	Mold Moving ½ °F	250	Steel Temp. "A" Side °F	300						
Barrel Front (H4)	690	Stripper or other °F		Steel Temp. "B" Side °F	265						
Barrel Center (H3)	690	Nozzle Tip Information		Melt Temp. °F	764						
Barrel Center (H2)	690	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	680	Length OAL (in.)	2	Open Delay							
		Orifice Size (in.)	1/4	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	2.55	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	40.00	PrePullbck before stro		Transfer							
Injection Press 2	90.00	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		Position 1 Gate/HB/Man	660	670	690				
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1		Position 3 Gate/HB/Man							
Injection Velocity 1	5.00	Screw recovery % 2		Position 4 Gate/HB/Man							
Injection Velocity 2	45.00	Back Pressure 1		Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2		Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed		Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.									
Injection Change Pos 1	2.50	Screw positon after SB		Using 100% regrind, parameters may change with virgin only.							
Injection Change Pos 2		Screw recovery time									
Injection Change Pos 3		Cooling time secs									
Injection Change Pos 4		Mold protect press									
Trans mode lvsh/lps	lvsh	Mold protect time									
Trans pos in.	0.15	Clamp tonnage									
lps PSI	1900	Injection pressure gauge									
Inj PSI at transfer	1900	Holding 1 gauge psi									
Injection time act. secs.	3.10	Holding 2 gauge psi									
Hold Press 1 %	500	Back pressure gauge psi									
Hold Press 2 %		Back pressure gauge psi									
Hold Time 1		Final Cushion									
Hold Time 2											
Injection Hold Time	6.00										