

Version No.

VALIDATING FORM

Product Name	1014FF168
Material Number	11250
Material Description	RSN CP360H POLYPROPYLENE
Date Created	02/14/2018

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	26.40	27.9	27.90
Final Part(s) Weight (g)	473.620	476.0	478.380

Tool Number	1014FFSTACK	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	2.00

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		Fill Only Time	4.00
Nozzle Body %		Mold Fixed ½ °F	65	Fill Only Weight	438.0
Adapter 1 (EX)	420	Mold Moving ½ °F	65	Steel Temp. "A" Side °F	73
S/H Heat (EX)	420	Stripper or other °F		Steel Temp. "B" Side °F	91
Barrel Head (EX)	400	Nozzle Tip Information		Melt Temp. °F	419
Barrel Front (EX7)	400	Type GP, FT, NYL		Valve Gate	VG1 VG2 VG3 VG4
Barrel Center (EX6)	400	Length OAL (in.)	0.00	Open	135.0 135.0
Barrel Center (EX5)	400	Orifice Size (in.)	0.00	Close	
Barrel Center (EX4)	395	Nozzle Body Information		PSI	120 120
Barrel Center (EX3)	390	Length OAL (in.)	0.00	Delay	
Barrel Center (EX2)	385				
Barrel Rear (EX1)	380				

Machine Number: H401

Injection Profile	Set	Recovery & Clamp Profile	Gas Assist	C1	C2	C3	C4		
Shot size in.	95.0	Pre-Pullback mm/s		Delay (Sec)					
Injection Velocity mm/s	75	Pre-Pullback Stroke m	3.00	Hold (Sec)					
Injection Velocity mm/s	35	Screw Start Delay	2.00	Exhaust (Sec)					
Injection Velocity mm/s	6	Screw Chg Position	50.0	Pressure 1 (PSI)					
Injection Velocity mm/s		Screw Recovery RPM	100	Time (Sec)					
Injection Velocity mm/s		Screw Recovery RPM	100	Pessure 2 (PSI)					
Injection Change Pos 1	85.0	Back Pressure 1	250.0	Time (Sec)					
Injection Change Pos 2	25.0	Back Pressure 2	250.0	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5 Box 6
Injection Change Pos 3		Post Pullback mm/s		Position 1 Gate/HB/Man	500	550			
Injection Change Pos 4		Post Pullback Stroke		Position 2 Gate/HB/Man	500	550			
Trans Pos. mm	15.00	Screw positon after SB	103.00	Position 3 Gate/HB/Man	500				
Injection Press Limit	2600	Screw recovery time	9.39	Position 4 Gate/HB/Man	500				
Inj PSI at transfer	1048	Cooling time secs	14.0	Position 5 Gate/HB/Man	500				
Injection time act. secs.	3.99	Mold protect press	1800	Position 6 Gate/HB/Man					
Hold Press 1 PSI	900	Mold protect time		Start-Up Instructions / Comments					
Hold Press 2 PSI	1000	Clamp tonnage	400						
Hold Press 1 secs	3.00	Injection pressure gauge	2030						
Hold Press 2 secs	3.00	Holding 1 gauge psi	903						
Final Cushion mm	6.0	Holding 2 gauge psi	1001						
		Back pressure gauge psi	249						
		Back pressure gauge psi	253						
				Validated by:					