

**VALIDATING FORM**

Product Name	22HPTBH1150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	06/05/2019

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	31.50	33.0	33.00
Final Part(s) Weight (g)	386.060	388.0	389.940

Tool Number	22HPTBH	
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: 47					
Nozzle Tip %	100	Mold Gate Temp °F	200	Fill Only Time	2.96						
Nozzle Body %	100	Mold Fixed ½ °F	300	Fill Only Weight	377.0						
Adapter (NH)	650	Mold Moving ½ °F	280	Steel Temp. "A" Side °F	280						
Barrel Front (H4)	700	Stripper or other °F		Steel Temp. "B" Side °F	315						
Barrel Center (H3)	700	Nozzle Tip Information		Melt Temp. °F	745						
Barrel Center (H2)	700	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	680	Length OAL (in.)	2 3/4	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.	4.20	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	40.00	PrePullbk 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	4.00	Position 1 Gate/HB/Man							
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	50.00	Position 3 Gate/HB/Man							
Injection Velocity 1	5.00	Screw recovery % 2	40.00	Position 4 Gate/HB/Man							
Injection Velocity 2	60.00	Back Pressure 1	60.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	60.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	99.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.25								
Injection Change Pos 1	4.15	Screw positon after SB	4.61								
Injection Change Pos 2		Screw recovery time	12.22								
Injection Change Pos 3		Cooling time secs	18.00								
Injection Change Pos 4		Mold protect press	70.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	0.20	Clamp tonnage	260								
lps PSI		Injection pressure gauge	2000								
Inj PSI at transfer	2000	Holding 1 gauge psi	750								
Injection time act. secs.	2.96	Holding 2 gauge psi	700								
Hold Press 1 %	25	Back pressure gauge psi	350								
Hold Press 2 %	20	Back pressure gauge psi	150								
Hold Time 1		Final Cushion	0.11								
Hold Time 2											
Injection Hold Time	10.00										