

Version No.

**QUALIFY FORM**

Product Name	<b>64CW110</b>
Material Number	<b>11100</b>
Material Description	<b>CLEAR POLYCARB</b>
Date Created	<b>10/03/2017</b>

Tool Number	<b>GN64PAN</b>
Resin/Additive Number	
Resin/Additive Descrip	
	<b>Std.</b>
	<b>Cert.</b>

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

<b>Standardization Info</b>	<b>Min.</b>	<b>Mid.</b>	<b>Max.</b>
Certified Cycle Time :			
Final Part(s) Weight (g)	<b>335.710</b>	<b>337.4</b>	<b>339.090</b>

**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: 413					
Nozzle Tip %	3	Mold Gate Temp °F	120	Fill Only Time	1.60						
Nozzle Body %	3	Mold Fixed ½ °F	170	Fill Only Weight	332.8						
Adapter (NH)	OFF	Mold Moving ½ °F	160	Steel Temp. "A" Side °F	177						
Barrel Front (H4)	590	Stripper or other °F		Steel Temp. "B" Side °F	167						
Barrel Center (H3)	610	Nozzle Tip Information		Melt Temp. °F	595						
Barrel Center (H2)	610	Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	590	Length OAL (in.)	0.00	Open Delay							
		Orifice Size (in.)	0.00	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	0.00	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	3.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	8000.00	PrePullbck before stro		Transfer							
Injection Press 2	21000.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	21000.00	Screw Chg Position 1		Position 1 Gate/HB/Man	550	530	600				
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	0.80	Screw recovery % 2		Position 4 Gate/HB/Man							
Injection Velocity 2	2.00	Back Pressure 1		Position 5 Gate/HB/Man							
Injection Velocity 3	2.00	Back Pressure 2		Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed		Start-Up Instructions / Comments  USING I.P.S. SET @ 22500 TRANSFERRING TO HOLDING AT 0.381 CAN #2 FILLS EASIER							
Injection Velocity 5		Post Pullback stroke in.									
Injection Change Pos 1	3.25	Screw positon after SB									
Injection Change Pos 2	1.00	Screw recovery time									
Injection Change Pos 3		Cooling time secs									
Injection Change Pos 4		Mold protect press									
Trans mode lvsh/lps	IPS - 2200	Mold protect time									
Trans pos in.	0.50	Clamp tonnage									
lps PSI		Injection pressure gauge									
Inj PSI at transfer	22480	Holding 1 gauge psi									
Injection time act. secs.	1.78	Holding 2 gauge psi									
Hold Press 1 %	9000	Back pressure gauge psi									
Hold Press 2 %	8000	Back pressure gauge psi									
Hold Time 1	2.00	Final Cushion									
Hold Time 2	2.00										
Injection Hold Time	5.80										
				Validated by:							