

QUALIFY FORM

Product Name	TG6148
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	07/20/2017

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (g)	0.020	0.0	0.020

Tool Number	TONG	
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: 411				
Nozzle Tip %	N/A	Mold Gate Temp °F		Fill Only Time	1.90					
Nozzle Body %	100	Mold Fixed ½ °F	160	Fill Only Weight	0.1					
Adapter (NH)	440	Mold Moving ½ °F	140	Steel Temp. "A" Side °F	138					
Barrel Front (H4)	580	Stripper or other °F		Steel Temp. "B" Side °F	135					
Barrel Center (H3)	580	Nozzle Tip Information		Melt Temp. °F	518					
Barrel Center (H2)	580	Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4		
Barrel Rear (H1)	580	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.	2.00	PrePullbk(PB2)speed		Inj HP End						
Injection Press 1	25.00	PrePullbck before stro		Transfer						
Injection Press 2	55.00	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		1.00	Position 1 Gate/HB/Man					
Injection Press 4		Screw Chg Position 2			Position 2 Gate/HB/Man					
Injection Press 5		Screw recovery % 1		30.00	Position 3 Gate/HB/Man					
Injection Velocity 1	8.00	Screw recovery % 2		30.00	Position 4 Gate/HB/Man					
Injection Velocity 2	25.00	Back Pressure 1		50.00	Position 5 Gate/HB/Man					
Injection Velocity 3		Back Pressure 2		50.00	Position 6 Gate/HB/Man					
Injection Velocity 4		PostPullback(PB1)speed		55.00	Start-Up Instructions / Comments COLOR METER SET AT 002					
Injection Velocity 5		Post Pullback stroke in.								
Injection Change Pos 1	1.86	Screw positon after SB		2.23						
Injection Change Pos 2	1.35	Screw recovery time		2.07						
Injection Change Pos 3		Cooling time secs		14.50						
Injection Change Pos 4		Mold protect press		80.00						
Trans mode lvsh/lps	IVSH	Mold protect time		2.06						
Trans pos in.	1.35	Clamp tonnage		385						
lps PSI		Injection pressure gauge		1200						
Inj PSI at transfer		Holding 1 gauge psi		900						
Injection time act. secs.	2.29	Holding 2 gauge psi		500						
Hold Press 1 %	40	Back pressure gauge psi		220						
Hold Press 2 %	20	Back pressure gauge psi		100						
Hold Time 1	3.00	Final Cushion		1.20						
Hold Time 2										
Injection Hold Time	10.00									