

**VALIDATING FORM**

Product Name	18269P148
Material Number	11187
Material Description	RSN 6719 HDPE (INJ/MTC)
Date Created	06/04/2019

Tool Number	18269CB	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	85.50	87.0	87.00
Final Part(s) Weight (g)	2210.890	2222.0	2233.110

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: 154							
Nozzle Tip %	100	Mold Gate Temp °F		Fill Only Time	7.84								
Nozzle Body %	100	Mold Fixed ½ °F	50	Fill Only Weight	2218.0								
Adapter (NH)	300	Mold Moving ½ °F	120	Steel Temp. "A" Side °F	88								
Barrel Front (H4)	440	Stripper or other °F	160	Steel Temp. "B" Side °F	145								
Barrel Center (H3)	440	Nozzle Tip Information		Melt Temp. °F	450								
Barrel Center (H2)	420	Type GP, FT, NYL	GP	Valve Gate	VG1						VG2	VG3	VG4
Barrel Rear (H1)	400	Length OAL (in.)	3-3/4	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.	9.00	PrePullbk(PB2)speed		Inj HP End									
Injection Press 1	40.00	PrePullbck before stro		Transfer									
Injection Press 2	60.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6			
Injection Press 3	65.00	Screw Chg Position 1		6.00	Position 1 Gate/HB/Man								
Injection Press 4		Screw Chg Position 2			Position 2 Gate/HB/Man								
Injection Press 5		Screw recovery % 1		42.00	Position 3 Gate/HB/Man								
Injection Velocity 1	22.00	Screw recovery % 2		40.00	Position 4 Gate/HB/Man								
Injection Velocity 2	50.00	Back Pressure 1		20.00	Position 5 Gate/HB/Man								
Injection Velocity 3	40.00	Back Pressure 2		15.00	Position 6 Gate/HB/Man								
Injection Velocity 4		PostPullback(PB1)speed		60.00	Start-Up Instructions / Comments								
Injection Velocity 5		Post Pullback stroke in.		0.50									
Injection Change Pos 1	9.00	Screw positon after SB		9.54									
Injection Change Pos 2	7.00	Screw recovery time		45.36									
Injection Change Pos 3		Cooling time secs		48.00									
Injection Change Pos 4		Mold protect press		90.00									
Trans mode lvsh/lps	IVSH	Mold protect time		6.00									
Trans pos in.	0.90	Clamp tonnage		1300									
lps PSI	1000	Injection pressure gauge		1000									
Inj PSI at transfer	1000	Holding 1 gauge psi		400									
Injection time act. secs.	7.84	Holding 2 gauge psi		300									
Hold Press 1 %	20	Back pressure gauge psi		150									
Hold Press 2 %	15	Back pressure gauge psi		100									
Hold Time 1		Final Cushion		0.35									
Hold Time 2													
Injection Hold Time	18.00												