

**VALIDATING FORM**

|                      |                           |
|----------------------|---------------------------|
| Product Name         | 182612CW135               |
| Material Number      | 11100                     |
| Material Description | RSN CLR MKRN 2856-550042/ |
| Date Created         | 05/29/2018                |

|                        |          |       |
|------------------------|----------|-------|
| Tool Number            | 182612CB |       |
| Resin/Additive Number  |          |       |
| Resin/Additive Descrip |          |       |
|                        |          |       |
|                        | Std.     | Cert. |
|                        |          |       |
|                        |          |       |

|                  |  |
|------------------|--|
| Colorant Number  |  |
| Colorant Descrip |  |
| Color Percentage |  |
| MacGuire Setting |  |

| Standardization Info      | Min.     | Mid.   | Max.     |
|---------------------------|----------|--------|----------|
| Certifield Cycle Time :   | 69.50    | 71.0   | 71.00    |
| Final Part(s) Weight (gm) | 3467.580 | 3485.0 | 3502.430 |

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          |                                  | Machine Number: HT1504 |        |        |       |       |       |
|---------------------------|--|-------|--------------------------|-------|-------------------------|----------------------------------|------------------------|--------|--------|-------|-------|-------|
| Nozzle Tip %              |  | 120   | Mold Gate Temp °F        |       | Fill Only Time          | 7.80                             |                        |        |        |       |       |       |
| Nozzle Body %             |  | 120   | Mold Fixed ½ °F          | 185   | Fill Only Weight        | 3450.0                           |                        |        |        |       |       |       |
| Adapter 1 (HT1)           |  |       | Mold Moving ½ °F         | 180   | Steel Temp. "A" Side °F | 172                              |                        |        |        |       |       |       |
| Barrel Front (HT2)        |  | 580   | Stripper or other °F     |       | Steel Temp. "B" Side °F | 168                              |                        |        |        |       |       |       |
| Barrel Center (HT3)       |  | 630   | Nozzle Tip Information   |       | Melt Temp. °F           | 595                              |                        |        |        |       |       |       |
| Barrel Center (HT4)       |  | 655   | Type GP, FT, NYL         | gp    | Valve Gate              | VG1                              | VG2                    | VG3    | VG4    |       |       |       |
| Barrel Center (HT5)       |  | 655   | Length OAL (in.)         | 3 3/4 | Open                    | Tm/Pos                           | Tm/Pos                 | Tm/Pos | Tm/Pos |       |       |       |
| Barrel Center (HT6)       |  | 655   | Orifice Size (in.)       | 1/4   | Time                    |                                  |                        |        |        |       |       |       |
| Barrel Center (HT7)       |  | 655   | Nozzle Body Information  |       | Pos                     |                                  |                        |        |        |       |       |       |
| Barrel Rear (HT8)         |  | 640   | Length OAL (in.)         | 6.0   | Close                   | Tm/Pos                           | Tm/Pos                 | Tm/Pos | Tm/Pos |       |       |       |
|                           |  |       |                          |       | Time                    |                                  |                        |        |        |       |       |       |
|                           |  |       |                          |       | Pos                     |                                  |                        |        |        |       |       |       |
| Injection Profile         |  | Set   | Recovery & Clamp Profile |       | Hold                    | On/Off                           | On/Off                 | On/Off | On/Off |       |       |       |
| Shot size in.             |  | 10.15 | Suckback Before Pos      |       | Delay                   |                                  |                        |        |        |       |       |       |
| Injection Change Pos 1    |  | 10.00 | Screw Start Delay        |       | Active                  |                                  |                        |        |        |       |       |       |
| Injection Change Pos 2    |  | 20.00 | Charge Position 1        |       | 9.00                    | Hot Tip Controller               | Box 1                  | Box 2  | Box 3  | Box 4 | Box 5 | Box 6 |
| Injection Change Pos 3    |  |       | Charge Position 2        |       |                         | Position 1 Gate/HB/Man           |                        |        |        |       |       |       |
| Injection Change Pos 4    |  |       | Charge Pressure 1        |       | 1600                    | Position 2 Gate/HB/Man           |                        |        |        |       |       |       |
| Injection Press 1         |  | 2000  | Charge Pressure 2        |       | 1600                    | Position 3 Gate/HB/Man           |                        |        |        |       |       |       |
| Injection Press 2         |  | 2530  | Charge Flow 1            |       | 70                      | Position 4 Gate/HB/Man           |                        |        |        |       |       |       |
| Injection Press 3         |  | 2050  | Charge Flow 2            |       | 60                      | Position 5 Gate/HB/Man           |                        |        |        |       |       |       |
| Injection Press 4         |  |       | Back Pressure 1          |       | 150.0                   | Position 6 Gate/HB/Man           |                        |        |        |       |       |       |
| Injection Press 5         |  |       | Back Pressure 2          |       | 50.0                    | Start-Up Instructions / Comments |                        |        |        |       |       |       |
| Injection Flow 1          |  | 30    | Suckback After Pos       |       | 0.60                    |                                  |                        |        |        |       |       |       |
| Injection Flow 2          |  | 46    | Screw Positon After SB   |       | 10.15                   |                                  |                        |        |        |       |       |       |
| Injection Flow 3          |  | 16    | Screw charge Time        |       | 22.3                    |                                  |                        |        |        |       |       |       |
| Injection Flow 4          |  |       | Cooling time secs        |       | 35.0                    |                                  |                        |        |        |       |       |       |
| Injection Flow 5          |  |       | Mold protect press       |       | 700                     |                                  |                        |        |        |       |       |       |
| Inj Position threshold    |  | 0.90  | Mold Protect Flow        |       | 15                      |                                  |                        |        |        |       |       |       |
| Inj Pressure threshold    |  |       | Mold protect time        |       |                         |                                  |                        |        |        |       |       |       |
| InjectionTime threshold   |  |       | Clamp High Press PSI     |       | 2500                    |                                  |                        |        |        |       |       |       |
| Inj PSI at transfer       |  |       | Clamp High Press Flow    |       | 20                      |                                  |                        |        |        |       |       |       |
| Injection time act. secs. |  | 16.80 | Injection pressure gauge |       |                         |                                  |                        |        |        |       |       |       |
| Hold Press 1 PSI          |  | 500   | Holding 1 gauge psi      |       |                         |                                  |                        |        |        |       |       |       |
| Hold Press 2 PSI          |  | 400   | Holding 2 gauge psi      |       |                         |                                  |                        |        |        |       |       |       |
| Hold Flow 1               |  | 35    | Back pressure gauge psi  |       |                         |                                  |                        |        |        |       |       |       |
| Hold Flow 2               |  | 35    | Back pressure gauge psi  |       |                         |                                  |                        |        |        |       |       |       |
| Hold Time 1               |  | 5.00  |                          |       |                         |                                  |                        |        |        |       |       |       |
| Hold Time 2               |  | 4.00  |                          |       |                         |                                  |                        |        |        |       |       |       |
| Final Cushion mm          |  | 0.00  |                          |       |                         |                                  |                        |        |        |       |       |       |