

Version No.

VALIDATING FORM

Product Name	24CW135
Material Number	11100
Material Description	CLEAR POLYCARB
Date Created	03/08/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (g)	974.110	979.0	983.900

Tool Number	GN24PAN	
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: 712					
Nozzle Tip %	30	Mold Gate Temp °F	150	Fill Only Time	6.51						
Nozzle Body %	10	Mold Fixed ½ °F	190	Fill Only Weight	887.0						
Adapter (NH)	550	Mold Moving ½ °F	190	Steel Temp. "A" Side °F	200						
Barrel Front (H4)	660	Stripper or other °F		Steel Temp. "B" Side °F	200						
Barrel Center (H3)	650	Nozzle Tip Information		Melt Temp. °F	673						
Barrel Center (H2)	650	Type GP, FT, NYL	gp	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	600	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	7/32	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6.0	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	4.80	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	35.00	PrePullbk before stro		Transfer							
Injection Press 2	95.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	80.00	Screw Chg Position 1	4.00	Position 1 Gate/HB/Man	400	550	400	550	530		
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	35.00	Position 3 Gate/HB/Man							
Injection Velocity 1	15.00	Screw recovery % 2	35.00	Position 4 Gate/HB/Man							
Injection Velocity 2	95.00	Back Pressure 1	90.00	Position 5 Gate/HB/Man							
Injection Velocity 3	90.00	Back Pressure 2	25.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	30.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.35								
Injection Change Pos 1	4.70	Screw positon after SB	5.23								
Injection Change Pos 2	0.80	Screw recovery time	12.41								
Injection Change Pos 3		Cooling time secs	18.00								
Injection Change Pos 4		Mold protect press	99.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	0.40	Clamp tonnage	700								
lps PSI		Injection pressure gauge									
Inj PSI at transfer	1970	Holding 1 gauge psi	360								
Injection time act. secs.	6.51	Holding 2 gauge psi									
Hold Press 1 %	15	Back pressure gauge psi									
Hold Press 2 %		Back pressure gauge psi									
Hold Time 1		Final Cushion	0.36								
Hold Time 2											
Injection Hold Time	10.00										

Validated by: