

VALIDATING FORM

Product Name	1216CW110
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	04/26/2018

Tool Number	1216TRAY	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	51.40	52.9	52.90
Final Part(s) Weight (g	575.110	578.0	580.890

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	
Nozzle Tip %		Mold Gate Temp °F	tower	Fill Only Time	4.45
Nozzle Body %	25	Mold Fixed ½ °F	150	Fill Only Weight	515.0
Adapter 1 (EX)	25	Mold Moving ½ °F	85	Steel Temp. "A" Side °F	149
S/H Heat (EX)		Stripper or other °F		Steel Temp. "B" Side °F	115
Barrel Head (EX)	580	Nozzle Tip Information		Melt Temp. °F	612
Barrel Front (EX7)	600	Type GP, FT, NYL	GP	Valve Gate	VG1 VG2 VG3 VG4
Barrel Center (EX6)	600	Length OAL (in.)	2 3/4	Open	
Barrel Center (EX5)	600	Orifice Size (in.)	1/4	Close	
Barrel Center (EX4)	600	Nozzle Body Information		PSI	
Barrel Center (EX3)	600	Length OAL (in.)	6.0	Delay	
Barrel Center (EX2)	600				
Barrel Rear (EX1)	580				

Machine Number: **H407**

Injection Profile	Set	Recovery & Clamp Profile	Gas Assist	C1	C2	C3	C4			
Shot size in.	108.0	Pre-Pullback mm/s		Delay (Sec)						
Injection Velocity mm/s	8	Pre-Pullback Stroke m		Hold (Sec)						
Injection Velocity mm/s	22	Screw Start Delay		Exhaust (Sec)						
Injection Velocity mm/s	18	Screw Chg Position	103.0	Pressure 1 (PSI)						
Injection Velocity mm/s		Screw Recovery RPM	100	Time (Sec)						
Injection Velocity mm/s		Screw Recovery RPM	100	Pessure 2 (PSI)						
Injection Change Pos 1	108.0	Back Pressure 1	250.0	Time (Sec)						
Injection Change Pos 2	40.0	Back Pressure 2	10.0	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Injection Change Pos 3		Post Pullback mm/s		Position 1 Gate/HB/Man	460					
Injection Change Pos 4		Post Pullback Stroke		Position 2 Gate/HB/Man						
Trans Pos. mm	10.00	Screw positon after SB	108.90	Position 3 Gate/HB/Man						
Injection Press Limit		Screw recovery time	13.10	Position 4 Gate/HB/Man						
Inj PSI at transfer		Cooling time secs	30.0	Position 5 Gate/HB/Man						
Injection time act. secs.	1202.00	Mold protect press	2000	Position 6 Gate/HB/Man						
Hold Press 1 PSI	500	Mold protect time		Start-Up Instructions / Comments						
Hold Press 2 PSI	380	Clamp tonnage	317							
Hold Press 1 secs	4.00	Injection pressure gauge								
Hold Press 2 secs	6.00	Holding 1 gauge psi	500							
Final Cushion mm	7.1	Holding 2 gauge psi	380							
		Back pressure gauge psi								
		Back pressure gauge psi								