

Version No.

**CERTIFIED FORM**

Product Name	PR314151
Material Number	11252
Material Description	RSN PFSG722 PP COPOLYME
Date Created	08/22/2017

Tool Number	PR314	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	2.00

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	63.00	64.5	64.50
Final Part(s) Weight (g)	1836.770	1846.0	1855.230

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 %	40	Mold Gate Temp °F	100	Fill Only Time	10.20
Nozzle Body %		Mold Fixed ½ °F	100	Fill Only Weight	1788.0
Adapter 1 (EX)	420	Mold Moving ½ °F	65	Steel Temp. "A" Side °F	125
S/H Heat (EX)	450	Stripper or other °F		Steel Temp. "B" Side °F	116
Barrel Head (EX)	450	Nozzle Tip Information		Melt Temp. °F	461
Barrel Front (EX7)		Type GP, FT, NYL		Valve Gate	VG1 VG2 VG3 VG4
Barrel Center (EX6)	450	Length OAL (in.)	0.00	Open	
Barrel Center (EX5)	450	Orifice Size (in.)	0.00	Close	
Barrel Center (EX4)	450	Nozzle Body Information		PSI	
Barrel Center (EX3)	375	Length OAL (in.)	0.00	Delay	
Barrel Center (EX2)	370				
Barrel Rear (EX1)	370				

Machine Number: **H603**

Injection Profile	Set	Recovery & Clamp Profile	Gas Assist	C1	C2	C3	C4			
Shot size in.	308.0	Pre-Pullback mm/s	Delay (Sec)							
Injection Velocity mm/s	25	Pre-Pullback Stroke m	Hold (Sec)							
Injection Velocity mm/s	35	Screw Start Delay	Exhaust (Sec)							
Injection Velocity mm/s	15	Screw Chg Position	140.0	Pressure 1 (PSI)						
Injection Velocity mm/s		Screw Recovery RPM	140	Time (Sec)						
Injection Velocity mm/s		Screw Recovery RPM	140	Pessure 2 (PSI)						
Injection Change Pos 1	285.0	Back Pressure 1	155.0	Time (Sec)						
Injection Change Pos 2	35.0	Back Pressure 2	155.0	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	450	450				
Injection Change Pos 4		Post Pullback Stroke	15.00	Position 2 Gate/HB/Man	450					
Trans Pos. mm	15.00	Screw positon after SB	323.10	Position 3 Gate/HB/Man	450					
Injection Press Limit	1600	Screw recovery time	25.80	Position 4 Gate/HB/Man	450					
Inj PSI at transfer	902	Cooling time secs	35.0	Position 5 Gate/HB/Man	450					
Injection time act. secs.	10.20	Mold protect press	650	Position 6 Gate/HB/Man	450					
Hold Press 1 PSI	600	Mold protect time		Start-Up Instructions / Comments						
Hold Press 2 PSI		Clamp tonnage	350							
Hold Press 1 secs	7.00	Injection pressure gauge	997							
Hold Press 2 secs		Holding 1 gauge psi	603							
Final Cushion mm	3.6	Holding 2 gauge psi								
		Back pressure gauge psi	158							
		Back pressure gauge psi	158							

Validated by: