CAMBRO
TRUSTED FOR GENERATIONS™

JSW

Run Sheet - CONFIDENTIAL

Version No.

QUALIFY FORM

Product Name	66CW110
Material Number	11100
Material Description	CLEAR POLYCARB
Date Created	02/21/2018

Tool Number	GN66PAN#3		
Resin/Aditive Number			
Resin/Aditive Descrip			
		Std.	Cert.

Colorant Number	20549A
Colorant Descrip	CLR BK MB102056AC 901
Color Percentage	5.00
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :			
Final Part(s) Weight (g	473.320	475.7	478.080

ALL DATA BELOW IS REFERENCE ONLY AND SETTINGS CAN BE ADJUSTED IF REQUIRED IN ORDER TO MEET PRODUCT STANDARDS

Barrel Temperatures	Set
Nozzle Tip %	2
Nozzle Body %	2
Adapter (NH)	476
Barrel Front (H4)	580
Barrel Center (H3)	620
Barrel Center (H2)	620
Barrel Rear (H1)	580

Mold Cooling Temps	Set
Mold Gate Temp °F	120
Mold Fixed ½ °F	180
Mold Moving ½ °F	170
Stripper or other °F	
Nozzle Tip Information	
Type GP, FT, NYL	
Length OAL (in.)	0.00
Orifice Size (in.)	0.00
Nozzle Body Information	
Length OAL (in.)	0.00

Reference Data	Set
Fill Only Time	2.90
Fill Only Weight	469.2
Steel Temp. "A" Side °F	186
Steel Temp. "B" Side °F	178
Melt Temp. °F	594

Machine Number: 413

Valve Gate	VG1	VG2	VG3	VG4
Open Delay				
Open Time				
Adv Cls Tm				
Close Delay				
Close Time				
Inj HP End				
Transfer				

Injection Profile	Set
Shot size in.	4.50
Injection Press 1	1800.00
Injection Press 2	2450.00
Injection Press 3	2400.00
Injection Press 4	
Injection Press 5	
Injection Velocity 1	1.00
Injection Velocity 2	2.00
Injection Velocity 3	2.00
Injection Velocity 4	
Injection Velocity 5	
Injection Change Pos 1	3.50
Injection Change Pos 2	1.20
Injection Change Pos 3	
Injection Change Pos 4	
Trans mode Ivsh/Ips	IPS
Trans pos in.	0.71
Ips PSI	
Inj PSI at transfer	2408
Injection time act. secs.	2.62
Hold Press 1 %	880
Hold Press 2 %	760
Hold Time 1	2.00
Hold Time 2	2.00
Injection Hold Time	6.62

Recovery & Clamp Profile	
PrePullbk(PB2)speed	
PrePullbck before stro	
Screw Start Delay	
Screw Chg Position 1	3.00
Screw Chg Position 2	
Screw recovery % 1	65.00
Screw recovery % 2	70.00
Back Pressure 1	180.00
Back Pressure 2	180.00
PostPullback(PB1)speed	50.00
Post Pullback stroke in.	
Screw positon after SB	4.63
Screw recovery time	12.83
Cooling time secs	13.50
Mold protect press	80.00
Mold protect time	20.00
Clamp tonnage	350
Injection pressure gauge	2463
Holding 1 gauge psi	819
Holding 2 gauge psi	751
Back pressure gauge psi	179
Back pressure gauge psi	151
Final Cushion	0.44

Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Position 1 Gate/HB/Man	580	620	580	620	620	
Position 2 Gate/HB/Man						
Position 3 Gate/HB/Man						
Position 4 Gate/HB/Man						
Position 5 Gate/HB/Man						
Position 6 Gate/HB/Man						

Start-Up Instructions / Comments

Mold has vent issues

Validated by:

2:50:20PM