

Version No.

QUALIFY FORM

Product Name	RSB1419CW110
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	01/15/2019

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	51.50	52.5	53.00
Final Part(s) Weight (g)	800.980	805.0	809.030

Tool Number	1419RIBSALBOWL	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	20549A
Colorant Descrip	CLR BK MB102056AC 901
Color Percentage	5.00
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		Machine Number: H407				
Nozzle Tip %	15	Mold Gate Temp °F		Fill Only Time	3.60					
Nozzle Body %	15	Mold Fixed ½ °F	165	Fill Only Weight	796.0					
Adapter 1 (EX)	15	Mold Moving ½ °F	145	Steel Temp. "A" Side °F	165					
S/H Heat (EX)		Stripper or other °F		Steel Temp. "B" Side °F	150					
Barrel Head (EX)	550	Nozzle Tip Information		Melt Temp. °F	620					
Barrel Front (EX7)	610	Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4		
Barrel Center (EX6)	610	Length OAL (in.)	0.00	Open						
Barrel Center (EX5)	610	Orifice Size (in.)	0.00	Close						
Barrel Center (EX4)	610	Nozzle Body Information		PSI						
Barrel Center (EX3)	600	Length OAL (in.)	0.00	Delay						
Barrel Center (EX2)	600									
Barrel Rear (EX1)	600									
Injection Profile	Set	Recovery & Clamp Profile		Gas Assist	C1	C2	C3	C4		
Shot size in.	138.0	Pre-Pullback mm/s	20.00	Delay (Sec)						
Injection Velocity mm/s	5	Pre-Pullback Stroke m	1.00	Hold (Sec)						
Injection Velocity mm/s	55	Screw Start Delay		Exhaust (Sec)						
Injection Velocity mm/s	25	Screw Chg Position	70.0	Pressure 1 (PSI)						
Injection Velocity mm/s		Screw Recovery RPM	90	Time (Sec)						
Injection Velocity mm/s		Screw Recovery RPM	80	Pessure 2 (PSI)						
Injection Change Pos 1	138.0	Back Pressure 1		Time (Sec)						
Injection Change Pos 2	133.0	Back Pressure 2		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Injection Change Pos 3	40.0	Post Pullback mm/s		Position 1 Gate/HB/Man	340					
Injection Change Pos 4		Post Pullback Stroke		Position 2 Gate/HB/Man						
Trans Pos. mm	22.00	Screw positon after SB	139.00	Position 3 Gate/HB/Man						
Injection Press Limit	2600	Screw recovery time	13.00	Position 4 Gate/HB/Man						
Inj PSI at transfer	1500	Cooling time secs	21.0	Position 5 Gate/HB/Man						
Injection time act. secs.	3.62	Mold protect press	1000	Position 6 Gate/HB/Man						
Hold Press 1 PSI	700	Mold protect time		Start-Up Instructions / Comments						
Hold Press 2 PSI	580	Clamp tonnage	363							
Hold Press 1 secs	8.00	Injection pressure gauge								
Hold Press 2 secs	5.00	Holding 1 gauge psi								
Final Cushion mm		Holding 2 gauge psi								
		Back pressure gauge psi								
		Back pressure gauge psi								
				Validated by:						