

VALIDATING FORM

Product Name	10CWH135
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	06/21/2017

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	34.50	36.0	36.00
Final Part(s) Weight (g)	538.300	541.0	543.710

Tool Number	GN10HCOVER#2	
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: 718								
Nozzle Tip %	100	Mold Gate Temp °F	TOWER	Fill Only Time	3.97									
Nozzle Body %	100	Mold Fixed ½ °F	200	Fill Only Weight	496.0									
Adapter (NH)	480	Mold Moving ½ °F	180	Steel Temp. "A" Side °F	177									
Barrel Front (H4)	620	Stripper or other °F		Steel Temp. "B" Side °F	110									
Barrel Center (H3)	620	Nozzle Tip Information		Melt Temp. °F	585									
Barrel Center (H2)	620	Type GP, FT, NYL	GP	Valve Gate	VG1							VG2	VG3	VG4
Barrel Rear (H1)	580	Length OAL (in.)	2 3/4	Open Delay										
		Orifice Size (in.)	1/4	Open Time										
		Nozzle Body Information		Adv Cls Tm										
		Length OAL (in.)	6.00	Close Delay										
Injection Profile	Set	Recovery & Clamp Profile		Close Time										
Shot size in.	3.85	PrePullbk(PB2)speed		Inj HP End										
Injection Press 1	30.00	PrePullbck 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	95.00	Screw Chg Position 1	3.40	Position 1 Gate/HB/Man	580	620								
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man										
Injection Press 5		Screw recovery % 1	30.00	Position 3 Gate/HB/Man										
Injection Velocity 1	6.00	Screw recovery % 2	30.00	Position 4 Gate/HB/Man										
Injection Velocity 2	65.00	Back Pressure 1	35.00	Position 5 Gate/HB/Man										
Injection Velocity 3	55.00	Back Pressure 2	20.00	Position 6 Gate/HB/Man										
Injection Velocity 4		PostPullback(PB1)speed	35.00	Start-Up Instructions / Comments										
Injection Velocity 5		Post Pullback stroke in.	0.25											
Injection Change Pos 1	3.70	Screw positon after SB	4.17											
Injection Change Pos 2	0.70	Screw recovery time	13.74											
Injection Change Pos 3		Cooling time secs	18.00											
Injection Change Pos 4		Mold protect press	50.00											
Trans mode lvsh/lps	IVSH	Mold protect time	10.00											
Trans pos in.	0.15	Clamp tonnage	700											
lps PSI	2000	Injection pressure gauge	1800											
Inj PSI at transfer	2000	Holding 1 gauge psi	600											
Injection time act. secs.	3.97	Holding 2 gauge psi	200											
Hold Press 1 %	56	Back pressure gauge psi	300											
Hold Press 2 %	25	Back pressure gauge psi	250											
Hold Time 1	0.40	Final Cushion	0.30											
Hold Time 2														
Injection Hold Time	8.50													