

VALIDATING FORM

Product Name	32HPTBH1150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	05/22/2019

Tool Number	32HPTBH	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	32.50	34.0	34.00
Final Part(s) Weight (g)	266.660	268.0	269.340

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: 47							
Nozzle Tip %	100	Mold Gate Temp °F	200	Fill Only Time	3.29								
Nozzle Body %	100	Mold Fixed ½ °F	330	Fill Only Weight	262.5								
Adapter (NH)	600	Mold Moving ½ °F	225	Steel Temp. "A" Side °F	316								
Barrel Front (H4)	690	Stripper or other °F	225	Steel Temp. "B" Side °F	268								
Barrel Center (H3)	690	Nozzle Tip Information		Melt Temp. °F	739								
Barrel Center (H2)	690	Type GP, FT, NYL	GP	Valve Gate	VG1						VG2	VG3	VG4
Barrel Rear (H1)	680	Length OAL (in.)	2	Open Delay									
		Orifice Size (in.)	1/8	Open Time									
		Nozzle Body Information		Adv Cls Tm									
		Length OAL (in.)	6	Close Delay									
Injection Profile	Set	Recovery & Clamp Profile		Close Time									
Shot size in.	3.00	PrePullbk(PB2)speed		Inj HP End									
Injection Press 1	40.00	PrePullbk before stro		Transfer									
Injection Press 2	90.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4			Box 5	Box 6	
Injection Press 3		Screw Chg Position 1	1.90	Position 1 Gate/HB/Man									
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	5.00	Screw recovery % 2	35.00	Position 4 Gate/HB/Man									
Injection Velocity 2	600.00	Back Pressure 1	85.00	Position 5 Gate/HB/Man									
Injection Velocity 3		Back Pressure 2	50.00	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	2.80	Screw positon after SB	3.31										
Injection Change Pos 2		Screw recovery time	14.22										
Injection Change Pos 3		Cooling time secs	21.00										
Injection Change Pos 4		Mold protect press	50.00										
Trans mode lvsh/lps	lvsh	Mold protect time	5.00										
Trans pos in.	0.20	Clamp tonnage	260										
lps PSI	2050	Injection pressure gauge	2050										
Inj PSI at transfer	2050	Holding 1 gauge psi	1000										
Injection time act. secs.	3.29	Holding 2 gauge psi	700										
Hold Press 1 %	40	Back pressure gauge psi	390										
Hold Press 2 %	35	Back pressure gauge psi	300										
Hold Time 1	2.00	Final Cushion	0.05										
Hold Time 2													
Injection Hold Time	6.00												