

HAITIAN

QUALIFY FORM

Product Name	SCP64CW135
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	06/06/2017

Tool Number	64OZSCOOP#2	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :			
Final Part(s) Weight (gm)	251.740	253.0	254.270

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: HT49					
Nozzle Tip %		OFF	Mold Gate Temp °F		Fill Only Time	6.10						
Nozzle Body %		OFF	Mold Fixed ½ °F	180	Fill Only Weight	234.0						
Adapter 1 (HT1)		4	Mold Moving ½ °F	165	Steel Temp. "A" Side °F	167						
Barrel Front (HT2)		590	Stripper or other °F		Steel Temp. "B" Side °F	171						
Barrel Center (HT3)		600	Nozzle Tip Information		Melt Temp. °F	573						
Barrel Center (HT4)		600	Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4			
Barrel Center (HT5)		590	Length OAL (in.)	0.00	Open	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos			
Barrel Center (HT6)			Orifice Size (in.)	0.00	Time							
Barrel Center (HT7)			Nozzle Body Information		Pos							
Barrel Rear (HT8)			Length OAL (in.)	0.00	Close	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos			
					Time							
					Pos							
					Injection Profile		Set	Recovery & Clamp Profile		Hold	On/Off	On/Off
Shot size in.		3.20	Suckback Before Pos		Delay							
Injection Change Pos 1		3.04	Screw Start Delay		Active							
Injection Change Pos 2			Charge Position 1		1.50	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Injection Change Pos 3			Charge Position 2			Position 1 Gate/HB/Man	640					
Injection Change Pos 4			Charge Pressure 1		755	Position 2 Gate/HB/Man	700					
Injection Press 1		400	Charge Pressure 2			Position 3 Gate/HB/Man						
Injection Press 2		1500	Charge Flow 1		45	Position 4 Gate/HB/Man						
Injection Press 3			Charge Flow 2		45	Position 5 Gate/HB/Man						
Injection Press 4			Back Pressure 1		350.0	Position 6 Gate/HB/Man						
Injection Press 5			Back Pressure 2		350.0	Start-Up Instructions / Comments						
Injection Flow 1		10	Suckback After Pos		0.02	HAED 30 FILL - MUST PACK OUT PARTS						
Injection Flow 2		75	Screw Positon After SB		3.63							
Injection Flow 3			Screw charge Time									
Injection Flow 4			Cooling time secs		28.0							
Injection Flow 5			Mold protect press		700							
Inj Position threshold		1.00	Mold Protect Flow		80							
Inj Pressure threshold			Mold protect time									
InjectionTime threshold			Clamp High Press PSI		1555							
Inj PSI at transfer			Clamp High Press Flow		29							
Injection time act. secs.		20.30	Injection pressure gauge		400							
Hold Press 1 PSI		650	Holding 1 gauge psi		650							
Hold Press 2 PSI		600	Holding 2 gauge psi		600							
Hold Flow 1		30	Back pressure gauge psi									
Hold Flow 2		30	Back pressure gauge psi									
Hold Time 1		7.00										
Hold Time 2		7.00										
Final Cushion mm		1.00										