

Version No.

**VALIDATING FORM**

Product Name	10CWGL135
Material Number	11188
Material Description	RSN TEXIN 990R 000000
Date Created	07/13/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	84.50	86.0	86.00
Final Part(s) Weight (g)	221.390	222.5	223.610

Tool Number	10CWGLTPU	
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: 412					
Nozzle Tip %	20	Mold Gate Temp °F		Fill Only Time	7.45						
Nozzle Body %	20	Mold Fixed ½ °F	100	Fill Only Weight	621.0						
Adapter (NH)	400	Mold Moving ½ °F	100	Steel Temp. "A" Side °F	124						
Barrel Front (H4)	430	Stripper or other °F		Steel Temp. "B" Side °F	124						
Barrel Center (H3)	440	Nozzle Tip Information		Melt Temp. °F	359						
Barrel Center (H2)	430	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	420	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	3/16	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6.0	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	3.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	15.00	PrePullbk before stro		Transfer							
Injection Press 2	50.00	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		Position 1 Gate/HB/Man							
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	45.00	Position 3 Gate/HB/Man							
Injection Velocity 1	5.00	Screw recovery % 2	30.00	Position 4 Gate/HB/Man							
Injection Velocity 2	5.00	Back Pressure 1	50.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	50.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	95.00	<b>Start-Up Instructions / Comments</b>  The Standard Shot & Part weight listed in header section is for the Texin (TPU) resin only. The total Shot weight with TPU resin, 10CWGLWIP135 and runner is 753.The total Part weight with TPU resin and 10CWGLWIP135 is 730.5							
Injection Velocity 5		Post Pullback stroke in.	0.23								
Injection Change Pos 1	2.80	Screw positon after SB	3.27								
Injection Change Pos 2		Screw recovery time	7.10								
Injection Change Pos 3		Cooling time secs	20.00								
Injection Change Pos 4		Mold protect press	70.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	1.70	Clamp tonnage	300								
lps PSI		Injection pressure gauge	518								
Inj PSI at transfer	518	Holding 1 gauge psi	395								
Injection time act. secs.	7.45	Holding 2 gauge psi	406								
Hold Press 1 %	24	Back pressure gauge psi	158								
Hold Press 2 %	20	Back pressure gauge psi									
Hold Time 1	5.00	Final Cushion	0.02								
Hold Time 2											
Injection Hold Time	40.00										
				Validated by:							