

VALIDATING FORM

Product Name	36HP150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	05/23/2019

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	32.50	34.0	34.00
Final Part(s) Weight (g)	520.390	523.0	525.620

Tool Number	GN36PAN#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: 41					
Nozzle Tip %	100	Mold Gate Temp °F	300	Fill Only Time	3.87						
Nozzle Body %	50	Mold Fixed ½ °F	315	Fill Only Weight	504.3						
Adapter (NH)	650	Mold Moving ½ °F	280	Steel Temp. "A" Side °F	343						
Barrel Front (H4)	690	Stripper or other °F	280	Steel Temp. "B" Side °F	309						
Barrel Center (H3)	690	Nozzle Tip Information		Melt Temp. °F	799						
Barrel Center (H2)	690	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	680	Length OAL (in.)	2-3/4	Open Delay							
		Orifice Size (in.)	1/8	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	7-1/4	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	6.45	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	30.00	PrePullbck before stro		Transfer							
Injection Press 2	95.00	Screw Start Delay		1.00	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		50.00	Position 3 Gate/HB/Man						
Injection Velocity 1	5.40	Screw recovery % 2			Position 4 Gate/HB/Man						
Injection Velocity 2		Back Pressure 1		45.00	Position 5 Gate/HB/Man						
Injection Velocity 3		Back Pressure 2			Position 6 Gate/HB/Man						
Injection Velocity 4		PostPullback(PB1)speed		20.00	Start-Up Instructions / Comments						
Injection Velocity 5		Post Pullback stroke in.		0.25	Make sure not to exceed cushion set point in order to prevent black specks.						
Injection Change Pos 1	5.40	Screw positon after SB		5.72							
Injection Change Pos 2		Screw recovery time		13.02							
Injection Change Pos 3		Cooling time secs		17.50							
Injection Change Pos 4		Mold protect press		55.00							
Trans mode lvsh/lps	lvsh	Mold protect time		5.00							
Trans pos in.	0.15	Clamp tonnage		340							
lps PSI	2050	Injection pressure gauge		2050							
Inj PSI at transfer	2050	Holding 1 gauge psi		600							
Injection time act. secs.	3.87	Holding 2 gauge psi									
Hold Press 1 %	25	Back pressure gauge psi		300							
Hold Press 2 %		Back pressure gauge psi									
Hold Time 1		Final Cushion		0.07							
Hold Time 2											
Injection Hold Time	10.20										