

QUALIFY FORM

Product Name	30HPCH150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	06/06/2019

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	29.40	30.9	30.90
Final Part(s) Weight (g)	196.020	197.0	197.990

Tool Number	GN30HPCOVER	
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: 48					
Nozzle Tip %	110	Mold Gate Temp °F	285	Fill Only Time	4.29						
Nozzle Body %	100	Mold Fixed ½ °F	285	Fill Only Weight	196.0						
Adapter (NH)	650	Mold Moving ½ °F	210	Steel Temp. "A" Side °F	305						
Barrel Front (H4)	680	Stripper or other °F		Steel Temp. "B" Side °F	223						
Barrel Center (H3)	680	Nozzle Tip Information		Melt Temp. °F	750						
Barrel Center (H2)	680	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	670	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	1/8	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6" inches	Close Delay							
		Injection Profile		Set	Recovery & Clamp Profile		Close Time				
Shot size in.	2.30	PrePullbk(PB2)speed			Inj HP End						
Injection Press 1	35.00	PrePullbck before stro			Transfer						
Injection Press 2	80.00	Screw Start Delay			Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	
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	10.00	Screw recovery % 2			Position 4 Gate/HB/Man						
Injection Velocity 2	50.00	Back Pressure 1		60.00	Position 5 Gate/HB/Man						
Injection Velocity 3		Back Pressure 2			Position 6 Gate/HB/Man						
Injection Velocity 4		PostPullback(PB1)speed		10.00	Start-Up Instructions / Comments						
Injection Velocity 5		Post Pullback stroke in.		0.10							
Injection Change Pos 1	2.35	Screw positon after SB		2.40							
Injection Change Pos 2		Screw recovery time		7.92							
Injection Change Pos 3		Cooling time secs		13.50							
Injection Change Pos 4		Mold protect press		50.00							
Trans mode lvsh/lps	IVSH	Mold protect time		5.00							
Trans pos in.	0.10	Clamp tonnage		290							
lps PSI		Injection pressure gauge		1800							
Inj PSI at transfer	1800	Holding 1 gauge psi		900							
Injection time act. secs.	4.29	Holding 2 gauge psi		500							
Hold Press 1 %	35	Back pressure gauge psi		350							
Hold Press 2 %	35	Back pressure gauge psi									
Hold Time 1	1.00	Final Cushion		0.08							
Hold Time 2											
Injection Hold Time	10.00										