

VALIDATING FORM

Product Name	6TGS135
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	08/14/2018

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :			
Final Part(s) Weight (g)	45.770	46.0	46.230

Tool Number	6TGS#3	
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		Machine Number: H406				
Nozzle Tip %		Mold Gate Temp °F		Fill Only Time	2.95					
Nozzle Body %	25	Mold Fixed ½ °F	180	Fill Only Weight	43.0					
Adapter 1 (EX)	25	Mold Moving ½ °F	160	Steel Temp. "A" Side °F	182					
S/H Heat (EX)		Stripper or other °F		Steel Temp. "B" Side °F	150					
Barrel Head (EX)	580	Nozzle Tip Information		Melt Temp. °F	585					
Barrel Front (EX7)		Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4		
Barrel Center (EX6)	600	Length OAL (in.)	2 3/4	Open						
Barrel Center (EX5)	600	Orifice Size (in.)	3/16	Close						
Barrel Center (EX4)	600	Nozzle Body Information		PSI						
Barrel Center (EX3)	600	Length OAL (in.)	6.0	Delay						
Barrel Center (EX2)	580									
Barrel Rear (EX1)	570									
Injection Profile	Set	Recovery & Clamp Profile		Gas Assist	C1	C2	C3	C4		
Shot size in.	20.0	Pre-Pullback mm/s	9.00	Delay (Sec)						
Injection Velocity mm/s	3	Pre-Pullback Stroke m	9.00	Hold (Sec)						
Injection Velocity mm/s	15	Screw Start Delay	9.00	Exhaust (Sec)						
Injection Velocity mm/s	10	Screw Chg Position		Pressure 1 (PSI)						
Injection Velocity mm/s		Screw Recovery RPM	45	Time (Sec)						
Injection Velocity mm/s		Screw Recovery RPM	45	Pessure 2 (PSI)						
Injection Change Pos 1	18.0	Back Pressure 1	180.0	Time (Sec)						
Injection Change Pos 2	8.0	Back Pressure 2	50.0	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Injection Change Pos 3		Post Pullback mm/s	20.00	Position 1 Gate/HB/Man						
Injection Change Pos 4		Post Pullback Stroke	4.00	Position 2 Gate/HB/Man						
Trans Pos. mm	6.00	Screw positon after SB	24.10	Position 3 Gate/HB/Man						
Injection Press Limit	2600	Screw recovery time	1.80	Position 4 Gate/HB/Man						
Inj PSI at transfer		Cooling time secs	11.8	Position 5 Gate/HB/Man						
Injection time act. secs.	2.95	Mold protect press	1000	Position 6 Gate/HB/Man						
Hold Press 1 PSI	500	Mold protect time		Start-Up Instructions / Comments						
Hold Press 2 PSI	35	Clamp tonnage	400							
Hold Press 1 secs	4.00	Injection pressure gauge	1584							
Hold Press 2 secs	3.00	Holding 1 gauge psi	500							
Final Cushion mm		Holding 2 gauge psi	350							
		Back pressure gauge psi								
		Back pressure gauge psi								

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