

VALIDATING FORM

Product Name	RSB6CW148
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	04/19/2017

Tool Number	6INPEB/RIBSBWL	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	22.00	23.5	23.50
Final Part(s) Weight (g)	179.100	180.0	180.900

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: 411					
Nozzle Tip %	70	Mold Gate Temp °F	170	Fill Only Time	1.53						
Nozzle Body %	70	Mold Fixed ½ °F	170	Fill Only Weight	178.0						
Adapter (NH)		Mold Moving ½ °F	150	Steel Temp. "A" Side °F	222						
Barrel Front (H4)	625	Stripper or other °F	150	Steel Temp. "B" Side °F	206						
Barrel Center (H3)	625	Nozzle Tip Information		Melt Temp. °F	620						
Barrel Center (H2)	625	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	620	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.	2.90	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	50.00	PrePullbk before stro		Transfer							
Injection Press 2	85.00	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	1.50	Position 1 Gate/HB/Man	730						
Injection Press 4		Screw Chg Position 2	2.00	Position 2 Gate/HB/Man	790						
Injection Press 5		Screw recovery % 1	40.00	Position 3 Gate/HB/Man	800						
Injection Velocity 1	9.00	Screw recovery % 2	35.00	Position 4 Gate/HB/Man							
Injection Velocity 2	45.00	Back Pressure 1	65.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	50.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	55.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.20								
Injection Change Pos 1	2.80	Screw positon after SB	3.12								
Injection Change Pos 2		Screw recovery time	6.75								
Injection Change Pos 3		Cooling time secs	14.00								
Injection Change Pos 4		Mold protect press	70.00								
Trans mode lvsh/lps	IVSH	Mold protect time	2.00								
Trans pos in.	1.30	Clamp tonnage									
lps PSI		Injection pressure gauge									
Inj PSI at transfer	1500	Holding 1 gauge psi									
Injection time act. secs.	1.53	Holding 2 gauge psi									
Hold Press 1 %	18	Back pressure gauge psi									
Hold Press 2 %	12	Back pressure gauge psi									
Hold Time 1	3.00	Final Cushion									
Hold Time 2											
Injection Hold Time	5.00										