

QUALIFY FORM

Product Name	SCP12CW135
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	07/31/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (g)	92.930	93.4	93.870

Tool Number	12OZSCOOP#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: 313					
Nozzle Tip %	5	Mold Gate Temp °F		Fill Only Time	2.10						
Nozzle Body %	5	Mold Fixed ½ °F	160	Fill Only Weight	90.0						
Adapter (NH)	580	Mold Moving ½ °F	180	Steel Temp. "A" Side °F	175						
Barrel Front (H4)	600	Stripper or other °F		Steel Temp. "B" Side °F	602						
Barrel Center (H3)	600	Nozzle Tip Information		Melt Temp. °F	599						
Barrel Center (H2)	600	Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	580	Length OAL (in.)	0.00	Open Delay							
		Orifice Size (in.)	0.00	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	0.00	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	1.25	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	18.00	PrePullbck before stro		Transfer							
Injection Press 2	65.00	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	500.00	Position 1 Gate/HB/Man	630						
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man	620						
Injection Press 5		Screw recovery % 1	35.00	Position 3 Gate/HB/Man							
Injection Velocity 1	2.00	Screw recovery % 2	35.00	Position 4 Gate/HB/Man							
Injection Velocity 2	40.00	Back Pressure 1	70.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	70.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	45.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.									
Injection Change Pos 1	1150.00	Screw positon after SB	1258.00								
Injection Change Pos 2		Screw recovery time	7.30								
Injection Change Pos 3		Cooling time secs	20.00								
Injection Change Pos 4		Mold protect press	95.00								
Trans mode lvsh/lps	IVSH	Mold protect time	10.00								
Trans pos in.	450.00	Clamp tonnage	200								
lps PSI		Injection pressure gauge	1440								
Inj PSI at transfer	2	Holding 1 gauge psi	550								
Injection time act. secs.	1440.00	Holding 2 gauge psi	440								
Hold Press 1 %	50	Back pressure gauge psi	200								
Hold Press 2 %	20	Back pressure gauge psi	150								
Hold Time 1	3.00	Final Cushion	0.46								
Hold Time 2											
Injection Hold Time	11.00										