

## VALIDATING FORM

Product Name	HT8CW135
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	09/19/2018

Tool Number	8OZHBTUMBLER	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	24.50	26.0	26.00
Final Part(s) Weight (gm)	235.320	236.5	237.680

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: HT49						
Nozzle Tip %		20	Mold Gate Temp °F	135	Fill Only Time							5.00	
Nozzle Body %		20	Mold Fixed ½ °F	165	Fill Only Weight							232.9	
Adapter 1 (HT1)		500	Mold Moving ½ °F	155	Steel Temp. "A" Side °F							171	
Barrel Front (HT2)		580	Stripper or other °F		Steel Temp. "B" Side °F							163	
Barrel Center (HT3)		580	Nozzle Tip Information		Melt Temp. °F		580						
Barrel Center (HT4)		580	Type GP, FT, NYL		Valve Gate		VG1	VG2	VG3	VG4			
Barrel Center (HT5)		570	Length OAL (in.)	0.00	Open	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos				
Barrel Center (HT6)			Orifice Size (in.)	0.00	Time								
Barrel Center (HT7)			Nozzle Body Information		Pos								
Barrel Rear (HT8)			Length OAL (in.)	0.00	Close	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos				
					Time								
					Pos								
Injection Profile		Set	Recovery & Clamp Profile		Hold	On/Off	On/Off	On/Off	On/Off				
Shot size in.		3.30	Suckback Before Pos	0.10	Delay								
Injection Change Pos 1		2.90	Screw Start Delay		Active								
Injection Change Pos 2			Charge Position 1	1.00	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6		
Injection Change Pos 3			Charge Position 2		Position 1 Gate/HB/Man	655							
Injection Change Pos 4			Charge Pressure 1	700	Position 2 Gate/HB/Man	655							
Injection Press 1		600	Charge Pressure 2	700	Position 3 Gate/HB/Man	656							
Injection Press 2		1600	Charge Flow 1	40	Position 4 Gate/HB/Man	645							
Injection Press 3			Charge Flow 2	40	Position 5 Gate/HB/Man	610							
Injection Press 4			Back Pressure 1	250.0	Position 6 Gate/HB/Man	610							
Injection Press 5			Back Pressure 2	200.0	Start-Up Instructions / Comments								
Injection Flow 1		8	Suckback After Pos	0.10									
Injection Flow 2		46	Screw Positon After SB	3.50									
Injection Flow 3			Screw charge Time	10.0									
Injection Flow 4			Cooling time secs	11.0									
Injection Flow 5			Mold protect press	300									
Inj Position threshold		1.00	Mold Protect Flow	99									
Inj Pressure threshold			Mold protect time										
InjectionTime threshold			Clamp High Press PSI	1950									
Inj PSI at transfer			Clamp High Press Flow	60									
Injection time act. secs.		5.00	Injection pressure gauge	1700									
Hold Press 1 PSI		500	Holding 1 gauge psi	500									
Hold Press 2 PSI		450	Holding 2 gauge psi										
Hold Flow 1		40	Back pressure gauge psi										
Hold Flow 2		40	Back pressure gauge psi										
Hold Time 1		2.00											
Hold Time 2		2.00											
Final Cushion mm		1.00											