

Version No.

**VALIDATING FORM**

Product Name	6SFSP148
Material Number	11187
Material Description	RSN 6719 HDPE (INJ/MTC)
Date Created	11/02/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (g)	735.310	739.0	742.700

Tool Number	6SFS	
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: 728					
Nozzle Tip %	3	Mold Gate Temp °F		Fill Only Time	5.00						
Nozzle Body %	3	Mold Fixed ½ °F	100	Fill Only Weight	733.0						
Adapter (NH)	400	Mold Moving ½ °F	65	Steel Temp. "A" Side °F	112						
Barrel Front (H4)	400	Stripper or other °F		Steel Temp. "B" Side °F	75	VG2	VG3	VG4			
Barrel Center (H3)	410	Nozzle Tip Information		Melt Temp. °F	405						
Barrel Center (H2)	410	Type GP, FT, NYL	GP	Valve Gate	VG1						
Barrel Rear (H1)	400	Length OAL (in.)	3 3/4	Open Delay							
		Orifice Size (in.)	1/4	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.	5.70	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	35.00	PrePullbk before stro		Transfer							
Injection Press 2	90.00	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		Position 1 Gate/HB/Man	350	400	400	350	400	400	
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	80.00	Position 3 Gate/HB/Man							
Injection Velocity 1	5.00	Screw recovery % 2		Position 4 Gate/HB/Man							
Injection Velocity 2	40.00	Back Pressure 1	20.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2		Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	99.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.50	HOT STAMP CELL #9							
Injection Change Pos 1	6.10	Screw positon after SB	6.20								
Injection Change Pos 2		Screw recovery time	6.69								
Injection Change Pos 3		Cooling time secs	35.00								
Injection Change Pos 4		Mold protect press	50.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	1.50	Clamp tonnage	700								
lps PSI		Injection pressure gauge	795								
Inj PSI at transfer	900	Holding 1 gauge psi	700								
Injection time act. secs.	5.01	Holding 2 gauge psi									
Hold Press 1 %	300	Back pressure gauge psi	200	Validated by:							
Hold Press 2 %		Back pressure gauge psi									
Hold Time 1		Final Cushion	0.35								
Hold Time 2											
Injection Hold Time	10.00										