

Version No.

VALIDATING FORM

Product Name	UPCHHPCULTRASON
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	04/09/2019

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	31.00	32.5	32.50
Final Part(s) Weight (g)	338.800	340.5	342.200

Tool Number	SMLHTENCLOSURE2	
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: 48											
Nozzle Tip %	50	Mold Gate Temp °F	200	Fill Only Time	3.02												
Nozzle Body %	100	Mold Fixed ½ °F	300	Fill Only Weight	332.0												
Adapter (NH)	650	Mold Moving ½ °F	300	Steel Temp. "A" Side °F	295												
Barrel Front (H4)	710	Stripper or other °F		Steel Temp. "B" Side °F	288												
Barrel Center (H3)	710	Nozzle Tip Information		Melt Temp. °F	710												
Barrel Center (H2)	710	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4									
Barrel Rear (H1)	690	Length OAL (in.)	3	Open Delay													
		Orifice Size (in.)	3/16	Open Time													
		Nozzle Body Information		Adv Cls Tm													
		Length OAL (in.)	6	Close Delay													
		Injection Profile		Set	Recovery & Clamp Profile		Close Time										
Shot size in.	3.80	PrePullbk(PB2)speed		Inj HP End													
Injection Press 1	95.00	PrePullbck before stro		Transfer													
Injection Press 2	95.00	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													
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man													
Injection Press 5		Screw recovery % 1	60.00	Position 3 Gate/HB/Man													
Injection Velocity 1	45.00	Screw recovery % 2		Position 4 Gate/HB/Man													
Injection Velocity 2	65.00	Back Pressure 1	55.00	Position 5 Gate/HB/Man													
Injection Velocity 3		Back Pressure 2		Position 6 Gate/HB/Man													
Injection Velocity 4		PostPullback(PB1)speed	40.00	Start-Up Instructions / Comments													
Injection Velocity 5		Post Pullback stroke in.	0.23														
Injection Change Pos 1	2.80	Screw positon after SB	4.05														
Injection Change Pos 2		Screw recovery time	10.72														
Injection Change Pos 3		Cooling time secs	12.00														
Injection Change Pos 4		Mold protect press	95.00														
Trans mode lvsh/lps	IVSH	Mold protect time	5.00														
Trans pos in.	0.14	Clamp tonnage	320														
lps PSI	2100	Injection pressure gauge	2100														
Inj PSI at transfer	2100	Holding 1 gauge psi	500														
Injection time act. secs.	3.02	Holding 2 gauge psi															
Hold Press 1 %	50	Back pressure gauge psi	300														
Hold Press 2 %		Back pressure gauge psi															
Hold Time 1		Final Cushion	0.12														
Hold Time 2																	
Injection Hold Time	12.00																
											Validated by:						

Validated by: