

Version No.

CERTIFIED FORM

Product Name	900CW152
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	06/06/2017

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	25.00	26.5	26.50
Final Part(s) Weight (g)	179.100	180.0	180.900

Tool Number	900CC	
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: 47					
Nozzle Tip %	25	Mold Gate Temp °F		Fill Only Time	2.30						
Nozzle Body %		Mold Fixed ½ °F	180	Fill Only Weight	173.0						
Adapter (NH)	500	Mold Moving ½ °F	190	Steel Temp. "A" Side °F	226						
Barrel Front (H4)	600	Stripper or other °F		Steel Temp. "B" Side °F	206						
Barrel Center (H3)	640	Nozzle Tip Information		Melt Temp. °F	560						
Barrel Center (H2)	620	Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	600	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.	210.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	30.00	PrePullbk before stro		Transfer							
Injection Press 2	80.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	60.00	Screw Chg Position 1	1.80	Position 1 Gate/HB/Man							
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	40.00	Position 3 Gate/HB/Man							
Injection Velocity 1	5.00	Screw recovery % 2	35.00	Position 4 Gate/HB/Man							
Injection Velocity 2	50.00	Back Pressure 1	40.00	Position 5 Gate/HB/Man							
Injection Velocity 3	35.00	Back Pressure 2	10.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	99.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.30	AIR BLOWN ON TOP OF CORE							
Injection Change Pos 1	2.00	Screw positon after SB	2.49								
Injection Change Pos 2	0.80	Screw recovery time	8.80								
Injection Change Pos 3		Cooling time secs	15.00								
Injection Change Pos 4		Mold protect press	50.00								
Trans mode lvsh/lps	lvsh	Mold protect time	5.00								
Trans pos in.	0.40	Clamp tonnage	300								
lps PSI		Injection pressure gauge	1600								
Inj PSI at transfer	1600	Holding 1 gauge psi	800								
Injection time act. secs.	2.23	Holding 2 gauge psi	400								
Hold Press 1 %	35	Back pressure gauge psi	300	Validated by:							
Hold Press 2 %	40	Back pressure gauge psi	200								
Hold Time 1	1.00	Final Cushion	0.21								
Hold Time 2											
Injection Hold Time	7.00										