VALIDATING FORM

Product Name	46PP190
Material Number	11160
Material Description	RSN R12C-01 CLARFD PP
Date Created	06/04/2019

Tool Number	GN46PAN#3	
Resin/Aditive Number		
Resin/Aditive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	33.50	35.0	35.00
Final Part(s) Weight (g	517.400	520.0	522.600

ALL DATA BELOW IS REFERENCE ONLY AND SETTINGS CAN BE ADJUSTED IF REQUIRED IN ORDER TO MEET PRODUCT STANDARDS

Barrel Temperatures	Set
Nozzle Tip %	20
Nozzle Body %	20
Adapter (NH)	400
Barrel Front (H4)	450
Barrel Center (H3)	450
Barrel Center (H2)	450
Barrel Rear (H1)	440

Injection Profile	Set
Shot size in.	3.70
Injection Press 1	20.00
Injection Press 2	99.00
Injection Press 3	99.00
Injection Press 4	
Injection Press 5	
Injection Velocity 1	15.00
Injection Velocity 2	50.00
Injection Velocity 3	5.00
Injection Velocity 4	
Injection Velocity 5	
Injection Change Pos 1	3.70
Injection Change Pos 2	0.60
Injection Change Pos 3	
Injection Change Pos 4	
Trans mode Ivsh/Ips	IVSH
Trans pos in.	0.32
Ips PSI	1218
Inj PSI at transfer	1218
Injection time act. secs.	3.55
Hold Press 1 %	15
Hold Press 2 %	
Hold Time 1	
Hold Time 2	
Injection Hold Time	6.50

Mold Cooling Temps	Set
Mold Gate Temp °F	65
Mold Fixed ½ °F	65
Mold Moving ½ °F	65
Stripper or other °F	65
Nozzle Tip Information	
Type GP, FT, NYL	GP
Length OAL (in.)	2-3/4
Orifice Size (in.)	1/4
Nozzle Body Information	
Length OAL (in.)	7-1/4
Recovery & Clamp Profile	
PrePullbk(PB2)speed	
PrePullbck before stro	
Screw Start Delay	
Screw Chg Position 1	2.80
Screw Chg Position 2	
Screw recovery % 1	40.00
Screw recovery % 2	20.00
Back Pressure 1	40.00
Back Pressure 2	10.00
PostPullback(PB1)speed	99.00
Post Pullback stroke in.	0.25
Screw positon after SB	4.02
Screw recovery time	13.42
Cooling time secs	13.00
Mold protect press	40.00
Mold protect time	5.00
Clamp tonnage	500
Injection pressure gauge	1218
Holding 1 gauge psi	600
Holding 2 gauge psi	
Back pressure gauge psi	200
Back pressure gauge psi	80
Final Cushion	0.24

Reference Data	Set
Fill Only Time	3.55
Fill Only Weight	510.0
Steel Temp. "A" Side °F	70
Steel Temp. "B" Side °F	65
Melt Temp. °F	465

Machine Number: **711**

Valve Gate	VG1	VG2	VG3	VG4
Open Delay				
Open Time				
Adv Cls Tm				
Close Delay				
Close Time				
Inj HP End				
Transfer				

Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Position 1 Gate/HB/Man	350	350	350	400		
Position 2 Gate/HB/Man						
Position 3 Gate/HB/Man						
Position 4 Gate/HB/Man						
Position 5 Gate/HB/Man						
Position 6 Gate/HB/Man						

Start-Up Instructions / Comments

MUST HAVE AIR ON ON CAVITY SIDE TO MAKE SURE PARTS COME OFF THE MOLD.