

VALIDATING FORM

Product Name	10146CW186
Material Number	11154
Material Description	RSN NVYBLUE2856C 508060
Date Created	09/27/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	40.00	41.5	41.50
Final Part(s) Weight (g)	770.130	774.0	777.870

Tool Number	10146TRAY	
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: 713					
Nozzle Tip %	15	Mold Gate Temp °F		Fill Only Time	6.50						
Nozzle Body %	15	Mold Fixed ½ °F	140	Fill Only Weight	761.0						
Adapter (NH)	550	Mold Moving ½ °F	160	Steel Temp. "A" Side °F	149						
Barrel Front (H4)	580	Stripper or other °F		Steel Temp. "B" Side °F	173						
Barrel Center (H3)	630	Nozzle Tip Information		Melt Temp. °F	600						
Barrel Center (H2)	630	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	630	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	3/16	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6.00	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	6.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	30.00	PrePullbk 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	4.00	Position 1 Gate/HB/Man							
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	70.00	Position 3 Gate/HB/Man							
Injection Velocity 1	25.00	Screw recovery % 2	70.00	Position 4 Gate/HB/Man							
Injection Velocity 2	75.00	Back Pressure 1	55.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	20.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	95.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.30								
Injection Change Pos 1	6.00	Screw positon after SB	6.33								
Injection Change Pos 2		Screw recovery time	10.00								
Injection Change Pos 3		Cooling time secs	15.00								
Injection Change Pos 4		Mold protect press	60.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	1.10	Clamp tonnage	650								
lps PSI		Injection pressure gauge	1200								
Inj PSI at transfer	1200	Holding 1 gauge psi	400								
Injection time act. secs.	6.50	Holding 2 gauge psi	350								
Hold Press 1 %	15	Back pressure gauge psi	200								
Hold Press 2 %	20	Back pressure gauge psi	150								
Hold Time 1	1.00	Final Cushion	0.25								
Hold Time 2											
Injection Hold Time	15.00										