

QUALIFY FORM

Product Name	10CWC135
Material Number	11100
Material Description	CLEAR POLYCARB
Date Created	07/24/2018

Tool Number	GN10COVER#2	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	20.00	21.5	21.50
Final Part(s) Weight (g)	521.380	524.0	526.620

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: 712					
Nozzle Tip %	3	Mold Gate Temp °F		Fill Only Time	4.60						
Nozzle Body %	4	Mold Fixed ½ °F	180	Fill Only Weight	515.0						
Adapter (NH)	500	Mold Moving ½ °F	150	Steel Temp. "A" Side °F	172						
Barrel Front (H4)	630	Stripper or other °F		Steel Temp. "B" Side °F	144						
Barrel Center (H3)	650	Nozzle Tip Information		Melt Temp. °F	610						
Barrel Center (H2)	650	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	620	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.	3.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	55.00	PrePullbck before stro		Transfer							
Injection Press 2	75.00	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	640						
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man	500						
Injection Press 5		Screw recovery % 1		Position 3 Gate/HB/Man							
Injection Velocity 1	15.00	Screw recovery % 2		Position 4 Gate/HB/Man							
Injection Velocity 2	65.00	Back Pressure 1		Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2		Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed		Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.									
Injection Change Pos 1	2.90	Screw positon after SB									
Injection Change Pos 2		Screw recovery time									
Injection Change Pos 3		Cooling time secs									
Injection Change Pos 4		Mold protect press									
Trans mode lvsh/lps	IVSH	Mold protect time									
Trans pos in.	0.30	Clamp tonnage									
lps PSI		Injection pressure gauge									
Inj PSI at transfer	1600	Holding 1 gauge psi									
Injection time act. secs.	4.60	Holding 2 gauge psi									
Hold Press 1 %	20	Back pressure gauge psi									
Hold Press 2 %	15	Back pressure gauge psi									
Hold Time 1	1.00	Final Cushion									
Hold Time 2											
Injection Hold Time	7.00										