

QUALIFY FORM

Product Name	SFC12453
Material Number	11136
Material Description	RSN 574.189 LLD POLYETHLE
Date Created	06/02/2017

Tool Number	SFC12	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :			
Final Part(s) Weight (g)	155.220	156.0	156.780

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		Machine Number: H301					
Nozzle Tip %	1%	Mold Gate Temp °F		Fill Only Time	1.40						
Nozzle Body %		Mold Fixed ½ °F		Fill Only Weight	146.0						
Adapter 1 (EX)	1%	Mold Moving ½ °F		Steel Temp. "A" Side °F	91						
S/H Heat (EX)		Stripper or other °F	60	Steel Temp. "B" Side °F	85						
Barrel Head (EX)		Nozzle Tip Information		Melt Temp. °F	390						
Barrel Front (EX7)		Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4			
Barrel Center (EX6)		Length OAL (in.)	0.00	Open							
Barrel Center (EX5)		Orifice Size (in.)	0.00	Close							
Barrel Center (EX4)	400	Nozzle Body Information		PSI							
Barrel Center (EX3)	400	Length OAL (in.)	0.00	Delay							
Barrel Center (EX2)	395										
Barrel Rear (EX1)	390										
Injection Profile	Set	Recovery & Clamp Profile		Gas Assist	C1	C2	C3	C4			
Shot size in.	80.0	Pre-Pullback mm/s		Delay (Sec)							
Injection Velocity mm/s	40	Pre-Pullback Stroke m		Hold (Sec)							
Injection Velocity mm/s	35	Screw Start Delay		Exhaust (Sec)							
Injection Velocity mm/s	30	Screw Chg Position		Pressure 1 (PSI)							
Injection Velocity mm/s		Screw Recovery RPM	70	Time (Sec)							
Injection Velocity mm/s		Screw Recovery RPM		Pessure 2 (PSI)							
Injection Change Pos 1	28.0	Back Pressure 1	20.0	Time (Sec)							
Injection Change Pos 2	20.0	Back Pressure 2	20.0	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Change Pos 3		Post Pullback mm/s	99.00	Position 1 Gate/HB/Man							
Injection Change Pos 4		Post Pullback Stroke	9.00	Position 2 Gate/HB/Man							
Trans Pos. mm		Screw positon after SB	89.00	Position 3 Gate/HB/Man							
Injection Press Limit	810	Screw recovery time	9.34	Position 4 Gate/HB/Man							
Inj PSI at transfer	790	Cooling time secs		Position 5 Gate/HB/Man							
Injection time act. secs.	1.43	Mold protect press		Position 6 Gate/HB/Man							
Hold Press 1 PSI	325	Mold protect time		Start-Up Instructions / Comments							
Hold Press 2 PSI	275	Clamp tonnage	250								
Hold Press 1 secs	2.00	Injection pressure gauge									
Hold Press 2 secs	1.00	Holding 1 gauge psi									
Final Cushion mm	7.2	Holding 2 gauge psi									
		Back pressure gauge psi									
		Back pressure gauge psi									