

VALIDATING FORM

Product Name	10146DCPC190
Material Number	11160
Material Description	RSN R12C-01 CLARFD PP
Date Created	11/02/2018

Tool Number	10146DC	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	49.20	50.7	50.70
Final Part(s) Weight (gm)	271.640	273.0	274.370

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: HT43			
Nozzle Tip %	6	Mold Gate Temp °F	65	Fill Only Time	5.70					
Nozzle Body %	5	Mold Fixed ½ °F	65	Fill Only Weight	271.0					
Adapter 1 (HT1)	380	Mold Moving ½ °F	185	Steel Temp. "A" Side °F	79					
Barrel Front (HT2)	400	Stripper or other °F		Steel Temp. "B" Side °F	188					
Barrel Center (HT3)	400	Nozzle Tip Information		Melt Temp. °F	391					
Barrel Center (HT4)	400	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4		
Barrel Center (HT5)	390	Length OAL (in.)	2 3/4	Open	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos		
Barrel Center (HT6)		Orifice Size (in.)	1/4	Time						
Barrel Center (HT7)		Nozzle Body Information		Pos						
Barrel Rear (HT8)		Length OAL (in.)	6.00	Close	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos		
				Time						
				Pos						
Injection Profile	Set	Recovery & Clamp Profile		Hold	On/Off	On/Off	On/Off	On/Off		
Shot size in.	4.00	Suckback Before Pos		Delay						
Injection Change Pos 1	3.80	Screw Start Delay		Active						
Injection Change Pos 2	1.60	Charge Position 1	1.60	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Injection Change Pos 3		Charge Position 2		Position 1 Gate/HB/Man	420					
Injection Change Pos 4		Charge Pressure 1	850	Position 2 Gate/HB/Man	420					
Injection Press 1	700	Charge Pressure 2		Position 3 Gate/HB/Man						
Injection Press 2	700	Charge Flow 1	60	Position 4 Gate/HB/Man						
Injection Press 3	500	Charge Flow 2	55	Position 5 Gate/HB/Man						
Injection Press 4		Back Pressure 1	160.0	Position 6 Gate/HB/Man						
Injection Press 5		Back Pressure 2	160.0	Start-Up Instructions / Comments						
Injection Flow 1	20	Suckback After Pos	0.10	VERIFY LID FIT BEFORE RUN.						
Injection Flow 2	20	Screw Positon After SB	4.17							
Injection Flow 3	30	Screw charge Time	6.8							
Injection Flow 4		Cooling time secs	25.0							
Injection Flow 5		Mold protect press	29							
Inj Position threshold	0.75	Mold Protect Flow	40							
Inj Pressure threshold		Mold protect time	5.00							
InjectionTime threshold		Clamp High Press PSI	2000							
Inj PSI at transfer	800	Clamp High Press Flow	18							
Injection time act. secs.	5.70	Injection pressure gauge	800							
Hold Press 1 PSI	450	Holding 1 gauge psi	600							
Hold Press 2 PSI	400	Holding 2 gauge psi	550							
Hold Flow 1	35	Back pressure gauge psi								
Hold Flow 2	35	Back pressure gauge psi								
Hold Time 1	5.00									
Hold Time 2	5.00									
Final Cushion mm										