

VALIDATING FORM

Product Name	CCP27152
Material Number	11114K
Material Description	RSN SAN 3301 KUMHO
Date Created	05/15/2018

Tool Number	CP27	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	59.50	61.0	61.00
Final Part(s) Weight (g)	768.140	772.0	775.860

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: 723					
Nozzle Tip %	75	Mold Gate Temp °F		Fill Only Time	4.53						
Nozzle Body %	75	Mold Fixed ½ °F	120	Fill Only Weight	764.0						
Adapter (NH)	370	Mold Moving ½ °F	100	Steel Temp. "A" Side °F	123						
Barrel Front (H4)	450	Stripper or other °F		Steel Temp. "B" Side °F	113						
Barrel Center (H3)	450	Nozzle Tip Information		Melt Temp. °F	478						
Barrel Center (H2)	450	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	42	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	7/32	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6.0	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	6.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	20.00	PrePullbk 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	5.00	Position 1 Gate/HB/Man	330						
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man	330						
Injection Press 5		Screw recovery % 1	30.00	Position 3 Gate/HB/Man	400						
Injection Velocity 1	10.00	Screw recovery % 2	25.00	Position 4 Gate/HB/Man							
Injection Velocity 2	45.00	Back Pressure 1	50.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	35.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	99.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.45								
Injection Change Pos 1	6.20	Screw positon after SB	6.61								
Injection Change Pos 2		Screw recovery time	24.00								
Injection Change Pos 3		Cooling time secs	38.00								
Injection Change Pos 4		Mold protect press	20.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	0.50	Clamp tonnage	700								
lps PSI		Injection pressure gauge	1216								
Inj PSI at transfer	974	Holding 1 gauge psi	593								
Injection time act. secs.	4.53	Holding 2 gauge psi									
Hold Press 1 %	20	Back pressure gauge psi	196								
Hold Press 2 %		Back pressure gauge psi	146								
Hold Time 1		Final Cushion	0.26								
Hold Time 2											
Injection Hold Time	10.00										